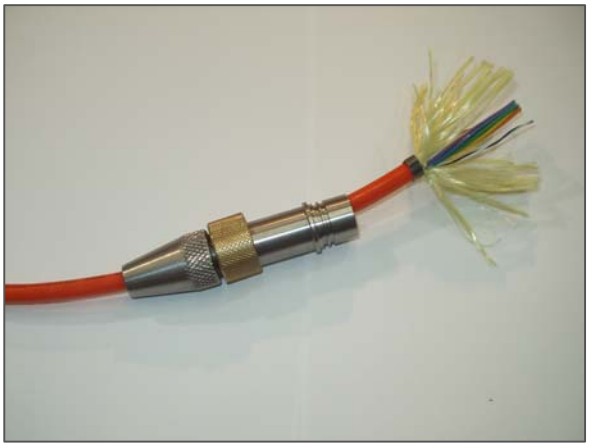
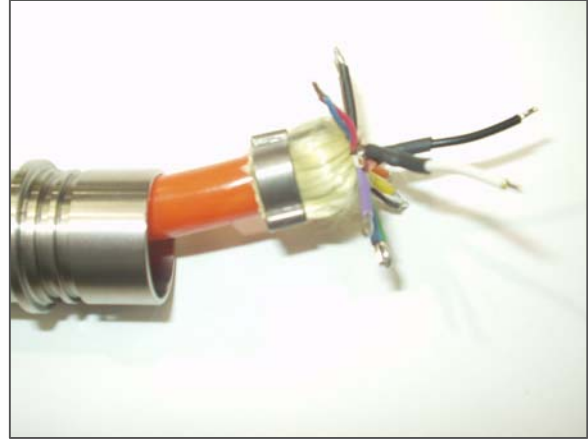


REVISIONS				
REV.	DESCRIPTION	BY	DATE	APPROVED
A	REVISED PART NUMBER ON CABLE CLAMPS	SPL	1/31/08	WB



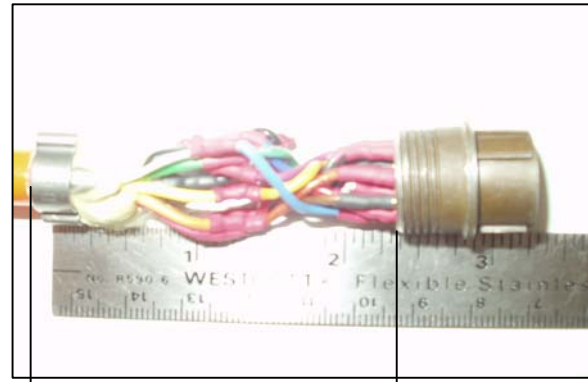
- REMOVE THE OLD TERMINATION BY CUTTING CABLE BACK AS NEEDED TO CLEAR THE PROBLEM, MAKING SURE THE CONDUCTORS ARE NOT CORRODED UNDER THE INSULATION.
- PLACE TERMINATION COMPONENTS IN FOLLOWING ORDER:  
WITHOUT SPRING
  - P & T WATERTIGHT CABLE LOCK (200-000-556)
  - GOTCHA RING BLUE (24-010-034)
  - STOPPER RUBBER W\ THRU HOLE (72-010-138)
  - P & T WATERTIGHT PLUG LOCK (200-000-555)
  - P & T WATERTIGHT PLUG (200-000-554\003)
  - CABLE CLAMP (08-010-041\002)
  - CABLE CLAMP (08-010-041\001)WITH SPRING
  - CABLE LOCK W\ WATERTIGHT TERM. W\ SPRING (200-001-210)
  - SPRING TERMINATION (200-001-224)
  - CABLE LOCK WASHER W\ WATERTIGHT TERM. W\ SPRING (200-001-211)
  - STOPPER RUBBER W\ THRU HOLE (72-010-138)
  - P & T WATERTIGHT PLUG LOCK (200-000-555)
  - P & T WATERTIGHT PLUG (200-000-554\003)
  - CABLE CLAMP (08-010-041\002)
  - CABLE CLAMP (08-010-041\001)
- PLACE THE FIRST CLAMP (08-010-041\001 7/16) AT LEAST 3' FROM END OF CABLE & CRIMP ON.



- SOLDER & TIN EACH WIRE BEING USED
- REMOVE THE COVERING ON THE COAXIAL SHIELD TO EXPOSE THE COAXIAL SHIELD WIRES. PULL BACK SHIELD AS FAR AS POSSIBLE, THEN TWIST THE SHIELD TOGETHER ONTO ONE SIDE LEAVING 1/2".
- CUT COAX LEAVING 1/2" THEN STRIP THE INSULATION OFF THE COAXIAL WIRE LEAVING 1/8" EXPOSED
- SOLDER A 1/2" PIECE OF 20 GA. WHITE WIRE TO THE COAXIAL SHIELD AND A 1/2" PIECE OF BLACK 20 GA. TO THE COAXIAL WIRE.
- BEING SURE TO SHRINK WRAP EACH TERMINATION. APPLY A LARGER DIAMETER SHRINK WRAP TO KEEP THESE CONNECTIONS TOGETHER.

