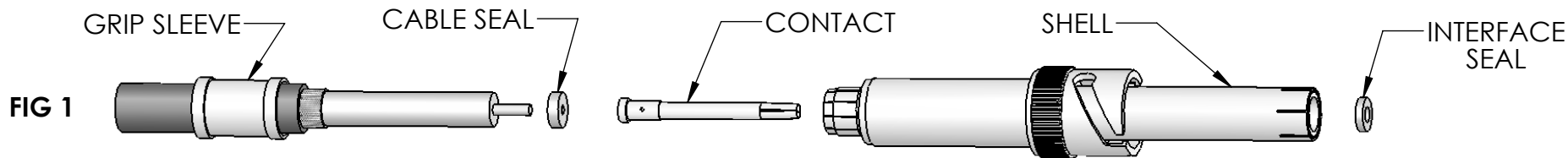
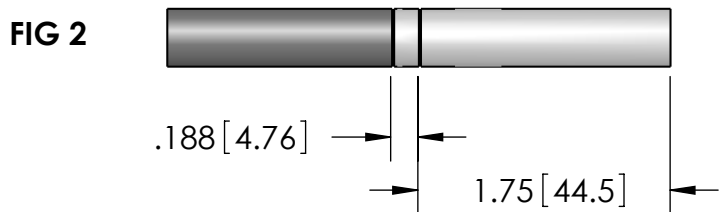


COAXIAL CABLE: RG213/U



PARTS NOMENCLATURE  
 NOTE DO NOT INTERCHANGE THE CABLE SEAL  $\phi$ .09 HOLE BY .10 THICK WITH  
 THE INTERFACE SEAL  $\phi$ .13 HOLE BY .06 THICK



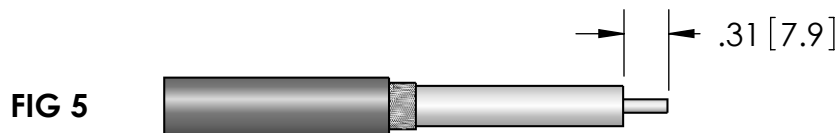
CUT CABLE END SQUARE  
 SLIDE THE GRIP SLEEVE OVER THE CABLE  
 AND MAKE CUTS IN JACKET AS SHOWN



REMOVE JACKET TO FIRST CUT  
 FLARE OUT BRAID AND TRIM WITH SCISSORS  
 AT EDGE OF JACKET



REMOVE JACKET TO SECOND CUT

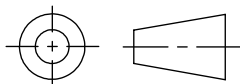


TRIM INNER DIELECTRIC AS SHOWN  
 THE INNER CONDUCTOR MUST NOT HAVE ANY  
 SEVERED STRANDS AND NO MORE THAN TWO  
 STRANDS NICKED DURING STRIPPING  
 60-40 TIN LEAD SOLDER THE EXPOSED CONDUCTOR

PROPRIETARY AND CONFIDENTIAL

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 REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN  
 PERMISSION OF SOLID SEALING TECHNOLOGY IS PROHIBITED.

THIRD ANGLE PROJECTION



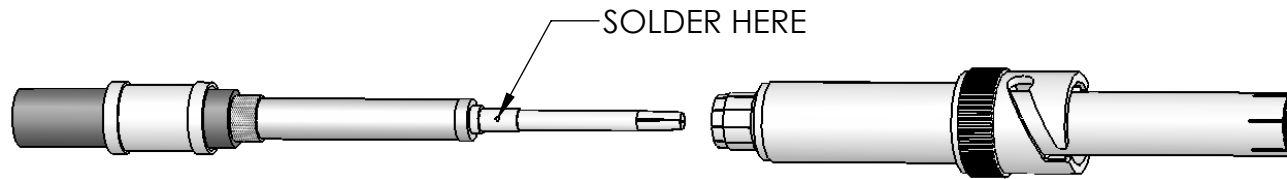
TITLE: INSTRUCTION SHEET  
 20KV SHV PLUG ASSEMBLY



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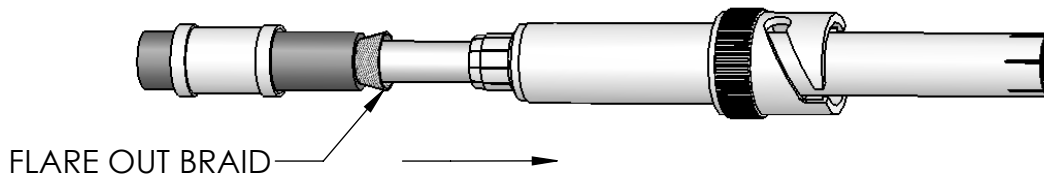
REV.	APP'D	DATE	SCALE 0.75:1	DIMENSIONS IN INCHES [mm]	DRAWN	MH	10/30/2007	NUMBER:	NS10549	REV:	B
B	MH	10/01/2008	NS10549-11		ENG APPR.	MH	10/31/2007				

FIG 6



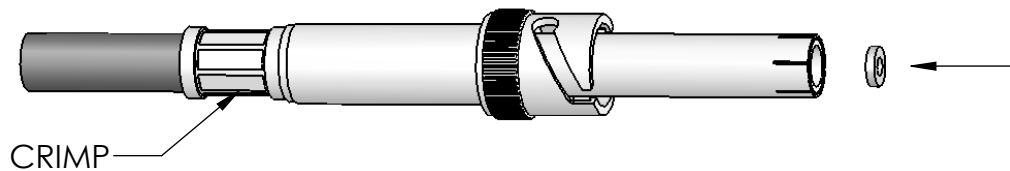
SLIDE CABLE SEAL AND CONTACT OVER CONDUCTOR. PUSH AGAINST CABLE SEAL WHILE SOLDERING CONTACT IN PLACE THROUGH SOLDER HOLE -DO NOT OVERHEAT-

FIG 7



FLARE OUT BRAID -DO NOT FRAY- SLIDE CABLE ASSEMBLY INTO SHELL, DO NOT PINCH OR OTHERWISE DAMAGE THE CABLE SEAL. GUIDE BRAID OVER SPLINED COLLAR ON SHELL UNTIL CONTACT SHOULDER BUTTS AGAINST SHELL INSULATOR.

FIG 8

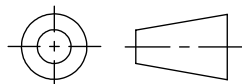


SLIDE GRIP SLEEVE INTO POSITION AND CRIMP. USE THOMAS & BETTS CRIMPING TOOL WT-540 AND DIE NUMBER 5452 OR KINGS CRIMPING TOOL #KTH-1000 AND CRIMP DIE #KTH-1078. ENSURE THAT BRAID DOES NOT EXTEND BEYOND GRIP SLEEVE. INSERT INTERFACE SEAL INTO THE SHELL UNTIL IT BOTTOMS EVENLY AROUND THE CONTACT.

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THIRD ANGLE PROJECTION



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20KV SHV PLUG ASSEMBLY



REV.	APP'D	DATE	SCALE 0.75:1	DIMENSIONS IN INCHES [mm]	DRAWN	MH	10/30/2007
B	MH	10/01/2008	NS10549-12		ENG APPR.	MH	10/31/2007

NUMBER:	NS10549
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REV:	B
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