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This specification will describe the technique used for assembling the 165 series jacketed plugs and cable receptacles.

NOTE: Sheet 2 or equivalent is to be supplied as an instruction sheet with each connector shipped.

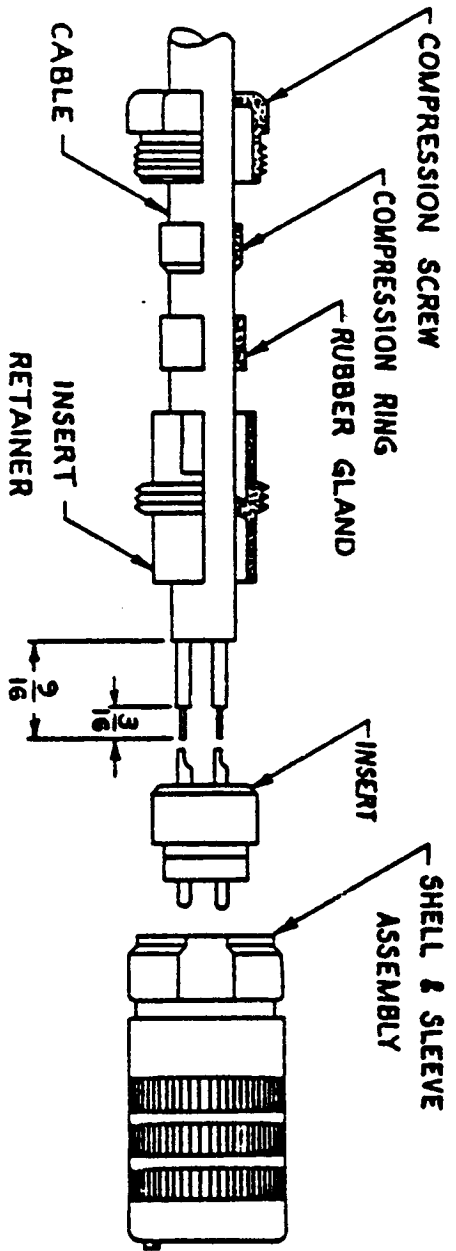
SHEET NO.	1	2
REVISION	A	A

REVISIONS		DATE	APPROVED
SYM	DESCRIPTION		
A	RELEASED TO PRODUCTION		

ITEM NO.	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION

DRAWN S.A. HILLER		DATE 6-27-83	AMPHENOL NORTH AMERICA CONNECTOR OPERATIONS BUNKER RAMO CORPORATION CICERO/BROADVIEW, ILLINOIS		
CHECKED T. RACHWALSKI		6-28-83			
APPROVED <i>[Signature]</i>		6-28-83			
EARS: AI-1545-165-909030					
ENGINEERING RELEASE					
INDUSTRIAL ENGRG APPD.			TITLE METHOD OF WIRING AND ASSEMBLY OF 165 SERIES PLUGS AND CABLE RECEPTACLES		
DESIGN ACTIVITY APPD.					
EXPERIMENTAL NO.					
DRAWING NO. 123-165-1826		SCALE	WT. EST.	ACT.	SHEET 1 OF 2
CODE IDENT NO. 02660		DWG SIZE A	REV. A		





WIRING TECHNIQUE:

Prepare the cable for assembly by stripping the outer cable jacket to expose 9/16" of insulated leads and inner conductor insulation to expose 3/16" of bare wire. The conductors can be tinned before they are soldered into the contact solder cups. This will permit easy entrance into the solder cups and will eliminate the possibility of loose strands.

1. Fill solder pockets with solder.
2. For easy soldering, start with the lowest and work toward the top.
3. Slip the compression screw, the compression ring, the rubber gland and then the insert retainer onto the cable in this order.
4. Slip wired insert assembly into the shell and sleeve assembly. Be sure to align keyway on the insert with the key in the shell.
5. Slide the rubber gland and compression ring into the insert retainer and shell assembly.
6. Slide the compression screw into place and tighten to affect a complete moisture seal.

DWG SIZE A	CODE IDENT NO. 29587	DRAWING NO. 123-165-1826	REV. A
SHEET 2 OF 2			