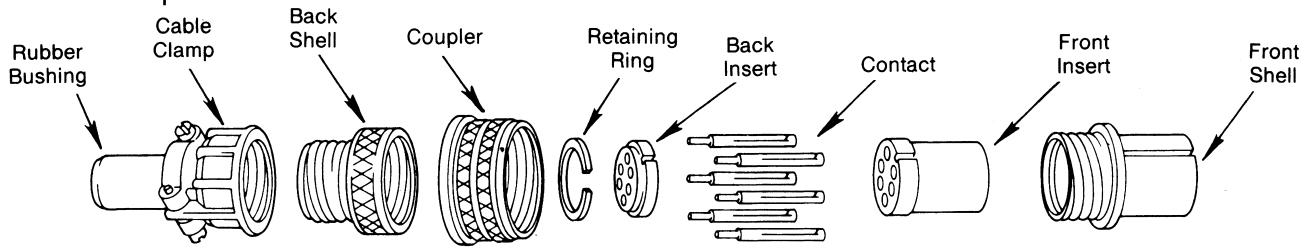
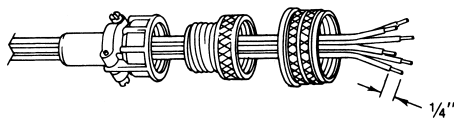


CIRCULAR MIL-C-5015 TYPE (125°C Max.)

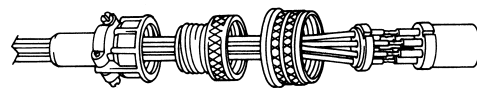
Thermocouple



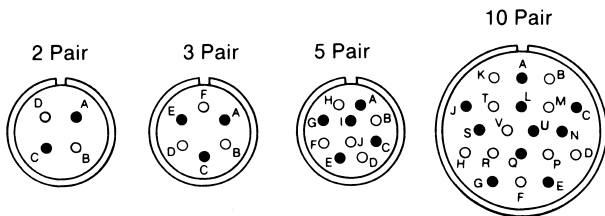
Note: Assembly instructions for the 2, 3, 5, and 10 pair thermocouple and extended range plugs are identical.



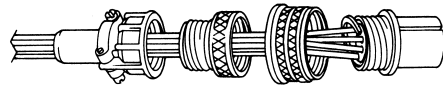
STEP 1 . . . Slide the cable clamp, rubber bushing, back shell and coupler over the cable. Strip the ends of the wires to the dimension shown.



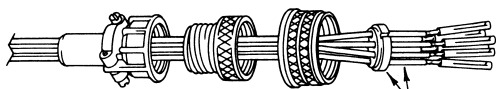
STEP 3 . . . Insert the contacts into the correct holes of the front insert. Notice that the alignment slots are in line upon assembly.



THERMOCOUPLE LEAD IDENTIFICATION
Darkened circles indicate placement of the positive (+) thermocouple leads and the empty circles indicate placement of the negative (-) thermocouple leads.

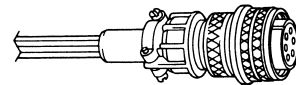


STEP 4 . . . Slide the front and back inserts together and insert them into the front shell. Secure them in place with the retaining ring.



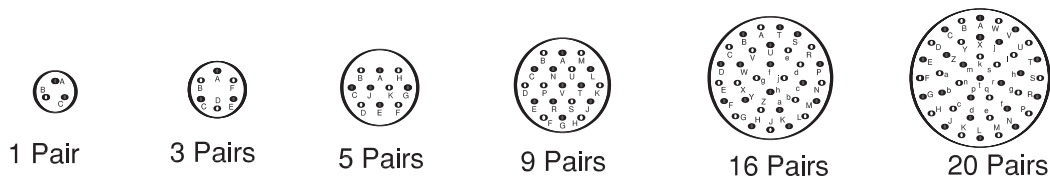
See Lead Orientation Charts Above

STEP 2 . . . Insert the proper thermocouple material into the properly identified holes in the back insert. Slide the proper contact on its corresponding conductor and crimp in place as shown.



STEP 5 . . . 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.

Thermocouple Header Pin Orientation



Darkened circles indicate placement of the positive (+) thermocouple leads and the empty circles indicate negative (-) thermocouple leads when viewed from the vacuum side.

TECHNICAL REFERENCE