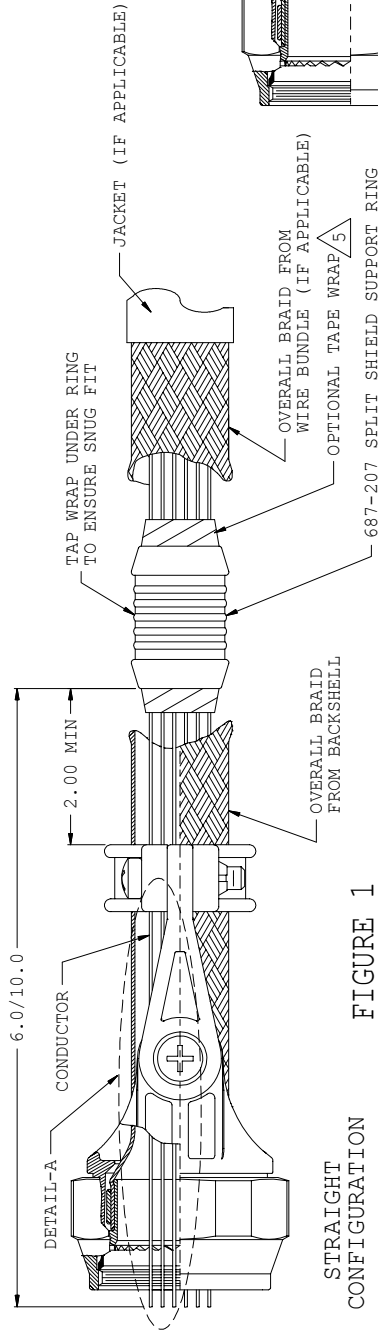


SYN	DESCRIPTION	DATE	APPROVED
2	PRELIMINARY	04/18/06	TMB



STRAIGHT CONFIGURATION  
FIGURE 1

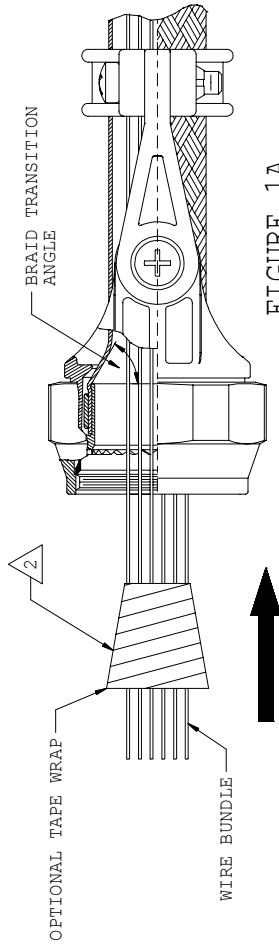
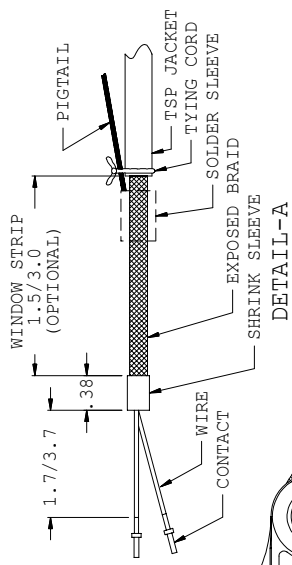


FIGURE 1A

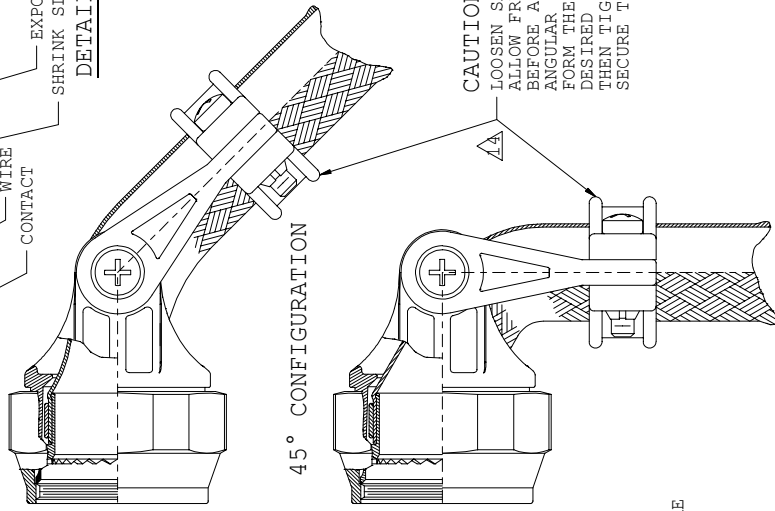
STEPS:

THE FOLLOWING SUGGESTED PROCEDURE IS A GUIDE FOR PROPER ASSEMBLY AND INSTALLATION OF GLENAIR'S 319 SERIES SWING ARM BRAID SOCK ADAPTERS. IT IS RECOMMENDED THAT TRIAL SAMPLES OF APPROPRIATE SHIELD WIRE BUNDLES BE USED TO DETERMINE PROPER TRIM DIMENSIONS OF THE CABLE JACKET (IF APPLICABLE), INDIVIDUAL SHIELDS AND CONDUCTORS.

