GAP-027

Composite Swing-Arm™

Shield sock termination assembly procedure

SWING-ARM COMPOSITE 3-IN-1 BACKSHELL SHIELD SOCK TERMINATION PROCEDURE

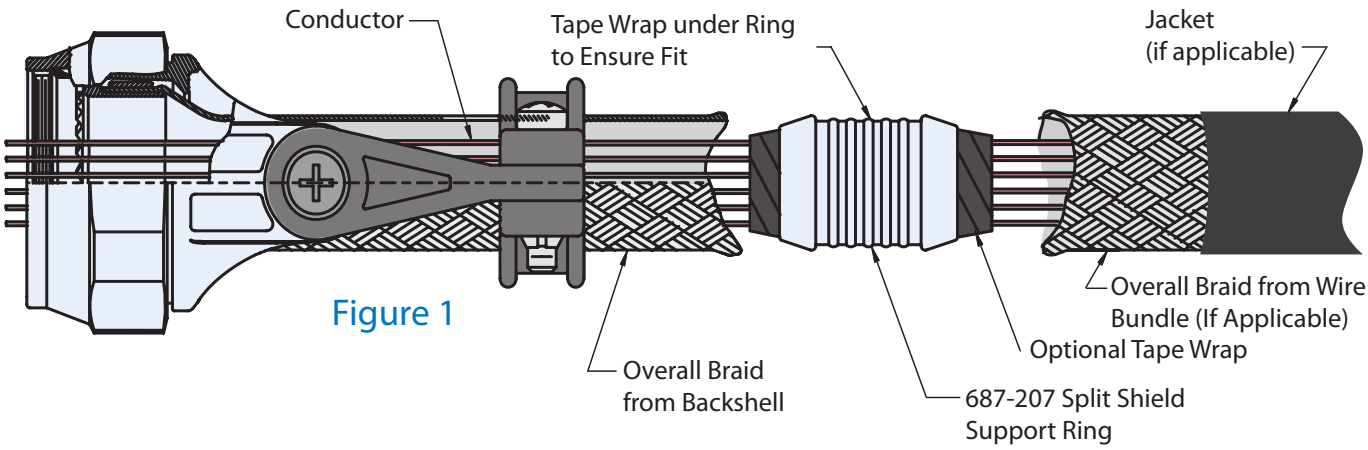
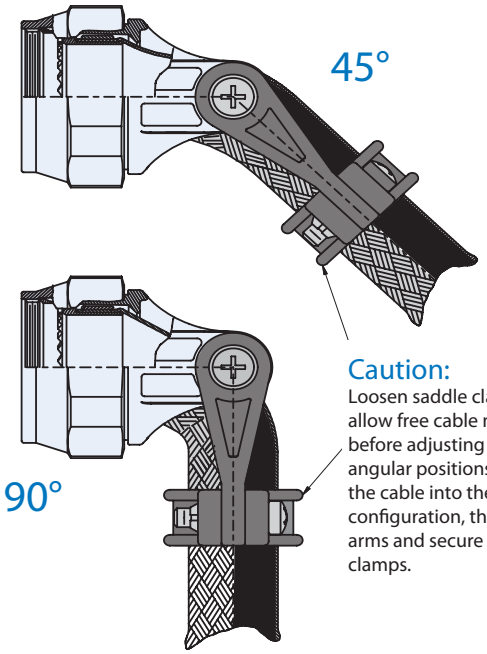


Figure 1

Glenair recommends that trial samples of appropriate shield wire bundles be used to determine proper trim dimensions of the individual shields, conductors, and cable jacket (if applicable)

1. Choose Straight, 45° or 90° angle, and tighten screws to lock arms in place. Leave the saddle clamp hardware loose.
2. Next, insert the wire bundle into the backshell to determine if the braid transition angle from the backshell to wire bundle is less than 45°. If it is less than 45°, build up the wire bundle with tape and re-insert wire bundle into backshell to support the transition of overall braid from the backshell to the wire bundle.
3. Loosely assemble the adapter to the connector and push back the backshell braid. Insert the wire bundle into the adapter and bottom it against the connector. Holding the cable, mark or tag the location where the shield support ring (Glenair Part Number 687-207) will be located. This distance may vary depending on your technique and the flexibility of the wire bundle immediately to the rear of the saddles (Figure 1).
4. At the marked location, near the shield support ring, wrap tape around wire bundle for snug fit of shield support ring (Figure 1). Tape wrap is optional.
5. Slide the overall braid from the wire bundle side over the shield support ring, trimming the braid ends and tucking extra braid underneath itself for a clean appearance.



Caution:
Loosen saddle clamps to allow free cable movement before adjusting clamp to angular positions. Form the cable into the desired configuration, then tighten arms and secure the saddle clamps.

