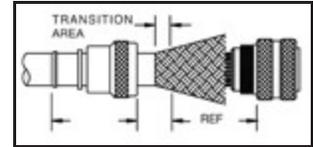
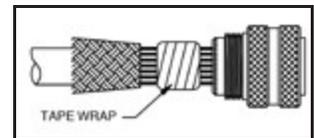


Careful measurement should be made prior to installing the backshell. The outer jacket is then uniformly removed at a distance which would allow the braid to make a comfortable transition onto the backshell termination area. This dimension will vary depending upon the differences between cable and backshell diameters or other application dependent factors.



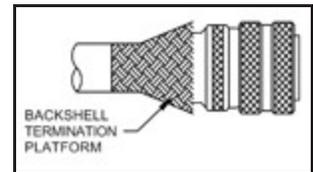
The braid is then trimmed to a length which will allow it to extend 1 inch past the backshell termination platform. Then the braid is carefully folded rearward to expose the wires which will be inside the backshell.

A sufficient number of wraps of self-vulcanizing tape (normally red in color) are applied over the wires to buildup a diameter slightly less than the inside diameter of the backshell. Care should be taken not to apply tension to the contacts located in the outer perimeter of the connector.



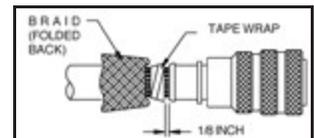
These layers of tape are followed by a minimum of one layer of Teflon tape which will prevent adhesion with the backshell and other components.

The backshell is then installed onto the connector, using a nonabrasive tool such as a strap wrench. The braid is then carefully moved from under the backshell. It is important to retain the woven characteristics of the braid during this step.



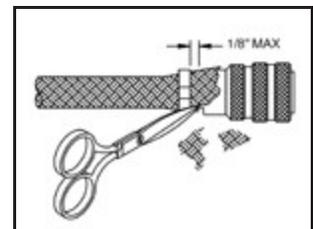
Use self vulcanizing tape or a preformed component to build up the area behind the backshell. It is important that the braid is supported in the transition from the backshell rear diameter to the natural diameter of the wire bundle. Leave approximately 1/8 inch spacing between the tape wrap and the backshell.

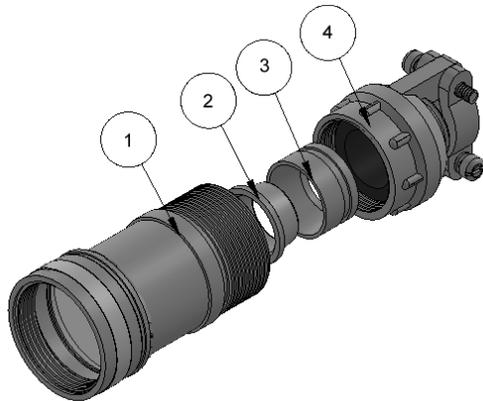
The braid is pushed into position over the backshell termination platform. Care must be taken to make sure the weave is uniform and no large "windows" are present. A shield termination band is then loaded into the tool. The band is then slid over the connector/backshell assembly into a position of alignment with the termination platform. Apply an adequate amount of pressure in line with the cable as it enters the backshell to allow the 1/8 inch space to be reduced to zero. The tool is then activated to the preset tension and the band terminated according to the individual tool's procedures.



For braided a non-jacket cable use fine point shears to trim the excess braid as close to the connector side of the bands as possible.

Do not leave any unsecured braid wires longer than 1/8 inch. Do not allow the trimmed wires to fall into any areas where they may present a foreign object damage hazard.



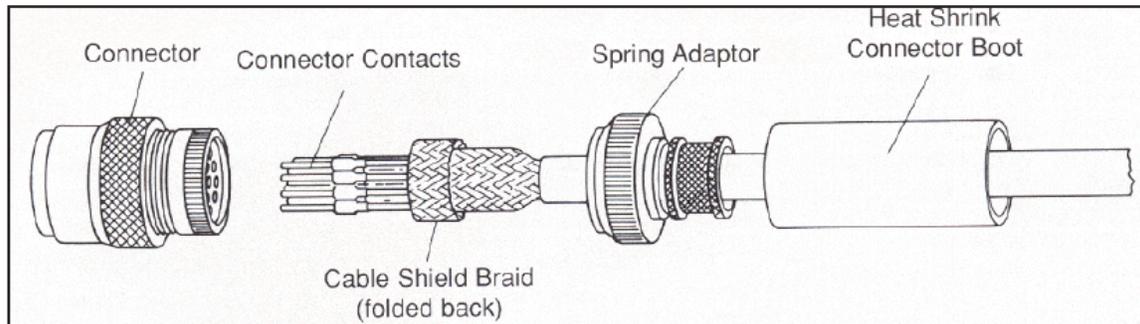


NOTES

1. Be sure to use the proper tools to ensure correct, reliable results
2. Assembly instructions are meant as an overall guide. Variations in cable type, connector series, braid style and other factors may require the steps below to be altered. It is suggested to use a trial sample to determine proper trim dimensions and identify assembly variations.

