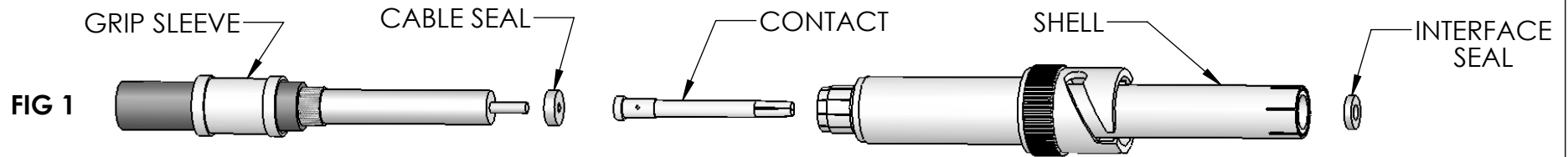
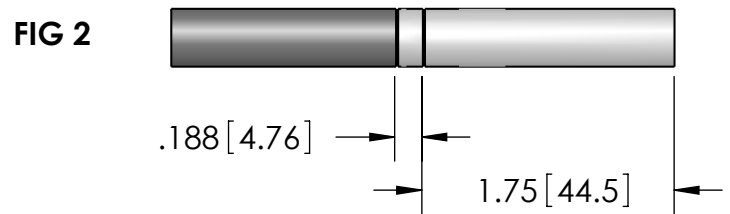


COAXIAL CABLE: RG213/U



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



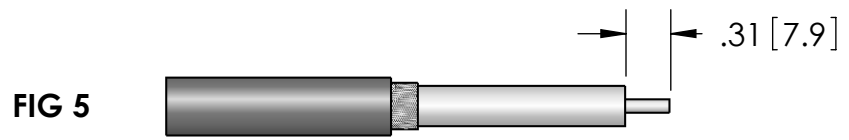
CUT CABLE END SQUARE
 SLIDE THE GRIP SLEEVE OVER THE CABLE
 AND MAKE CUTS IN JACKET AS SHOWN



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



REMOVE JACKET TO SECOND CUT

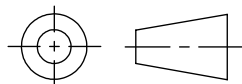


TRIM INNER DIELECTRIC AS SHOWN
 THE INNER CONDUCTOR MUST NOT HAVE ANY
 SEVERED STRANDS AND NO MORE THAN TWO
 STRANDS NICKED DURING STRIPPING
 60-40 TIN LEAD SOLDER THE EXPOSED CONDUCTOR

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THIRD ANGLE PROJECTION



TITLE: INSTRUCTION SHEET
 20KV SHV PLUG ASSEMBLY

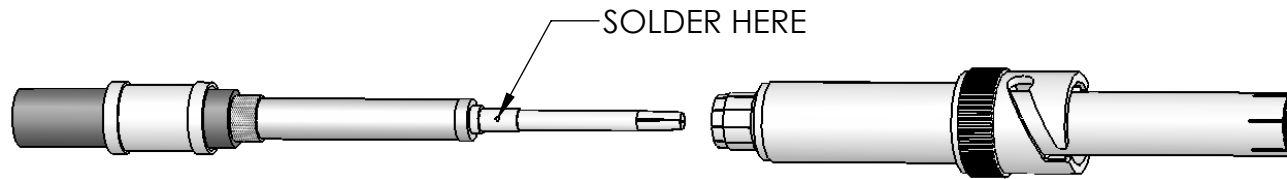


REV.	APP'D	DATE	SCALE 0.75:1	DIMENSIONS IN INCHES [mm]	DRAWN	MH	10/30/2007
B	MH	10/01/2008	NS10549-11		ENG APPR.	MH	10/31/2007

NUMBER:	NS10549	REV:	B
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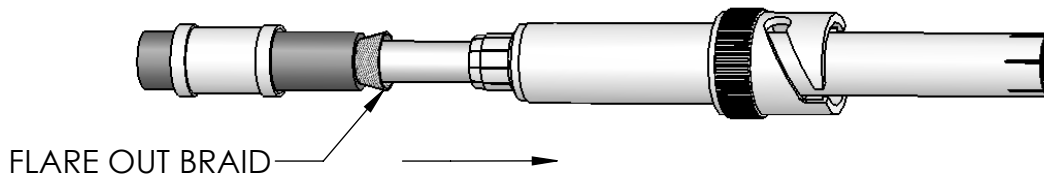
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 SHEET 1 OF 2

FIG 6



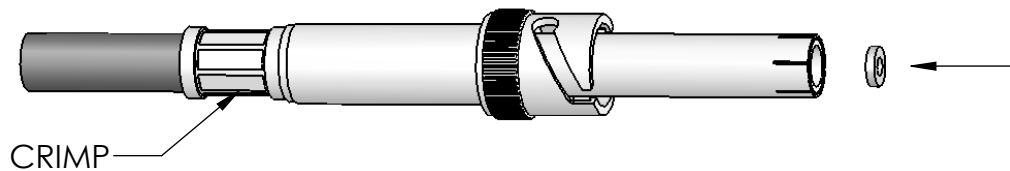
SLIDE CABLE SEAL AND CONTACT OVER CONDUCTOR.
 PUSH AGAINST CABLE SEAL WHILE SOLDERING CONTACT
 IN PLACE THROUGH SOLDER HOLE -DO NOT OVERHEAT-

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

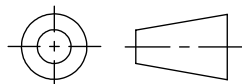


SLIDE GRIP SLEEVE INTO POSITION AND CRIMP.
 USE THOMAS & BETTS CRIMPING TOOL WT-540 AND DIE NUMBER 5452
 OR KINGS CRIMPING TOOL #KTH-1000 AND CRIMP DIE #KTH-1078.
 ENSURE THAT BRAID DOES NOT EXTEND BEYOND GRIP SLEEVE.
 INSERT INTERFACE SEAL INTO THE SHELL UNTIL IT BOTTOMS
 EVENLY AROUND THE CONTACT.

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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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