1. ASSEMBLE SWING ARM CLAMP TO DESIRED CONFIGURATION TIGHTENING SCREWS TO LOCK ARMS IN PLACE (STRAIGHT, 45°, OR 90° CONFIGURATION) LEAVING SADDLE CLAMP HARDWARE LOOSE.
2. INSERT WIRE BUNDLE INTO BACKSHELL TO DETERMINE IF BRAID TRANSITION ANGLE FROM BACKSHELL TO WIRE BUNDLE IS LESS THAN 45°. IF THE TRANSITION IS LESS THAN 45° BUILD UP WIRE BUNDLE WITH TAPE AND RE-INSERT WIRE BUNDLE INTO BACKSHELL AS SHOWN (FIGURE 1A) TO SUPPORT THE TRANSITION OF OVERALL BRAID FROM BACKSHELL TO THE WIRE BUNDLE
3. TEMPORARILY ASSEMBLE ADAPTER TO CONNECTOR (NOT SHOWN) AND PUSH BACK BACKSHELL BRAID.
4. INSERT WIRE BUNDLE INTO ADAPTER AND BOTTOM AGAINST THE CONNECTOR. HOLD CABLE AND MARK OR TAG LOCATION WHERE SHIELD SUPPORT RING, GLENAIR P/N 687-207, WILL BE LOCATED. THIS DISTANCE MAY VARY UPON ACCEPTED TECHNIQUE OF USER AND FLEXIBILITY OF BUNDLE IMMEDIATELY REAR OF SADDLES. (FIGURE 1)
5. AT THE MARKED LOCATION, WHERE THE SHIELD SUPPORT RING IS LOCATED, WRAP TAPE AROUND WIRE BUNDLE FOR SNUG FIT OF SHIELD SUPPORT RING. (FIGURE 1) (OPTIONAL TAPE WRAP)
6. SLIDE OVERALL BRAID FROM WIRE BUNDLE SIDE OVER SHIELD SUPPORT RING. TRIM BRAID ENDS AND TUCK EXTRA LENGTH BRAID UNDERNEATH ITSELF, CREATING A CLEAN APPEARANCE. (SKIP STEP IF WIRE BUNDLE DOES NOT HAVE A OVERALL BRAID)
7. PIN CONNECTOR, SLIDE BACKSHELL FORWARD, AND HAND TIGHTEN BACKSHELL TO CONNECTOR.



DETAIL-A



CAUTION:

LOOSEN SADDLE CLAMPS TO ALLOW FREE CABLE MOVEMENT BEFORE ADJUSTING CLAMP TO ANGULAR POSITIONS. FORM THE CABLE INTO THE DESIRED CONFIGURATION, THEN TIGHTEN ARMS AND SECURE THE SADDLE CLAMPS.

90° CONFIGURATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN K. BAILEY 03/16/05	CHKD 1910° 03/16/05
TOLERANCES:	CHECK J. PLESSAS 03/16/05	1211 AIR WAY - GLENDALE - CALIFORNIA 91201
FRACTIONS XX ±.03	ENGR J. PLESSAS 03/16/05	
DECIMALS .XX ±.015		
ANGLES ±.2°		
DO NOT SCALE THIS DRAWING	SCALE: N/A	HEIGHT: N/A
BY: 05-5388 P/C GWP	DATE: N/A	REV: 1 OF 3