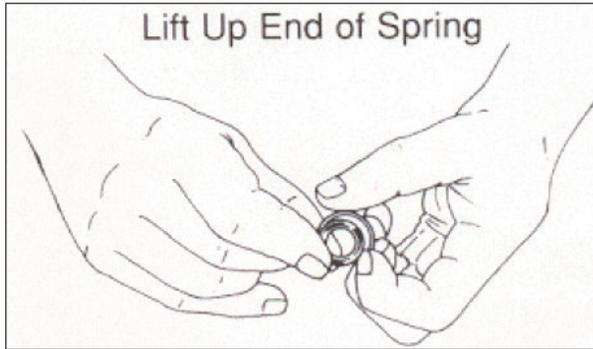
ASSEMBLY STEPS

- Step 1:** Assemble barrel (1) to connector.
- Step 2:** slide cable through barrel (1) and against rear accessory end of connector.
- Step 3:** Mark cable at rear end of barrel. if cable requires service loops or other factors requiring added length please compensate when marking cable in this step.
- Step 4:** Remove barrel (1) from connector and place entire backshell assembly (1-4) onto cable as pictured above. Verify that cable clamp (4) includes bushing and sleeve.
- Step 5:** Strip outer cable jacket and outer shield (braid) at marked point made in step 3.
- Step 6:** approximately 0.75" from strip point (step 5) remove just the outer cable jacket while leaving outer shield.
- Step 7:** Terminate and wire individual conductors onto connector.
- Step 8:** Assemble barrel (1) onto accessory threads of connector.
- Step 9:** Slide inner ferrule (2) into barrel (1).
- Step 10:** Carefully flare outer shield (braid) over inner ferrule (2).
- Step 11:** Encapsulate outer shield (braid) by sliding outer ferrule (3) into barrel (1) over inner ferrule (2).
- Step 12:** Tighten cable clamp (4) onto barrel (1) making sure that the bushing seals against the outer jacket of the cable.

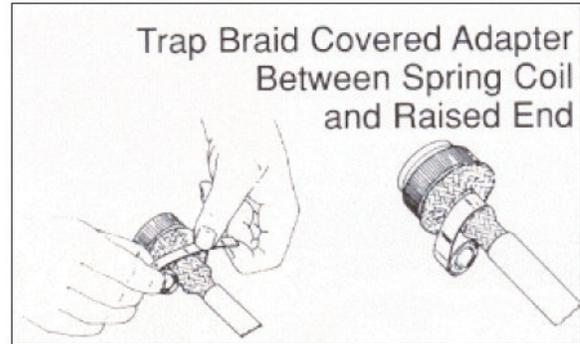


1. Prepare the cable making sure that a sufficient length of shield is available, so that it fits against the front shoulder of the lip groove.
2. Before insertion of connector contacts, slide the heat-shrinkable connector boot onto the cable followed by the Adaptor.
3. Position the heat shrinkable boot, Adaptor, and shield braid out of the way and insert the connector contacts. Depending upon the shielding braid size it can either be folded back onto itself or bunched up concertina style out of the way for easy access to the cable conductors.
4. Screw the Adaptor onto the connector and tighten to the torque value specified by the connector manufacturer. It is recommended that the connector threads are lubricated with a suitable compound if a liquid thread lock is not used. The adaptor should be hand tightened to ensure proper thread alignment and then tightened with a strap wrench and torque meter to the specified torque.
5. Bring the cable shield braid up onto the adaptor body so that it fits against the front shoulder of the lip groove Alternatively extend the braid past the lip groove.
6. **(FOR USE WITH CONSTANT FORCE SPRINGS)**
Open up the constant force spring and wrap it around the cable braid section that is positioned over the constant force spring slot area of the adaptor. This is most easily accomplished by lifting up the end of the spring and trapping the braid covered adaptor between the spring coil and raised end. The spring will now stay in place and can be installed by simply rolling the spring coil around the braid covered adaptor. Refer to appropriate code of practice for procedure to install heat shrink shape.
7. **(FOR USE WITH AS85049/128 TERMINATION BANDS)**
See Section J on "Installation Procedure for EMI/RFI Termination Bands"

