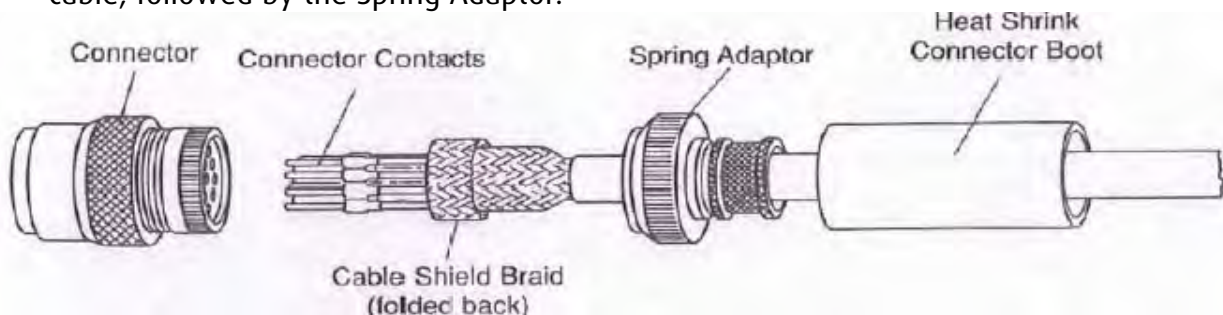


INSTALLATION PROCEDURE FOR SPRING ADAPTOR

This instruction sheet is to aid in the assembly of the following MIL-DTL-5015 connectors to braided cable:

- **C90-002-10SL**
 - **C90-002-12S**
 - **C90-002-14S**
- a) Prepare the cable making sure that a sufficient length of shield is available, so that it fits against the front shoulder of the lip groove.
- b) Before insertion of connector contacts, slide the heat-shrinkable connector boot onto the cable, followed by the Spring Adaptor.

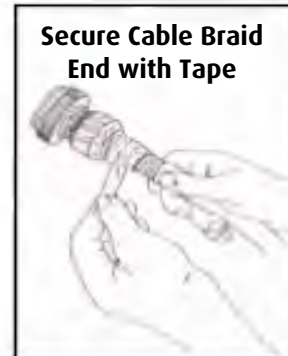
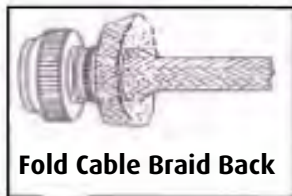


- c) Position the heat shrinkable boot, Spring Adaptor, and braid out of the way, and insert the connector contacts. Depending upon the shielding braid size it can either be folded back onto itself or bunched up concertina style out of the way for easy access to the cable conductors.
- d) Slide the Spring Adaptor forward, over the braid, and pull the braid back so it is not trapped under the Adaptor.
- e) Screw the Spring Adaptor onto the connector and tighten to the torque value specified in the table below. It is recommended that the connector threads are lubricated with a suitable compound if a liquid thread lock is not used. The Adaptor should be hand tightened to ensure proper thread alignment and then tightened with a strap wrench and torque meter to the specified torque.

Shell Size	Tightening Torque	
	(lb.in ± 5)	(Nm ± 0.5)
10SL	40	4.5
12S	40	4.5
14S	40	4.5

- f) Bring the cable shield braid up onto the adaptor body so that it fits against the front shoulder of the lip groove. Alternatively extend the braid past the lip groove.

Note: After assembly, braid can be trimmed with side cutters or folded back and secured with high temperature tape.



- g) Open up the constant force spring and wrap it around the cable braid section that is positioned over the constant force spring slot area of the adaptor. This is most easily accomplished by lifting up the end of the spring and trapping the braid covered adaptor between the spring coil and raised end. The spring will now stay in place and can be installed by simply rolling the spring coil around the braid covered adaptor.
- h) Install heat shrink connector boot over braid and back of Adaptor, use industry standard best practices.

