



**NOTE:**

- ① TRIM FOIL SHIELD FLUSH WITH CABLE JACKET, TYP BOTH ENDS. TRIM SHIELD, DRAIN WIRE FLUSH WITH CABLE JACKET ON CONNECTOR END ONLY
- ② STRIP CABLE JACKET AND LEAD INSULATION AS SHOWN, TWIST & TIN LEADS & SHIELD DRAIN WIRE
- ③ ASSEMBLE PER WI1171, AS APPLICABLE
- ④ PRINT ASSY PART NO "230489.0X3" ON LABEL IN WHITE COATED AREA. LOCATE APPROX. WHERE SHOWN & WRAP AROUND CABLE OVERLAPPING WHITE PRINTED AREA WITH CLEAR PORTION FOR PROTECTION.
- ⑤ BREATHER TUBE NOT USED IN THIS APPLICATION. TRIM BREATHER APPROX. 1/4" FROM END OF CABLE JACKET (BOTH ENDS). HEAT TUBE UNTILL CLEAR, PINCH WITH NEEDLE-NOSED PLIERS AS CLOSE AS POSSIBLE TO JACKET & HOLD UNTIL COOL. SHRINK TUBING TO COVER PINCHED TUBE.

NEXT ASSEMBLY		REFERENCE DRAWING		
FINAL		FR0015		
AR	31STDW3750	SHRINK TUBING	5	
1	19CR108LSR	PRINTABLE LABEL	4	
AR	1300060/40	SOLDER	3	
8'	122404F2PU	CABLE, POLYURETHANE JACKET	2	
B	1	100027.021	MODIFIED CONN., ENVIROTEC ET10	1
X	230489.023	CABLE ASSY		
X	230489.013	CABLE ASSY		
X	230489.003	CABLE ASSY		
QTY.	PART NO.	DESCRIPTION	ITEM	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				REVISIONS				CABLE ASSY, MATING, 6-PIN, SHELL SIZE 10, BAYONET STYLE, 4-COND. POLYURETHANE JACKET			
TOLERANCES ON FRACTIONS ±1/64 DECIMALS: XXX ±.01 XXXX ±.005 ANGLES ±1/2°				LET	DATE	BY	ECN	SCALE			
63 MACHINE FINISH (ALL SURFACES) REMOVE BURRS & BREAK SHARP EDGES 0.15 MAX. MACHINE FILLETS TO .015 R. MAX. ALL DIAMETERS TO BE CONCENTRIC WITHIN .010 F.I.M. CHAMFER ALL MALE THREADS 45°±5° TO MINOR DIAMETER C/SINK ALL FEMALE THREADS 90°±10° TO MAJOR DIAMETER				A	12/17/14	SN	14283	1/1			
				B	2/12/15	SN	14338	MATERIAL SEE B/M DRAFTSMAN DATE SMN 12/17/14			
				C	9/17/15	SN	14573	SEE ENGINEERING CHANGE NOTICE (ECN) FOR DRAWING APPROVALS			
				D	6/24/16	SN	14925	DRAWING NO.			
THIRD ANGLE PROJECTION											

230489