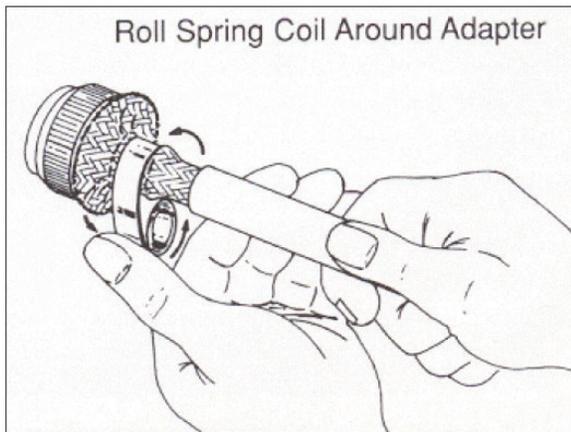
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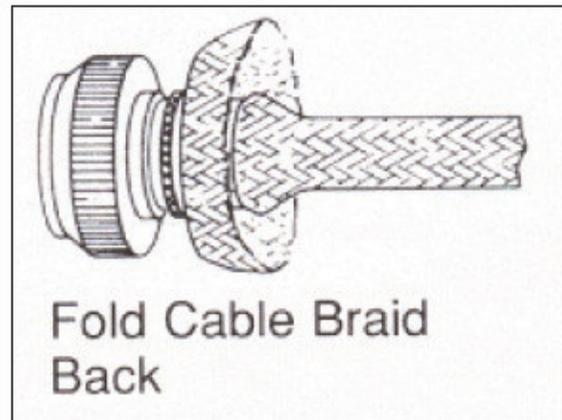
Step 1



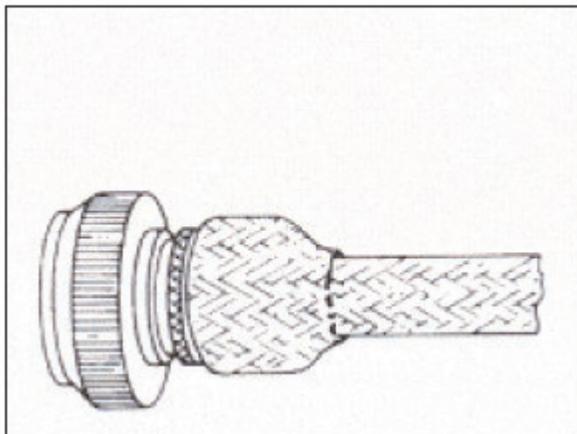
Step 2



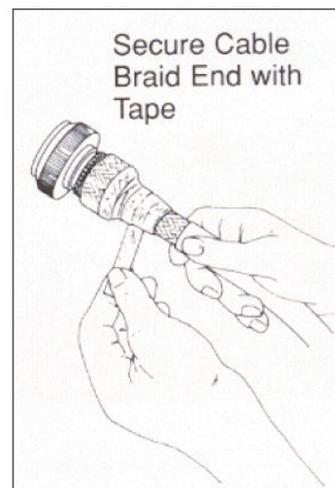
Step 3



Step 4



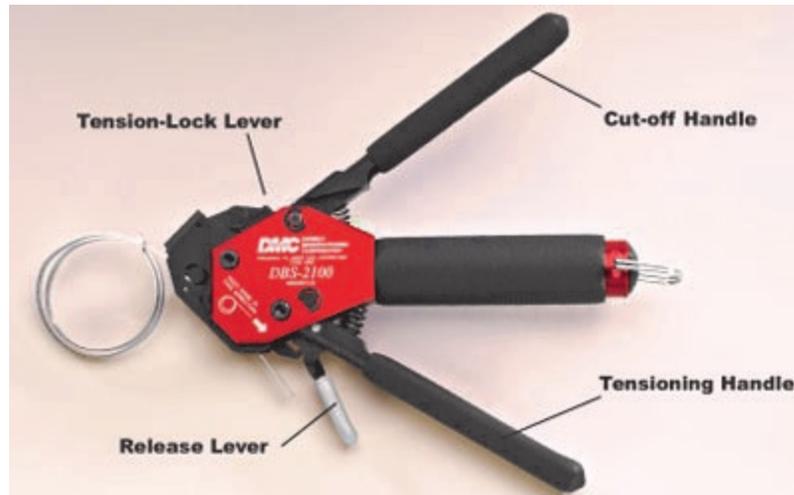
Step 5



Step 6

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STAMPED TERMINATION BANDS - ONE STEP METHOD



Step 1: Prepare the Connector and Cable Braid

Prepare the connector and cable braid for band termination process.

