



STANDARDS SHEET

This standard covers the selection of the approved components for the splicing of single and multiple conductor wires and/or braided shields, the methods of installation and the necessary tools.

For guidance in selecting components, the restrictions and the preferred selections use Table I for Butt and Cap connectors or Table II for Parallel connectors.

Table I - Butt and Cap Connectors

1. General Practice
 - 1.1 Braids and wires must not be intermixed at either end of a butt splice.
 - 1.2 Wire conductors
 - 1.2.1 A single wire in a butt splice must have an adapter where called for in Table I (See codes a, aa, & aaaa)
 - 1.2.2 A bundle (2 or more) of wires in a butt splice or end cap must have a sleeve (Code A in Table II)
 - 1.3 Shield braids do not require adapters or sleeves. (Amp Parts)
2. Select the splice connector to provide for the accommodation of the wires with the larger conductor/or braid overall diameter.
3. Where Table I offers a choice of splice size, select the smallest splice that will fulfill the needs of both ends.
4. The use of caps (MS25274) shall be restricted to the following:
 - 4.1 Unshielded wire
 - 4.1.1 For splicing within distribution boxes.
 - 4.1.2 For splicing wires which jumper pins of the same connector.

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4.2 Shielded Wire

4.2.1 For splicing wires whose shields all terminate in a common inner and outer sleeve.

4.2.2 For splicing pigtails from shield terminations together or to a common wire at one connector.

5. Insulating Sleeves (CSP220)

Select from Table I for the appropriate type of splice i.e.

(i) All wire splice (Upper line)

(ii) Braid or Braid and Wire (Lower Line)

TYPICAL EXAMPLES FOR GUIDANCE IN USE OF TABLE I.

Example 1:- Butt splice - 3 wires (22GA)

Since the splice will be made with two wires in one end and one wire in the other, the selection will be made to favour the end with two wires. Looking across the table for size 22GA wire it will be noted that it is possible to use either a medium or large "DSC" splice. Select the smallest i.e. DSC 44-2 (medium splice). Note that a sleeve is required. As indicated by symbol ▲ having determined the splice size it is now necessary to determine the hardware for the end with the single wire. Looking under the column "Med Splice" it is found that 1 No. 22GA wire and a 327635 adapter (Symbol ●) satisfies that end of the splice. The correct insulating sleeve for this splice is CSP220-9-7

Example 2: Butt Splice - 3 No. 22 Braids and 1 No. 20 Wire.

The 3 braids must be together in one end and this end will have the larger diameter.

Looking across from No. 22 braid in Table I, it is found that a medium splice will accommodate 3 number 22 braids. Having selected the splice size it is now necessary to select the hardware for the other end - Looking under the column "Medium Splice" it is found that one Number 20 wire requires a 327635 adapter (Symbol ●) to satisfy that end of the splice. The correct insulating sleeve for this splice is CSP220-11-8.

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Table II - Parallel Connectors

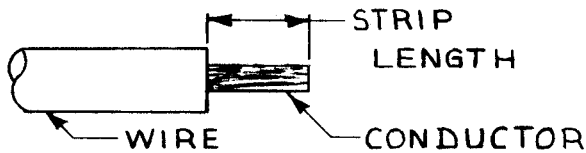
1. Select parallel connector that will accommodate the required number of wires and/or shields. The parallel connector will accept intermixed wires and braids from one or both ends. When employing the cap method of connection the CSP220 insulating sleeve can be crimped while hot to provide adequate seal.
2. The number of wires shown in table is the maximum that can be easily installed, always use the smallest connector that is available.

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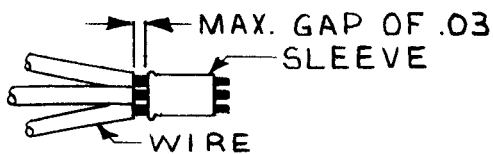
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INSTRUCTIONS FOR ASSEMBLY OF SPLICES USING SLEEVE AND BUTT CONNECTOR OR CAP