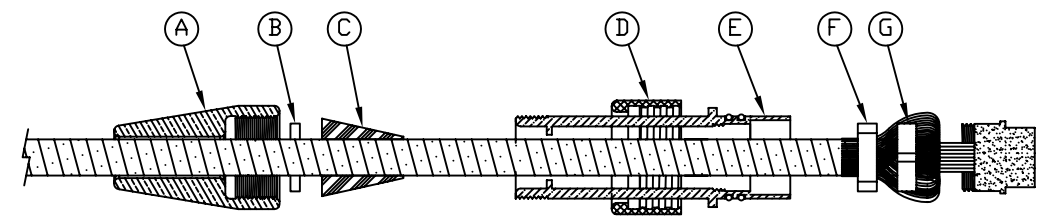


- STRIP OFF OUTER JACKET BACK TO THE CABLE CLAMP. MAKING SURE NOT TO CUT INSULATION OR KEVLAR ON WIRES.
- CUT WIRES LEAVING 1' FROM END OF CABLE.
- TUCK THE EXPOSED KEVLAR UNDER THE SECOND CLAMP (08-010-041\002 1/2) & CRIMP ON AT 90° TO FIRST CLAMP.
- TRIM OFF ALL EXCESS KEVLAR EXTENDING PAST THE SECOND CLAMP.
- SEPARATE & FAN OUT WIRES, REMOVING 1/8" OF INSULATION ON EACH WIRE BEING USED.

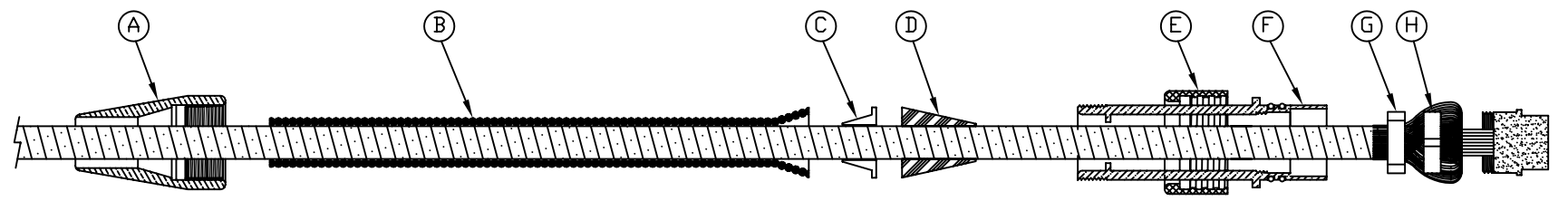


NO LONGER THAN 2 3/8"

- SOLDER THE CORRESPONDING COLORED WIRES FROM THE CABLE TO THE 12 PIN CONNECTOR. BE SURE TO SHRINK WRAP EACH TERMINATION.
- KEEP THE CONNECTIONS TWISTED IN A CLOCKWISE DIRECTION. TO ENSURE A FIT IN THE HOUSING.
- FINAL OVERALL LENGTH FROM BACK OF SECOND CLAMP TO 12 PIN HOUSING MUST NOT EXCEED 2 3/8"



WITHOUT SPRING - #200001029

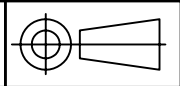


WITH SPRING - #200001029\001

NOTE: STANDARD ORANGE CABLE 12 PIN WIRING DIAGRAM SEE DWG. 100-000-295  
TOOLS REQUIRED: SOLDERING IRON (72-010-179), WIRE STRIPPER (72-010-178), EXACTO KNIFE (39-050-002), SOLDER (72-010-177)

PROVIDED: WRENCH (200-001-226), HEAT SHRINK WRAP (76-020-013\018), 1/2" PIECE OF 20 GA. WIRE (WHT), 1/2" PIECE OF 20 GA. WIRE (BLK)

**PROPRIETARY INFORMATION**  
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**OPTICAL ROBOTICS, INC.**  
 4806 Wright Dr., Annex C  
 Smyrna, GA 30082

DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCE AS BELOW UNLESS SPECIFIED AT THE DIMENSIONED AREA				12 PIN TERMINATION PROCEDURE	
1 PLACE DEC.	±.06	GROUP	NAME	DATE	FILE: Z:\STDDWG\ACCESSORY\21231.dwg PROJECT ACCESSORY DRAWING No. 200-001-231 SCALE: N.T.S. REV. A SHT. 1 OF 1
CHECKED		DRAWN BY:	SPL	3/5/07	
2 PLACE DEC.	±.010	PROJECT ENGINEERING:			
3 PLACE DEC.	±.005	MECHANICAL DESIGNER:			
ANGLES	±.5°	INDUSTRIAL DESIGNER:			
FILLETS NOT DIMENSIONED	R=0.032	CLIENT APPROVAL:			
ROUNDS NOT DIMENSIONED	R=0.032				

PREPARED BY COBRA TECHNOLOGIES LLC, 4806-C WRIGHT DRIVE, SMYRNA, GA. 30082