Question

Do you have connector assembly instructions for the 6917B cable with the replacement connector, 26574?

Answer

Assembly instructions are as follows:

1. Squarely cut through the cable at the end to be repaired. Strip the outer red Teflon jacket, 0.5 inches, and trim the shield as close as possible to the jacket. Remove all black low noise treatment on the two leads (see the stripping instruction card [74314] for proper lead preparation steps). Clean both leads with alcohol or other approved solvent. See figure 1.

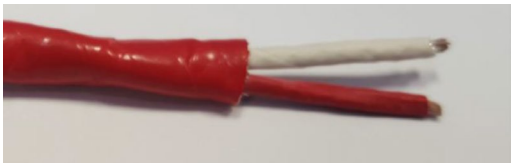

Figure 1

2. Disassemble the connector. Carefully cut the grommet in half & cut through one wall from O.D. to wire hole, over full length 180° apart.

3. Install the connector parts in order as shown in figure 2; the stripped leads being off to the right. (The fiberglass strain relief and heat shrink shown in figure 2 are not provided with the connector.)

Figure 2

4. Strip off the insulation from each wire, 0.25 inch, then insert though the white insulator, and do not tin the wire strands. See figure 3.

Figure 3

5. Crimp the contacts on the conductors, using crimp tool M22520/2-01 and the number 7 setting with Cannon K-18 stopper. (Tooling specified for this step in not provided with the connector. Spare crimp pins are available, 75961-01) See figure 4.

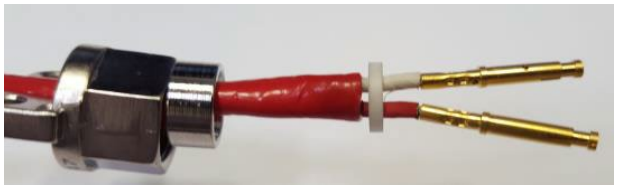

Figure 4

6. Measure insulation resistance with 100VDC, should be 1G Ohm minimum: Red wire to white wire and both wires to shield.

7. Install grommet halves in their proper location on the leads. Insert White lead into hole A and Red lead into hole B. See figure 5.

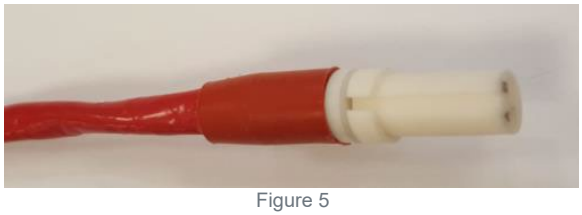

Figure 5

8. Install the assembly into the connector. Applying thread lock adhesive on the back shell is optional but recommended. Tighten the back shell to the connector as shown in figure 6. (Thread lock adhesive is not supplied with the connector and it should be rated to the full temperature of 500°F.)

Figure 6

9. Install the cable clamp bar and screws. Again, thread lock adhesive is optional but recommended. See figure 7.

Figure 7

10. Verify continuity from Red lead at opposite end of cable to pin B and White lead to pin A. The reading should be 1 Ohm max.

11. Measure insulation resistance per step 6 again.