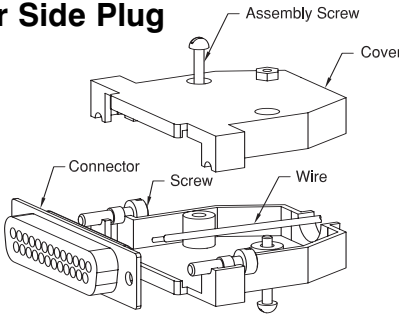


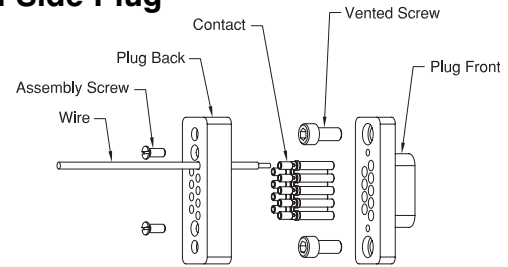
SUB D MIL-C-24308 TYPE

Air Side Plug



Solder wires to solder cup contacts. Insert connector between 2-piece housing. Assemble with included screws and nuts.

Vacuum Side Plug

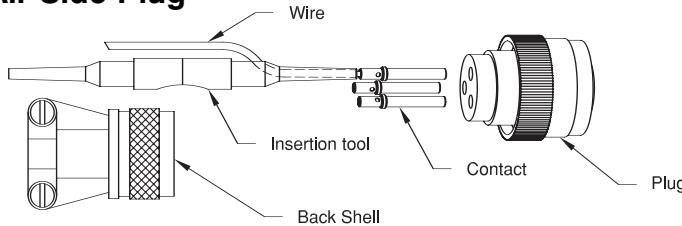


Feed wiring through plug back prior to crimping. Crimp wire to contact. Use crimp tool #2840-05. Insert two 4-40 vented socket head cap screws into counterbores in plug front. Insert contacts into holes in plug front. Align plug back with plug front. Insert assembly screws and tighten.

CIRCULAR MIL-C-26482 TYPE (200°C Max.)

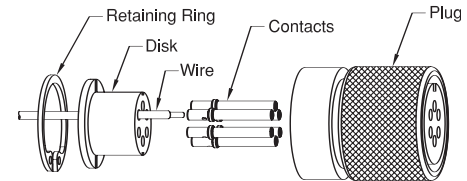
Circular Multipin and Thermocouple

Air Side Plug



Crimp wire to contact and insert through back shell. Place wire / contact on end of insertion tool. Starting at center of plug insert contact / wire.

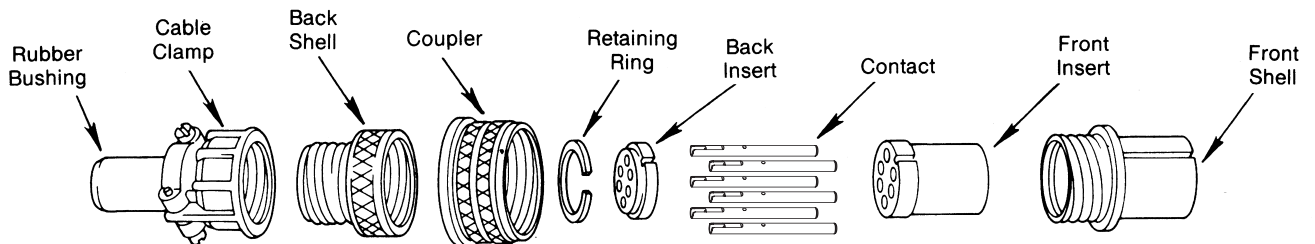
Vacuum Side Plug



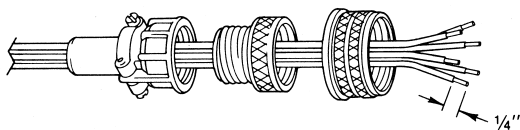
Insert wires through disk and crimp to contacts. Use crimp tool #2840-05. After crimping seat contacts on disk. Align contacts with holes in plug and insert. Insert retaining ring into back of plug to secure disk in place.

CIRCULAR MIL-C-5015 TYPE (125°C Max.)

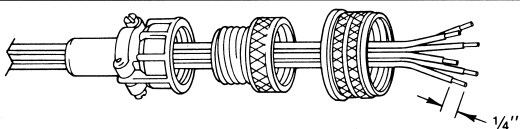
Instrumentation



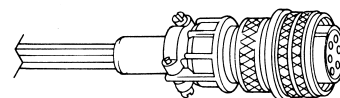
Note: Assembly instructions for the 4, 6, 10, 20 and 35 conductor and extended range plugs are identical.



STEP 1 . . . Slide the cable clamp, rubber bushing, back shell and coupler over the cable. Strip the ends of the wires to the dimension shown.



STEP 2 . . . Insert the proper wires into the contacts within the front shell and solder in place with the 60-40 rosin core solder. Snap ring and rear insulator can be removed, which would allow contacts to be more easily soldered.



STEP 3 . . . Slide the coupler over the front shell, then thread the back shell onto the front shell and tighten. Slide the rubber bushing inside the cable clamp. Thread the cable clamp onto the back shell and tighten. Moderately tighten the clamp on the cable.