



Cable Preparation and Assembly Instructions

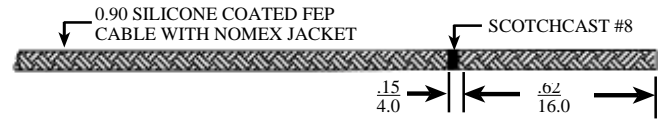
Series: 730/830 737 With Silicone Coated FEP Cable & Nomex Jacket

Series 730 Plugs (P/N 167-9151) Series 737 Plugs (P/N 167-8816) Series 830 Plugs (167-8810)

Note: These procedures allow .090 Dia. silicone coated FEP wire, P/N 178-8315 to be substituted for Nomex covered wire simply by ignoring all procedural references to 3M Scotchcast™ or Nomex in **Steps 1 and 2.**

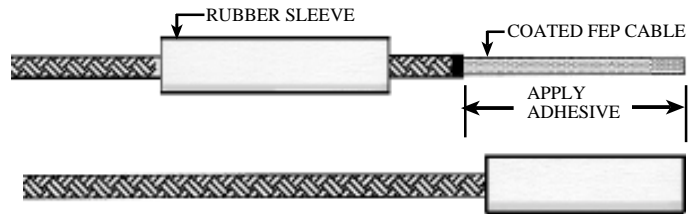
Step 1

Cut cable to length, clean and square. Apply 3M Scotchcast™ as shown. Cure for 1 hour @ 195°F (90°C).



Step 2

Trim Nomex back to cured Scotchcast as shown. Install rubber sleeve for buildup. Apply a thin film of General Electric RTV 162 adhesive over the entire surface of the FEP coated wire. Slide the rubber sleeve forward until it is flush with the end of the FEP coated wire. Wipe off any excess adhesive with isopropyl alcohol. Cure in a humidity oven with 60% relative humidity @ 100°F (38°C) for 24 hours or at room temperature for 48 hours.



Step 3

Strip the rubber sleeve and FEP cable insulation to the dimension shown. No nicked or severed strands allowed. Hot tin dip. Remove all flux.



Step 4

Rosin flux conductor and solder contact through the feed hole using SN60 solder in accordance with J-STD-006. Completed solder joint must have a continuous fillet of solder between the cable conductor and the contact. Solder in the feedhole must be free of pinholes and flush or below flush. Rear of contact must be as flush as possible with rubber sleeve.



Step 5

Lightly abraid *only* the areas indicated using air blast abrasive sand or new abrasive cloth.



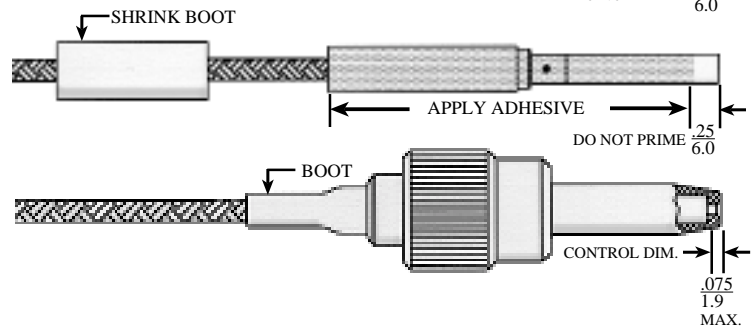
Step 6

Apply a thin coat of General Electric SS 4004 primer on the surfaces indicated. Allow primer to dry for 1 hour at room temperature.



Step 7

Brush a thin layer of General Electric RTV 162 adhesive over the indicated area. Immediately insert the contact with cable into the connector insulator. Rotation of the contact is permitted during insertion. Apply enough pressure to displace air at the interface. Make sure the contact shoulder butts against the insulator shoulder and that the 0.75 inch control dimension is maintained. Cure in a humidity oven with 60% relative humidity @ 100°F (38°C) for 24 hours. After curing, slide boot into place and shrink.



Step 8

Applies to Series 830 plugs only. Slide the metal coupling nut over the body/insulator and install the "C" retaining ring.