

PL-180 A

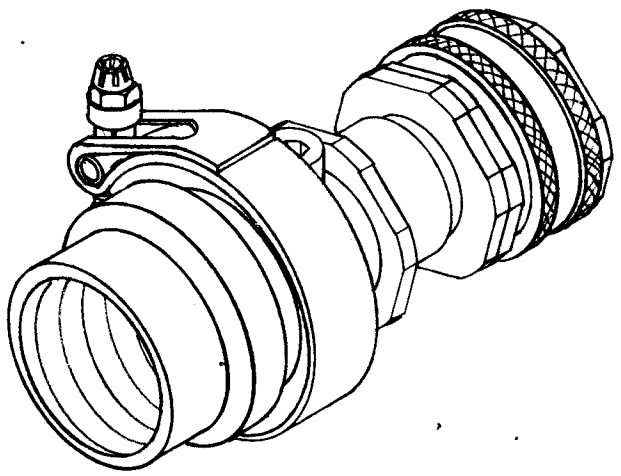
SPECIFICATIONS
 SERIES : QDL
 NO OF CONTACT : ONE (1)
 TYPE OF CONTACT : ROUND, MALE
 DIELECTRIC : TEFLON

ELECTRICAL DATA
 MAX. PEAK VOLTAGE :
 NOMINAL IMPEDANCE : 70 Ω

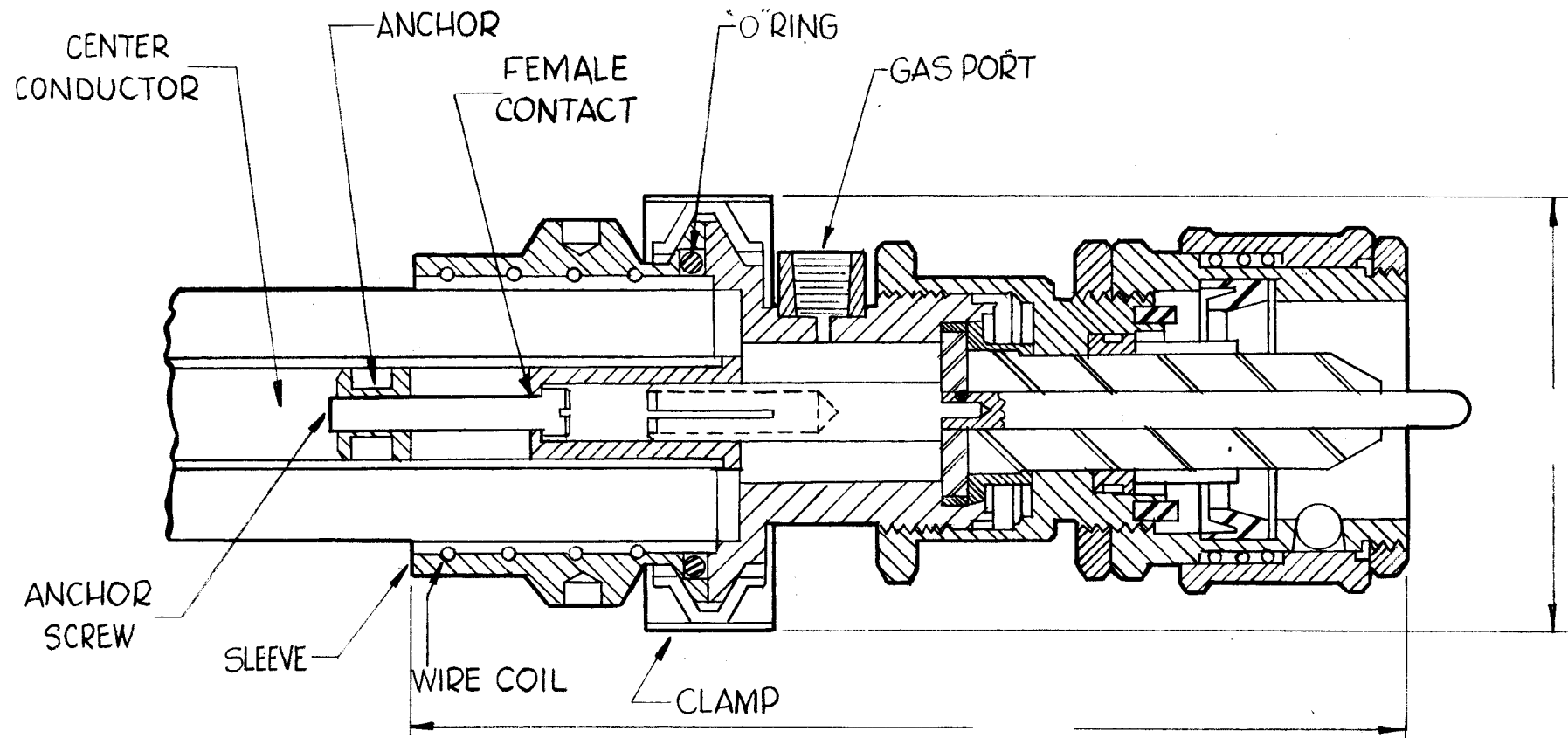
CABLE ACCOMODATIONS
 TYPE : STYROFLEX
 MAX. OD : 1-5/8
 IMPEDANCE : 70 Ω

MATERIAL
 EXTERNAL PARTS : BRASS
 CONTACT : BERYLLIUM COPPER
 INSULATION : LOW LOSS PLASTIC DIELECTRIC (TEFLON)
 CLAMP : STAINLESS STEEL

FINISH
 EXTERNAL PARTS : SILVER PLATE W/RHODIUM FLASH
 CONTACT : SILVER PLATE W/BOLD FLASH



- INSTALLATION INSTRUCTIONS**
- Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
 - Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
 - Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
 - Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
 - Saw off center conductor .061 from end of cable. Make saw cut carefully so that end of center conductor is straight and square, with cable axis. Remove inside and outside burrs from center conductor, being careful to keep chips out of cable.
 - Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
 - Separate sleeve from connector at clamp.
 - Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with TMC GL-117 anti-size compound. Use compounded sparingly wiping off any excess before starting sleeve on cable.
 - Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable extends beyond sleeve 1/32".
 - Grease sleeve "O" ring with "O" ring grease, TMC GL-118 No. 4 compound, and install in sleeve.
 - Reassemble connector with sleeve by mating center conductor and tightening clamp.



SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	REDRAWN W/DETAILS ADDED	5/3/61	#	DM	AO	alt
UNLESS OTHERWISE SPECIFIED:		SCALE: S-401-70 (9202)				
DIMENSIONS ARE IN INCHES		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°		QDL SERIES				

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
				5-2-61
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		CONNECTOR, PLUG, ELECTRICAL	
		SERIES QDL (70-Ω)	
		DRAWN	CHECKER
		PL-180	A