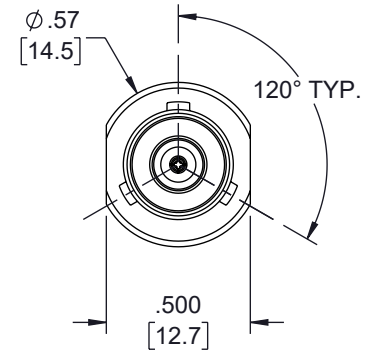
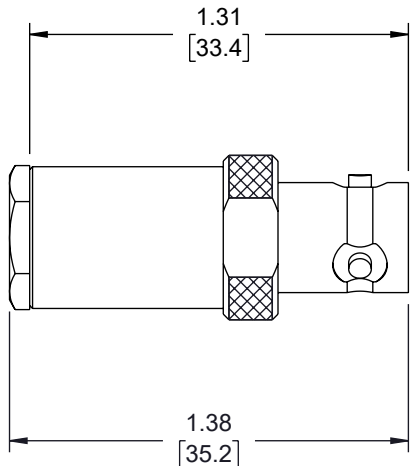
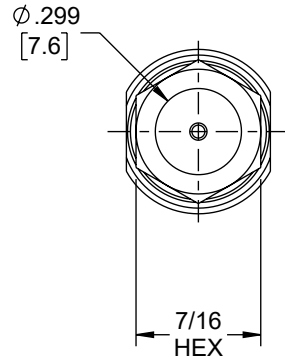


6 5 4 3 2 1



UNLESS OTHERWISE SPECIFIED  
LEADING DIMENSIONS ARE INCHES  
DIMENSIONS IN [ ] ARE MILLIMETERS


TOLERANCES:

X = ±.2 [5]	FRACTIONS ± 1/32
XX = ±.02 [0.5]	ANGLES ± 1°
XXX = ±.005 [0.13]	


CABLE LENGTH TOLERANCES:

≤12 [305]	= +1 [25] / -0
>12 [305] ≤60 [1524]	= +2 [51] / -0
>60 [1524] ≤120 [3048]	= +4 [102] / -0
>120 [3048] ≤300 [7620]	= +6 [152] / -0
>300 [7620]	= +5% / -0

ALL DIMENSIONS ARE FOR REFERENCE ONLY  
AND SUBJECT TO CHANGE WITHOUT NOTICE  
UN-DIMENSIONED NON-CRITICAL FEATURES  
MAY VARY IN SIZE AND LOCATION  
COLORS MAY VARY

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INTERPRET ALL DIMENSIONS AND  
TOLERANCES PER ASME Y14.5

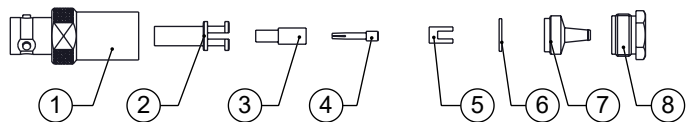
SCALE: NONE  
SHEET: 1 OF 2

DESCRIPTION  
**78 OHM TRB 3-LUG JACK 1553 CONNECTOR CLAMP/SOLDER  
ATTACHMENT FOR FMBC-30-02001, TWC-78-2**

SIZE A	CAGE CODE 3FKR5	DRAWN BY SREITER	ITEM NO. FMCN10-06575-210	REV B
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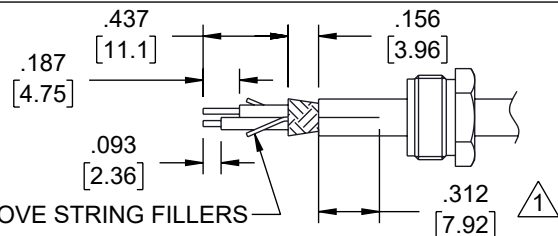
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## ASSEMBLY INSTRUCTIONS