**GLENAIR, INC.**

319 SERIES SWING ARM CLAMP  
SHIELD SOCK TERMINATION  
PROCEDURE

CODE: 1910°  
06324 D  
GAP-027  
SCALE: N/A  
HEIGHT: N/A  
REV: 1 OF 3

REVISIONS	
SYN.	DESCRIPTION
SEE SHEET 1	DATE APPROVED

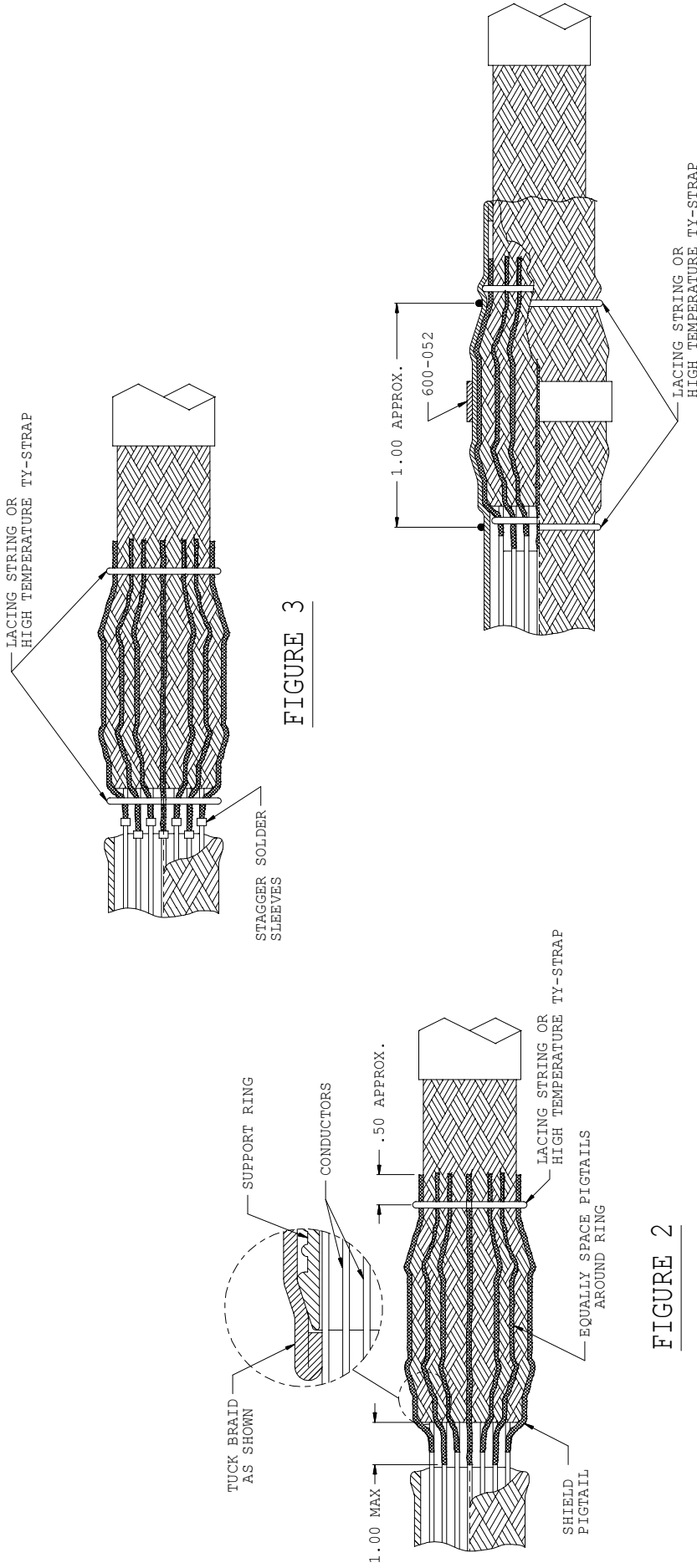


FIGURE 3

FIGURE 2

STEPS: CONT'D

8. EVENLY SPACE SHIELD PIGTAILS (FIGURE 2) OR SOLDER SLEEVE PIGTAILS (FIGURE 3) AROUND SHIELD SUPPORT RING. CUT PIGTAILS SO THAT END OF PIGTAILS ARE APPROXIMATELY .50 BEYOND END OF SHIELD SUPPORT RING.
9. BRING SHIELD SOCK FROM BACKSHELL AND COMPLETELY COVER PIGTAILS AND SUPPORT RING. TRIM AND FOLD BRAID AS SHOWN IN FIGURE 4. LACE TIE SHIELD ADJACENT TO SUPPORT RING ENDS.
10. INSTALL BAND, 600-052, PER GLENNAIR'S BAND-IT TERMINATION PROCESS BETWEEN THE LACE TIES ONTO THE CENTER OF THE SUPPORT RING, AS SHOWN (FIGURE 4). HAND BANDING TOOL, 600-058, OR PNEUMATIC BANDING TOOL, 600-067, REQUIRED FOR BANDING PROCESS.
11. WRAP SHIELD SUPPORT RING ASSEMBLY WITH HIGH TEMPERATURE TAPE, USING 50% OVERLAP (NOT SHOWN).