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SWING ARM COMPOSITE THREE-IN-ONE BACKSHELL

Shield sock termination assembly procedure

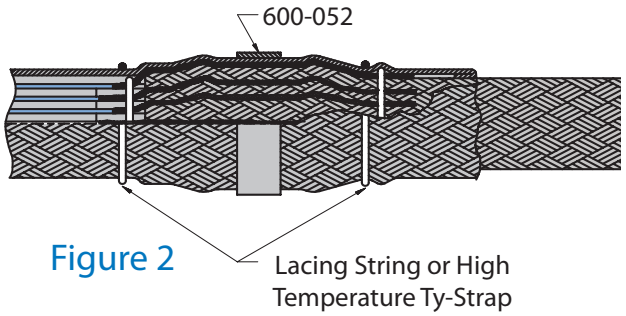

Figure 2

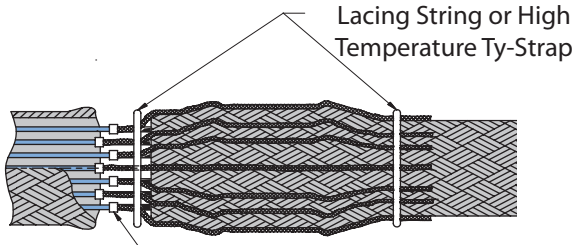

Figure 4

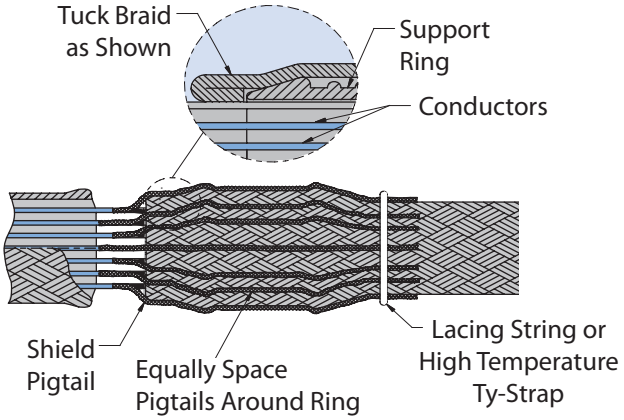

Figure 3

6. For pin connectors, slide the backshell forward, and hand tighten backshell to connector. Then, evenly space shield pigtails (Figure 3) or solder sleeve pigtails (Figure 4) around the shield support ring. Cut the pigtails so that their ends are approximately 1/2" beyond the end of the shield support ring.
7. Bring the shield sock from backshell and completely cover the pigtails and support ring. Trim and fold the braid as shown in Figure 2. Lace tie the shield adjacent to support ring ends.
8. Install a Glenair Band-Master ATS® band between the lace ties onto the center of the support ring as shown in Figure 2. 600 Series Band-Master ATS® hand banding tool or pneumatic banding tool is used for this process.
9. Wrap the shield support ring assembly with high-temperature tape. Place lacing cord, high-temperature tape, or high-temperature Ty-wraps in 1" increments starting at the braid transition at the rear of the backshell to secure overbraid on the wire bundle. Cover the overbraid with 102-080 braid sock extending approximately 1" past the shield support ring.
10. Tighten the adapter to the connector using Glenair 600-091 or 600-057 composite hex coupling torque wrench and related accessories to torque values in Table I below. Secure the strain relief saddle onto the wire bundle using TG69 soft jaw pliers. Torque the saddle screws to established values (Table I). Use Fluoropolymer tape wrap or M85049/127 bushing strip as needed to cushion the braid sock under the saddle clamps.

Your Swing-Arm strain relief installation is complete!

Table I: Torque Values

Connector Shell Size Ref.	Coupling Ring Installation Torque (in lb)	Hex Coupling Torque Wrench	Saddle Screw Size	Saddle Screw Installation Torque (in lb)	Arm Screw Size	Arm Screw Installation Torque (in lb)
08, 09, A	35	600-091-08 or 600-157-08	4	4	6	4
10, 11, B	35	600-091-10 or 600-157-10	4	4	6	4
12, 13, C	45	600-091-12 or 600-157-12	6	6	8	6
14, 15, D	45	600-091-14 or 600-157-14	6	6	8	6
16, 17, E	45	600-091-16 or 600-157-16	6	6	8	6
18, 19, F	45	600-091-18 or 600-157-18	6	6	8	6
20, 21, G	80	600-091-20 or 600-157-20	6	6	8	6
22, 23, H	80	600-091-22 or 600-157-22	6	6	8	6
24, 25, J	80	600-091-24 or 600-157-24	6	6	8	6
28	120	600-091-28 or 600-157-28	6	6	-	-
32	120	600-091-32 or 600-157-32	10	10	-	-
36	120	600-091-36 or 600-157-36	10	10	-	-