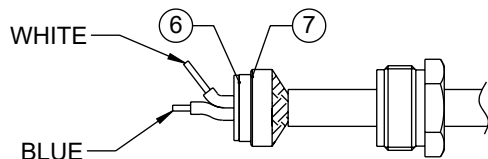
- |                 |                     |
|-----------------|---------------------|
| ① BODY ASSEMBLY | ⑤ NOTCHED INSERT    |
| ② INNER SHIELD  | ⑥ INSULATING WASHER |
| ③ DIELECTRIC    | ⑦ CONE              |
| ④ CONTACT       | ⑧ CLAMP NUT         |

### STEP 1



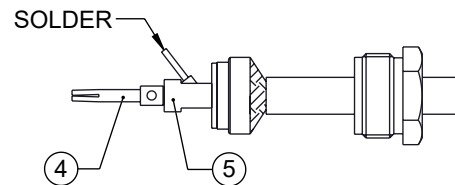
1. PLACE ⑧ ONTO CABLE.
2. STRIP CABLE AS SHOWN AND FLARE BRAID TO ALLOW FREE ENTER OF ⑦. (① LATERAL SLITS 180° APART MAY BE REQUIRED FOR INFLEXIBLE JACKET MATERIALS).
3. LIGHTLY TIN CENTER CONDUCTOR.

### STEP 2



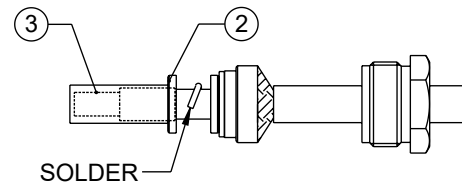
1. PUSH ⑦ UNDER BRAID UNTIL BRAID IS FLUSH WITH EDGE OF ⑦.
2. INSTALL ⑥ OVER CONDUCTORS AND SEAT AGAINST ⑦.
3. BEND LONGER BARED CONDUCTOR AT RIGHT ANGLE AND POSITION OTHER CONDUCTOR TO CENTER OF CABLE.

### STEP 3



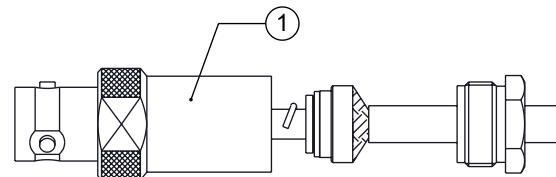
1. PLACE ⑤ OVER CONDUCTORS WITH CENTER CONDUCTOR THRU CENTER HOLE AND OTHER CONDUCTOR THRU SIDE SLOT UNTIL SEATED AGAINST ⑥ OR ⑦.
2. INSTALL ④ OVER CENTER CONDUCTOR. SEAT AGAINST ⑤ AND SOLDER IN PLACE.

### STEP 4



1. PLACE ③ OVER ④ UNTIL BOTTOMED.
2. INSTALL ② OVER ③ & ⑤ WITH CONDUCTOR THRU SIDE SLOT UNTIL BOTTOMED.
3. WRAP CONDUCTOR BETWEEN ② RIDGES AND SOLDER. BEING CAREFUL NOT TO ALLOW SOLDER OR CONDUCTOR TO EXTEND ABOVE ② RIDGES.

### STEP 5



1. BRING ⑧ UP ONTO TAPERED PORTION OF CABLE.
2. ASSEMBLE ① OVER ENTIRE ASSY AND ENGAGE WITH ⑧.
3. WRENCH TIGHTEN TO 25-35 IN LBS TORQUE.



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INTERPRET ALL DIMENSIONS AND TOLERANCES PER ASME Y14.5

SCALE  
NONE

SHEET  
2 OF 2

#### DESCRIPTION

78 OHM TRB 3-LUG JACK 1553 CONNECTOR CLAMP/SOLDER  
ATTACHMENT FOR FMBC-30-02001, TWC-78-2

SIZE	CAGE CODE	DRAWN BY	ITEM NO.	REV
A	3FKR5	SREITER	FMCN10-06575-210	B

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