

# Assembly Instructions

for Amphenol straight S.J.clamps 62GB-587 for internally and externally screened and unscreened cables to DEF 10 and DEF STAN 61-12 Part 5.

## Internally Screened Jacketed Cable 'Type C'

### Cable and Wire Stripping

Strip the outer P.V.C.Jacket of the cable back to dimension 'A' to expose the internal braid. Trim the braid back to within 19.05mm (0.75 in) of P.V.C.jacket and fold back 'B'.

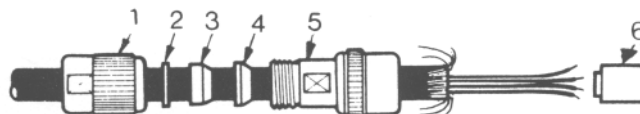
Size	A Dimension	
	mm	in
08	34.93	1.375
10	36.51	1.437
12 8 14	41.27	1.625
16 & 20	44.45	1.75
24	49.21	1.937



Strip 5.3mm (0.210 in) to 6.1 mm (0.240 in) of insulation from each wire to expose centre conductor. Tin the ends. If ends fray twist them back to their original lay before tinning.

### Initial Assembly

Slide onto the cable the following items in this order (1) Nut (2) Washer (3) Gasket (4) Braid Clamp and (5) Clamp Body (6) Grommet.



### Solder Connection to Contacts

Insert the individual wires into the appropriate grommet holes. At the same time, slide the grommet back as far as possible until the tinned ends of the centre conductors are far enough out of the grommet to permit soldering to the contacts. Insert the tinned ends of wires into the appropriate contacts in 62 series connector and solder into place. Slide the grommet forward over the wired contacts and press firmly into rear of connector shell and against rear face of insert.



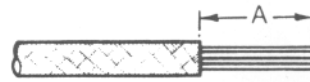
# Assembly Instructions

## Externally Screened Jacketed Cable Types 'B' & 'Q'

### Cable and Wire Stripping

Strip the outer braid and internal P.V.C. jacket of the cable back to dim 'A'

Size	A Dimension	
	mm	in
08	33.32	1.312
10	34.93	1.375
12 & 14	39.7	1.563
16 & 20	42.85	1.687
24	47.63	1.875

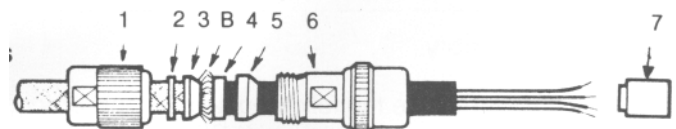


Strip 5.3mm (0.210 in) to 6.1 mm (0.240 in) of insulation from each wire to expose centre conductor. Tin the ends. If ends fray twist them back to their original lay before tinning.



### Initial Assembly

Slide onto the cable the following items in this order (1) Nut (2) Washer (3) Male Braid Clamp Convolute Screen (See B) as far as possible, and slide on items (4) Female Braid Clamp (5) Gasket and (6) Clamp Body (7) Grommet

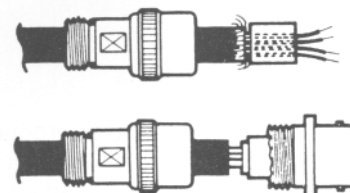


### Solder Connection to Contacts

Insert the individual wires into the appropriate grommet holes. At the same time, slide the grommet back as far as possible, until the tinned ends of the centre conductors are far enough out of the grommet to permit soldering to the contacts. Insert the tinned

ends of

and of wires into the appropriate contacts in 62 series connector and solder into place. Slide the grommet forward over the wired contacts and press firmly into the rear of connector shell and against rear face of insert.



### Unscreened Jacketed Cables Type 'A'

All procedures concerning this type of cable to be as for internally screened jacketed cable, but all references to screen (Braid) to be disregarded.

# Assembly Instructions

for Amphenol angled S.J. clamps 62GB-5028 for internally and externally screened and unscreened cables to DEF 10 and DEF STAN 61-12 Part 5.

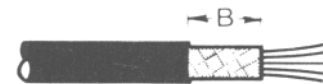
## Internally Screened Jacketed Cable Type 'C'

### Cable and Wire Stripping

Strip the outer P.V.C. jacket of the cable back to dim 'A' to expose the internal braid. Trim the braid back to within 19.05mm (0.75 in) of P.V.C. jacket and fold back 'B'.

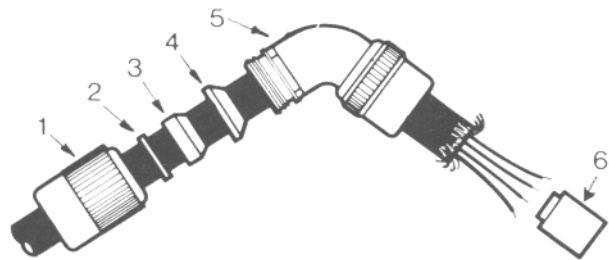
Size	A Dimension	
	mm	in
08	58.15	2.89
10,12,14	66.68	2.625
16	69.85	2.75
20	88.9	3.50
24	95.25	3.75

Strip 5.3mm (0.210 in) to 6.1 mm (0.240 in) of insulation from each wire to expose centre conductor. Tin the ends. If ends fray, twist them back to their original lay before tinning.



