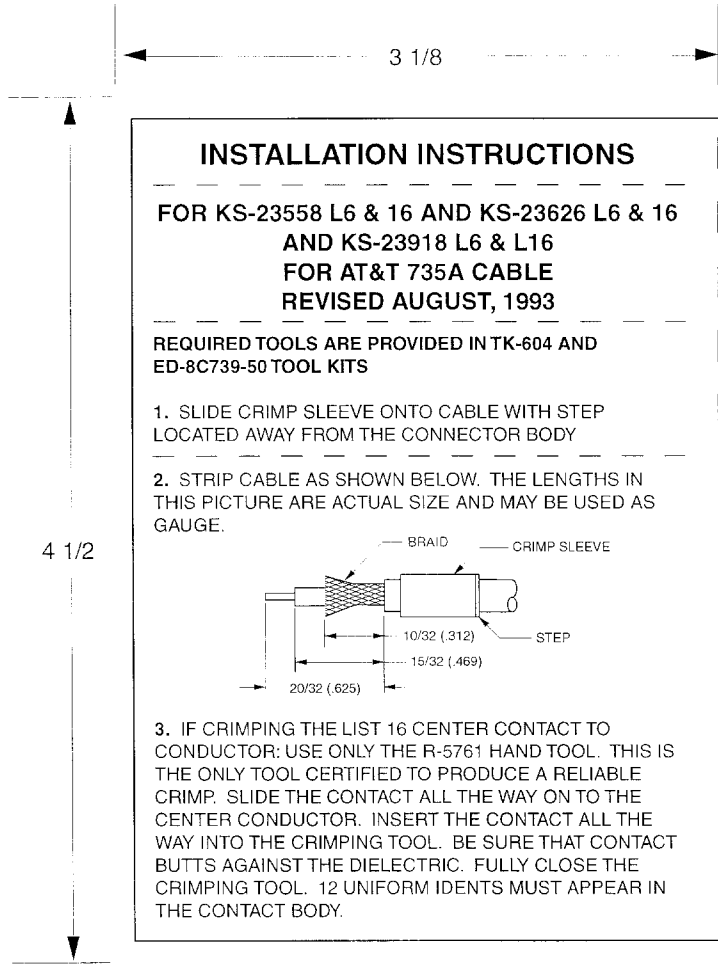


DWG SIZE <b>A</b>	DATA CONTAINED IN THIS DOCUMENT IS PROPRIETARY TO TROMPETER ELECTRONICS, INC. AND SHALL NOT BE DISCLOSED, COPIED, OR USED FOR PROCUREMENT OR MANUFACTURE WITHOUT EXPRESS WRITTEN PERMISSION.	REVISIONS			105-1668		SH5
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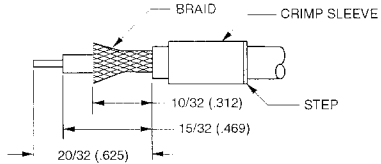
**INSTALLATION INSTRUCTIONS**

**FOR KS-23558 L6 & 16 AND KS-23626 L6 & 16  
AND KS-23918 L6 & L16  
FOR AT&T 735A CABLE  
REVISED AUGUST, 1993**

**REQUIRED TOOLS ARE PROVIDED IN TK-604 AND  
ED-8C739-50 TOOL KITS**

1. SLIDE CRIMP SLEEVE ONTO CABLE WITH STEP  
LOCATED AWAY FROM THE CONNECTOR BODY

2. STRIP CABLE AS SHOWN BELOW. THE LENGTHS IN  
THIS PICTURE ARE ACTUAL SIZE AND MAY BE USED AS  
GAUGE.



3. IF CRIMPING THE LIST 16 CENTER CONTACT TO  
CONDUCTOR: USE ONLY THE R-5761 HAND TOOL. THIS IS  
THE ONLY TOOL CERTIFIED TO PRODUCE A RELIABLE  
CRIMP. SLIDE THE CONTACT ALL THE WAY ON TO THE  
CENTER CONDUCTOR. INSERT THE CONTACT ALL THE  
WAY INTO THE CRIMPING TOOL. BE SURE THAT CONTACT  
BUTTS AGAINST THE DIELECTRIC. FULLY CLOSE THE  
CRIMPING TOOL. 12 UNIFORM IDENTENTS MUST APPEAR IN  
THE CONTACT BODY.

4. IF SOLDERING THE LIST 6 OR 16 CENTER CONTACT TO  
THE CONDUCTOR: USING .015 INCH DIAMETER TIN/LEAD  
SOLDER SLUG WITH 2% SILVER .20 INCH LONG (R-5774)  
DROP A SLUG INTO HOLE IN END OF CENTER CONTACT.  
APPLY HEAT WITH RESISTANCE TWEEZERS (R-5758) SET  
FOR ABOUT 35 WATTS (5 ON LOW POWER). WHEN SOLDER  
MELTS, INSERT CENTER CONDUCTOR IN HOLE. KEEP  
POWER ON FOR ABOUT 2 SECONDS, THEN REMOVE  
POWER AND CONTINUE TO HOLD PIN UNTIL COOL  
(ABOUT 5 SECONDS).

5. SLIGHTLY FAN OUT THE BRAID AT THE END. PUSH  
CABLE INTO CONNECTOR UNTIL CONTACT SNAPS INTO  
PLACE. ALL BRAID WIRES MUST BE OVER THE SUPPORT  
SLEEVE. FOIL MUST BE UNDER SUPPORT SLEEVE.

6. DRESS THE BRAID EVENLY AROUND THE SUPPORT  
SLEEVE. SLIDE CRIMP SLEEVE FORWARD OVER BRAID  
AND AGAINST CONNECTOR. CRIMP IN PLACE USING TOOL  
AND DIE COMBINATION AS FOLLOWS:

CRIMPING TOOL	DIE
AT&T R-5648	DET 2-A, 13-A
AT&T R-4081	DET 7-03
AT&T KS-22214	LIST 5-K

**REQUIRED DIE FLAT DIMENSIONS ARE .178 INCHES**

**RED INDICATES ORIGINAL**

**SIDE 1**

**SIDE 2**

- 1. Card Color: Light Red with Black Marking
- 2. Print on 15# paper If Folded; If Printed Front/Back, Print on 30# Paper.

QTY	DESCRIPTION	PART NUMBER	ITEM
TOL UNLESS SPECIFIED .XX ± .XXX ± XXXX+ ANGLES		KS-23626 L6 & L16 INSTALLATION INSTRUCTION SHEET	
DWN DC 8/24/00		MATERIAL	CODE IDENT 14949
CHK		SCALE	REV E
ENGR		DATE 9/29/98	SHEET 5 of 5
APPR			
NEXT ASSY			