

REVISIONS	
SYN.	DESCRIPTION
SEE SHEET 1	DATE APPROVED

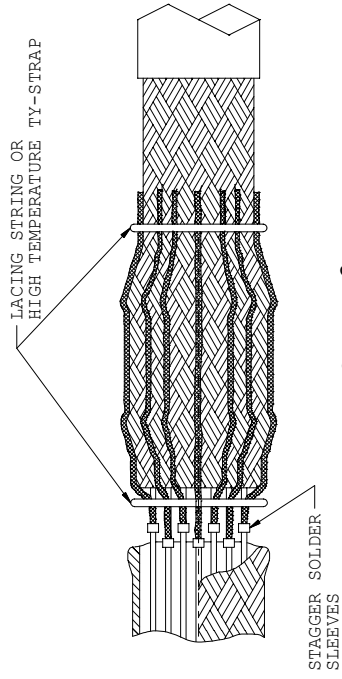


FIGURE 3

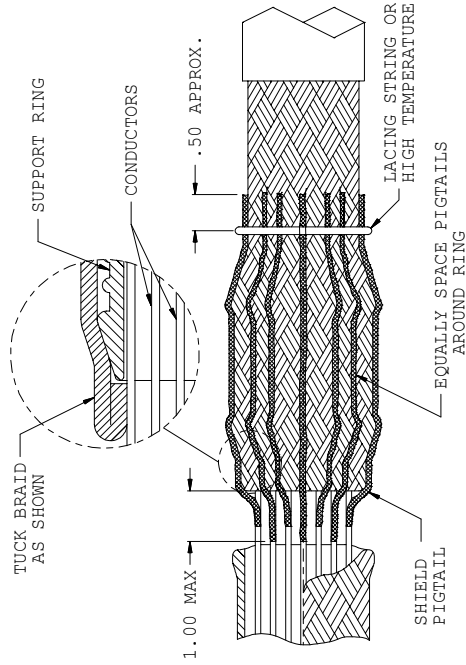


FIGURE 2

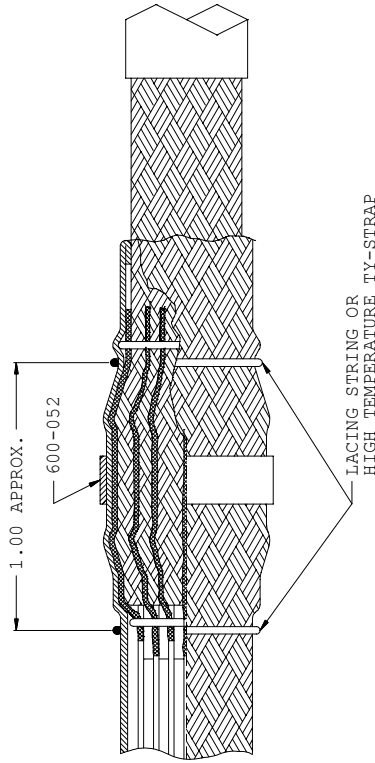


FIGURE 4

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 GLENAIR'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).

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN K. BAILEY 03/16/05	DATE 03/16/05	REV. 1910
TOLERANCES:	CHECK J. PLESSAS 03/16/05	DATE 03/16/05	1211 AIR WAY - GLENDALE - CALIFORNIA 91201
FRACTIONS $\pm 1/16$	ENGR J. PLESSAS 03/16/05		GLENAIR, INC.
DECIMALS $\pm .03$			319 SERIES SWING ARM CLAMP
ANGLES $\pm .015$			SHIELD SOCK TERMINATION
DO NOT SCALE THIS DRAWING	APPROVED: <i>R. Plessas</i>		PROCEDURE
BY: 05-5368 P/C GRP	SCALE: N/A	HEIGHT: N/A	CODE: 06324 D
DATE: N/A	SCALE: N/A	HEIGHT: N/A	FIG. GAP-027
ISSUE: N/A	SCALE: N/A	HEIGHT: N/A	SHEET 2 OF 3

REVISIONS	
SYN	DESCRIPTION
SEE SHEET 1	DATE APPROVED

TABLE I

CONNECTOR SHELL SIZE REF	COUPLING RING INSTALLATION TORQUE (IN LB) 13	HEX COUPLING TORQUE WRENCH 13	SADDLE SCREW SIZE	SADDLE SCREW INSTALLATION TORQUE (IN LB) 14	ARM SCREW SIZE	ARM SCREW INSTALLATION TORQUE (IN LB) 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)

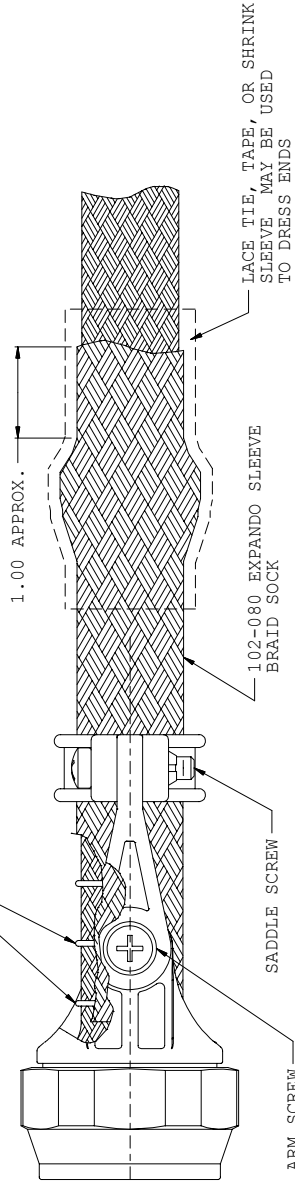


FIGURE 5

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	DATE 03/16/05	ORD 1910
TOLERANCES:	CHECK J. PLESSAS 03/16/05	DATE 03/16/05	GLENAIR, INC.
FRACTIONS ± 1/16	ENGR J. PLESSAS 03/16/05		1211 AIR WAY - GLENDALE - CALIFORNIA 91201
DECIMALS .XX ± 0.3			
ANGLES ± .2°			
DO NOT SCALE THIS DRAWING	APPROVED: <i>R. Plessas</i>		
BY: 05-5368 P/C GRP	SCALE: N/A	HEIGHT: N/A	SHEET 3 OF 3
	319 SERIES SWING ARM CLAMP SHIELD SOCK TERMINATION PROCEDURE		
	CODE: 06324 D		