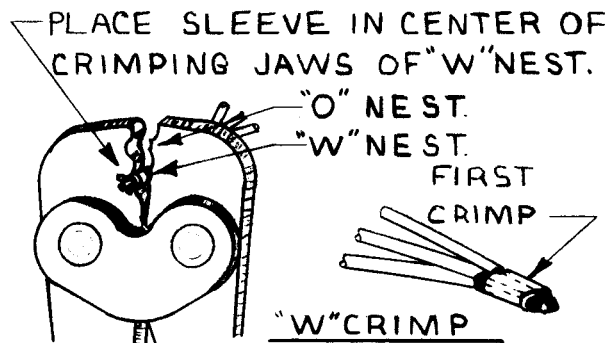


1. STRIP WIRES TO CORRECT DIMENSION AS SHOWN IN TABLE III.

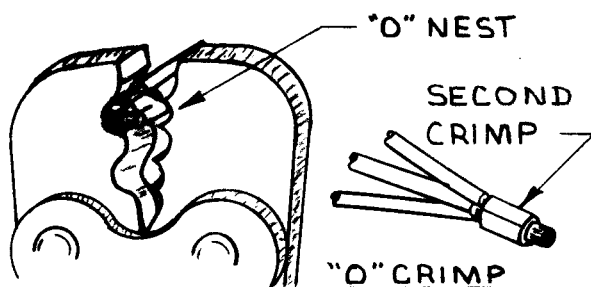
NOTE: DO NOT NICK OR CUT CONDUCTOR



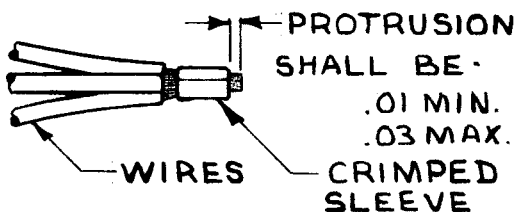
2. INSERT STRIPPED WIRES INTO SLEEVE AS SHOWN. MAXIMUM GAP BETWEEN WIRE INSULATION AND SLEEVE SHALL BE .03.



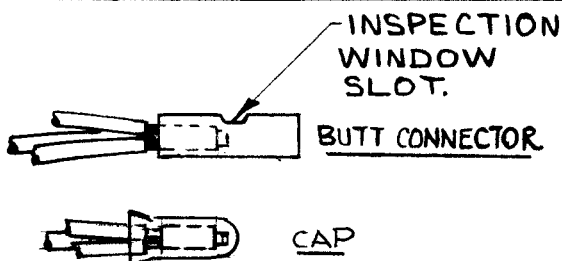
3. TWO CRIMPING STEPS ARE REQUIRED FOR PROPER ASSEMBLY OF SLEEVE AND WIRES. TO MAKE THE FIRST CRIMP PLACE SLEEVE (WITH STRIPPED WIRES INSERTED AS PER STEP 2) INTO 'W' CRIMP NEST OF TOOL SELECTED FROM TABLE III. PLACE SLEEVE IN CENTRE OF CRIMPING JAWS AND SQUEEZE UNTIL TOOL RATCHET RELEASES



4. TO MAKE SECOND CRIMP, ROTATE SLEEVE 1/4 TURN AND PLACE INTO THE CENTRE OF 'O' CRIMP NEST OF THE SAME TOOL. SQUEEZE UNTIL TOOL RATCHET RELEASES



5. TRIM EXCESS WIRE TO DIMENSION AS SHOWN



6. INSERT CRIMPED SLEEVE INTO PROPER BUTT CONNECTOR OR CAP AND CRIMP USING CORRECT TOOL SELECTED FROM TABLE III

NOTE: WIRE ENDS MUST APPEAR IN INSPECTION WINDOW

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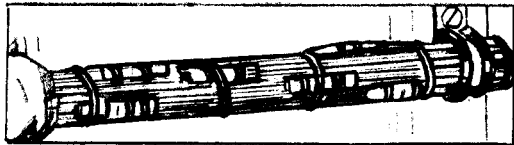
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INSTRUCTIONS FOR ASSEMBLY OF SPLICES IN A CABLE HARNESS

1. BUTT CONNECTORS ARE TO BE STAGGERED AND LOCATED ON THE OUTSIDE OF THE HARNESS
HARNESS TO BE LACED IN NORMAL MANNER TO GIVE ADEQUATE SUPPORT.

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BUTT & CAP CONNECTORS

TABLE I

TYPE OF CONDUCTOR	SPLICE OR CAP SIZE	SMALL SPLICE	MEDIUM SPLICE		LARGE SPLICE		CAP		
		UN-INS / INS	UN-INS	INS	UN-INS	INS	INS		
		DSC44-1 / MS25181-1	DSC44-2	MS25181-2	DSC44-3	MS25181-3	▲ MS25274-4		
WIRE	22		.	▲	..	▲	▲5,6 or 7		
	20	1		2		▲3		3	5,6 or 7
	18				2	OR 4		OR	
	16				..			4	
	14								
	12								
	10								
SHIELD BRAID ▲2	22			3			5		
	20	1	2						
	18				3	4			
	16								

- + ADAPTER 327635
- .. + ADAPTER 327636 } AMP
- ... + ADAPTER 327637
- ▲ + SLEEVE 328467

1. THE TABLE SHOWS PER END CAPACITY FOR WIRE OR BRAIDS

▲2 FOR FORMING PIGTAILS SEE PPS 9.04 PAR 5.5.5

INSULATING SLEEVE

- SEE PAGE 24 FOR TYP INSTL

SPLICE COMPOSED OF WIRE COND ONLY	CSP220-8-7	CSP220-9-7	CSP220-11-7	
SPLICE COMPOSED OF BRAIDS & WIRE		CSP220-11-8	CSP220-13-8	