FIGURE 4

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN	K. BAILEY	03/16/05	GLENNAIR, INC. 1211 AIR WAY - GLENDALE - CALIFORNIA 91201
	CHECKED	J. PLESSAS	03/16/05	
TOLERANCES:				
FRACTIONS	± 1/16			
DECIMALS	.XX ±.03			
ANGLES	±.015			
DO NOT SCALE THIS DRAWING				
SHEET NO.	06324	D	GAP-027	SHEET 2 OF 3

SYNOPSIS		REVISIONS	
DESCRIPTION	DATE	DESCRIPTION	DATE
SEE SHEET 1			

TABLE I

CONNECTOR SHELL SIZE REF	COUPLING RING INSTALLATION TORQUE (IN LB) $\triangle 13$	HEX COUPLING TORQUE WRENCH $\triangle 13$	SADDLE SCREW SIZE	SADDLE SCREW INSTALLATION TORQUE (IN LB) $\triangle 14$	ARM SCREW SIZE	ARM SCREW INSTALLATION TORQUE (IN LB) $\triangle 14$
08, 09, A	35	600-091-08	4	4	4	4
10, 11, B	40	600-091-10	4	4	4	4
12, 13, C	40	600-091-12	6	6	6	6
14, 15, D	40	600-091-14	6	6	6	6
16, 17, E	40	600-091-16	6	6	6	6
18, 19, F	40	600-091-18	6	6	6	6
20, 21, G	80	600-091-20	6	6	6	6
22, 23, H	80	600-091-22	6	6	6	6
24, 25, J	80	600-091-24	6	6	6	6
28	120	600-091-28	6	6	-	-
32	120	600-091-32	10	10	-	-
36	120	600-091-36	10	10	-	-

LACING STRING OR HIGH TEMPERATURE TY-STRAPS APPLIED IN 1.00 INCH INCREMENTS OPTIONAL (LACING MUST BE PLACED OVER WINDOW STRIP AREA)

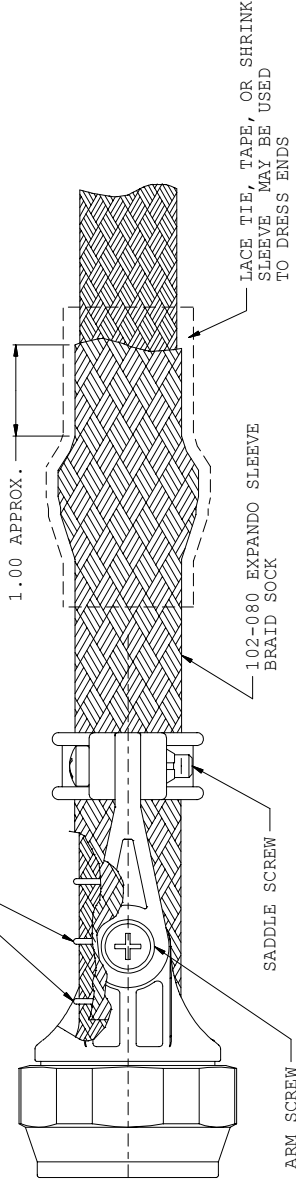


FIGURE 5

STEPS: CONT'D

12. PLACE LACING CORD, HIGH TEMPERATURE TAPE, OR HIGH TEMPERATURE PLASTIC TY-STRAPS IN 1.00 INCREMENTS STARTING AT THE BRAID TRANSITION REAR OF THE BACKSHELL TO SECURE OVER BRAID ON WIRE BUNDLE. COVER OVER BRAID WITH 102-080 BRAID SOCK EXTENDING APPROXIMATELY 1.00 INCHES PAST SHIELD SUPPORT RING. (FIGURE 5) OPTIONAL

13. SECURELY TIGHTEN ADAPTER TO CONNECTOR USING GLENAIR 600-091 COMPOSITE HEX COUPLING TORQUE WRENCH AND OTHER TOOLING ACCESSORIES TO ESTABLISHED TORQUE VALUES. (SEE TABLE I)

14. SECURE THE STRAIN RELIEF SADDLE ONTO THE WIRE BUNDLE USING TC69 SOFT JAW PLIERS TO FIRMLY HOLD SADDLES DOWN EVENLY ONTO WIRE BUNDLE. TORQUE SCREWS TO VALUES SHOWN IN TABLE I.

SUGGEST USING TEFLON TAPE WRAP OR M85049/127 BUSHING STRIP, AS NEEDED, TO CUSHION BRAID SOCK UNDER THE SADDLE CLAMPS.

15. SEE GLENAIR DRAWING 687-654, 687-655 & 687-656 FOR SADDLE BAR REPLACEMENT PARTS.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN K. BAILEY	03/16/05	REV 1910
TOLERANCES:	CHECK J. PLESSAS	03/16/05	<b>GLENAIR, INC.</b>
FRACTIONS ± 1/16	ENGR J. PLESSAS	03/16/05	1211 AIR WAY - GLENDALE - CALIFORNIA 91201
DECIMALS ± .03	APPROVED: <i>R. Plessas</i>		319 SERIES SWING ARM CLAMP
ANGLES ± .5°	DATE: 03/16/05		SHIELD SOCK TERMINATION
DO NOT SCALE THIS DRAWING	SCALE: N/A	HEIGHT: N/A	PROCEDURE
BY: 05-5368 P/C GRP	06324 D	GAP-027	SHEET 3 OF 3