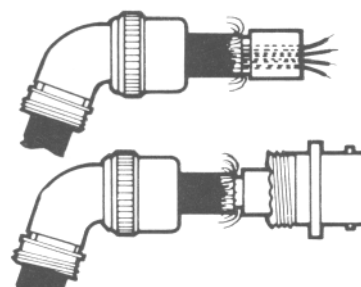
### Initial Assembly

Slide onto the cable the following items in this order (1) Nut (2) Washer (3) Gasket (4) Braid Clamp (5) 75o Angled Body (6) Grommet.



### Solder Connection to Contacts

**Insert** the individual wires into the appropriate grommet holes. At the same time, slide the grommet back as far as possible, until the tinned ends of the centre conductors are far enough out of the grommet to permit soldering to the contacts. Insert the tinned ends of wires into the appropriate contacts in 62 series connector and solder into place. Slide the grommet forward over the wired contacts and press firmly into the rear of the connector shell and against rear face of insert.



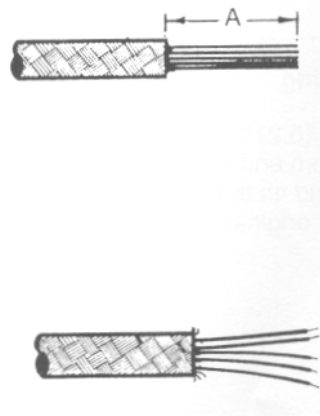
# Assembly Instructions

## Externally Screened Jacketed Cables Type `B' & `Q'

### Cable and Wire Stripping

Strip the outer braid and internal P.V.C. jacket of the cable back to dim `A'.

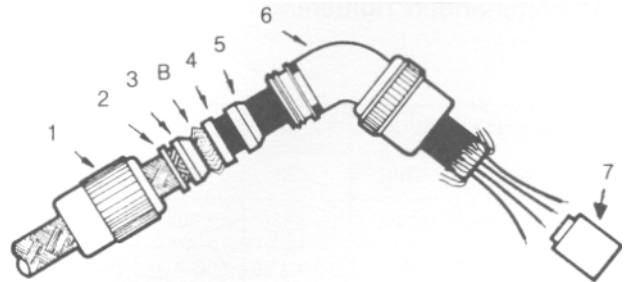
Size	A Dimension	
	mm	in
08	58.15	2.89
10,12,14	66.68	2.625
16	69.85	2.75
20	88.9	3.50
24	95.25	3.75



Strip 5.3mm (0.210 in) to 6.1 mm (0.240 in) of insulation from each wire to expose centre conductor Tin the ends. If ends fray, twist them back to their original lay before tinning.

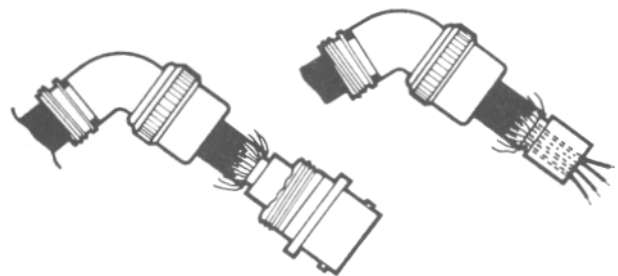
### Initial Assembly

Slide onto the cable the following items in this order: (1) Nut (2) Washer (3) Male Braid Clamp - Convolute Screen (See B) as far as possible and slide on items: (4) Female Braid Clamp (5) Gasket (6) 75o Right Angled Body (7) Grommet.



### Solder Connection to Contacts

Insert the individual wires into the appropriate grommet holes. At the same time, slide the grommet back as far as possible, until the tinned ends of the centre conductors are far enough out of the grommet to permit soldering to the contacts. Insert the tinned ends of wires into the appropriate contacts in 62 series connector and solder into place. Slide the grommet forward over the wired contacts and press firmly into the rear of connector shell and against rear face of insert.



### Unscreened Jacketed Cables Type `A'

All procedures concerning this type of cable to be as for internally screened jacketed cable, but all references to screen (Braid) to be disregarded.

# Assembly Instructions

## Wire Stripping

Strip 5.3mm (0.210 in) to 6.1 mm (.240 in) of insulation from end of wires to expose centre conductor and tin the ends. If ends fray, twist them back to their original lay before tinning.

## Wire Accommodation

Contact Size	Colour Code	Wire Seal and Conductor					
		Wire Insulation				Conductor	
		min. ins.	dia. (mm)	max. ins.	dia. (mm)	max. dia.	
20	Red	0.047	(1.19)	0.085	(2.16)	0.042	(1.07)
16	Blue	0.066	(1.68)	0.109	(2.77)	0.062	(1.57)

## Recommended Tightening Torques

Single Hole	Shell Size	8	10	12	14	16	18	20	22	24
Fixing	Nm	3.73	4.07	6.78	7.34	8.25	9.26	11.98	13.90	15.03
Receptacles	lbf. ins.	33	36	60	65	73	82	106	123	133
Accessories	Nm	3.39-3.96	3.96-4.52	4.52-5.09	5.09-5.65	5.65-6.78	6.78-7.91	8.48-9.04	9.61-10.17	10.74-11.3
	lbf. ins.	30-35	35-40	40-45	45-50	55-60	65-70	75-80	85-90	95-100