Step 2: Prepare Band

Using an appropriate size band, feed the end of the band through the narrow slot on the buckle twice. This will create a double-looped band. Never use a single-looped band. To hasten the termination process on smaller adapters, pull on the end of the band to reduce the diameter of the loop.

Step 3: Insert Looped Band into Tool

Squeeze the release lever and insert the end of the band into the nose of the tool. Ensure the orientation of the band matches the graphic on the body of the tool (coil down when the tool is held upright).

Step 4: Positioning

Position the connector and the shield assembly through the band.

Step 5: Tighten Band around Braid/Connector

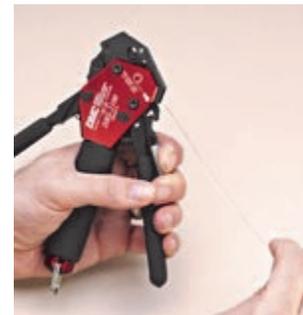
Repeatedly squeeze the tensioning handle until the band closes around the assembly. Once the band is close around the assembly, use half strokes of the handle until the band is tight against the braided cable. Release the tensioning handle and allow it to open fully. With one final stroke, close the tensioning handle until it locks against the tool body. This indicates that the band has been tightened to the pre-set tension.

Step 6: Cut Off

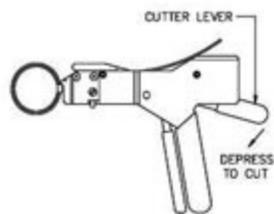
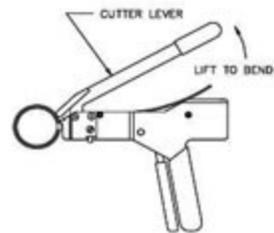
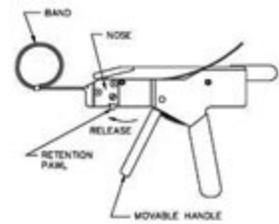
Once the tensioning handle is locked in place, squeeze the cut-off handle to finish the termination process. Both handles will open up on their own. (If shrinkable tubing is to be applied, it is recommended that the band is wrapped in tape and the excess braid folded back over the band to prevent cutting of shrinkable tubing.)

Step 7: Remove Excess Band Material

Release the tensioning handle and then squeeze the release lever. While squeezing the release lever, carefully pull on the band and slide it out of the tool and discard.



WELDED TERMINATION BANDS - TWO STEP METHOD



Step 1: Prepare the Connector and Cable Braid
Prepare the connector and cable braid for band termination process.

Step 2: Prepare Band
Using an appropriate size band, feed the end of the band through the narrow slot on the buckle twice. This will create a double-looped band. Never use a single-looped band. Pull on the end of the band to reduce the diameter of the loop.

Step 3: Insert Looped Band into Tool
Insert the band into the banding tool at least 1.75 inches, the band loop should be orientated on the upper side of the tool's nose. Actuate the movable tensioning handle of the tool one complete stroke to insure that the band has been captured by the gripping mechanism.

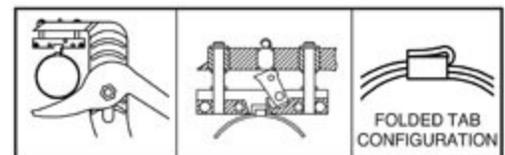
Step 4: Positioning
Position the connector and the shield assembly through the band.

Step 5: Tighten Band around Braid/Connector
Actuate the movable tensioning handle of the tool until the band is snug and tool resistance is felt, then release the movable handle and actuate the handle one full stroke thus locking the movable handle (locking occurs at the pre-set tension).

Step 6: Bend and Cut Band
To complete the termination, the band must be bent 90° by lifting the cutter lever upwards, and cut by depressing the cutter lever downwards.
Note: Sometimes the movable handle will open during the bend or cut operation. This is normal.

Step 7: Remove Excess Band Material
Remove excess band material from the tool by pulling out toward rear of tool.

Step 8: Roll Over Tab
The cutoff tab must be rolled over 180° in a manner which will prevent slippage Use the Tab Roll-Over Tool to perform the rollover. NOTE: Slippage may occur if rollover exceeds 180°



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