STRIP LTH

.19 ±.03

.31 ±.03

CRIMP
TOOLDSC
MS

AMP 49935

MS25037-1 OR T&B WT145A

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PARALLEL CONNECTORS Δ

TABLE II

TYPE OF CONDUCTOR	SPLICE Δ	SMALL DSC 51-1	MED DSC 51-2	LARGE DSC 51-3	EXTRA LARGE DSC 51-4
WIRE	22	3	5	11	15
	20	2	3	6	11
	18		2	5	7
	16		2	4	6
	14			3	5
	12			2	3
SHIELD BRAID Δ	22		2 $\frac{1}{2}$ * OR 1 $\frac{1}{2}$ 2*	5 $\frac{1}{2}$ * OR 4 $\frac{1}{2}$ 2*	6 $\frac{1}{2}$ * OR 5 $\frac{1}{2}$ 2*
	20		2 $\frac{1}{2}$ * OR 1 $\frac{1}{2}$ 2*	5 $\frac{1}{2}$ * OR 4 $\frac{1}{2}$ 2*	6 $\frac{1}{2}$ * OR 5 $\frac{1}{2}$ 2*
	18		1 $\frac{1}{2}$ 2*	4 $\frac{1}{2}$ * OR 3 $\frac{1}{2}$ 2*	6 $\frac{1}{2}$ * OR 5 $\frac{1}{2}$ 2*
	16		1 $\frac{1}{2}$ 2*	3 $\frac{1}{2}$ 2*	5 $\frac{1}{2}$ * OR 4 $\frac{1}{2}$ 2*

* INDICATES — ANZO

INSULATING SLEEVE — SEE PAGE 24 FOR TYP INSTL

SPLICE COMPOSED OF WIRE CONDUCTOR ONLY	CSP220-9-6	CSP220-9-6	CAP CSP220-11-6 PARALLEL CSP220-9-6	CSP220-13-6
SPLICE COMPOSED OF BRAIDS OR BRAIDS & CONDUCTOR		CSP220 -13-8	CSP220 -15-8	CSP220 -15-8

STRIP
LENGTH $\frac{3}{8}$ "

& TERM AFTER CRIMPING

CRIMP
TOOLAMP
ETC49935-8
RHT1000

59070



FOR FORMING PIGTAILS SEE PPS 9.04 PAR 5.5.5



MAY BE USED FOR MIXTURES OF STRANDED OR SOLID CONDS.



THE TABLE SHOWS THE MAX CAPACITY OF THE CONN. FOR WIRE &/OR BRAID

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TYPE	SYMBOL		HARDWARE	NO. REQD	DESCRIPTION
	WIRING	CABLE			
1			DSC 44 SPlice CON.	1	CSP - SLEEVE SLEEVE ADAPTER CONNECTOR TYPICAL MULTI SPlicing OF WIRES AT THE BACK OF A CONNECTOR IN A CABLE
			ADAPTER SLEEVE CSP 220 SLEEVE	1	
2			DSC 51 PARALLEL CON	1	<u>PREFERRED</u> CON, PLUG, CONNECTOR OR RECEPT CSP 220 - SLEEVE SAME AS NOTE ABOVE ALSO IN BOX HARNESS WIRING
			MS25274 CAP SLEEVE	1	
			DSC 51 PARALLEL CON	1	<u>PREFERRED</u> CONNECTOR CSP 220 SLEEVE CRIMP SLEEVE WHILE STILL HOT SAME AS NOTE ABOVE
			CSP 220 SLEEVE	1	

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TYPE	SYMBOL		HARDWARE	NO REQD	DESCRIPTION
	WIRING	CABLE			
3			DSC 51 PARALLEL CON MS25190 -A-20 WIRE CSP 220 SLEEVE *	1 1 1	<u>PREFERRED</u>
			DSC 44 SPLICE CON ADAPTER MS25190 -A-20 WIRE CSP 220 SLEEVE *	1 1 1	TYPICAL FOR MAX SHIELD BRAID ACCEPTANCE SHOWN IN TABLE 1 OR 2 SEE TYPE 4 FOR TERMINATIONS IN EXCESS OF THAT PERMITTED BY TYPE 3. * SEE PAGE 24

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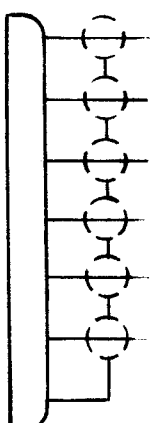
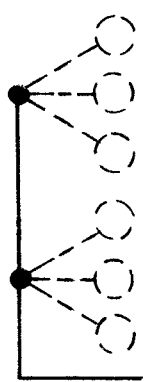
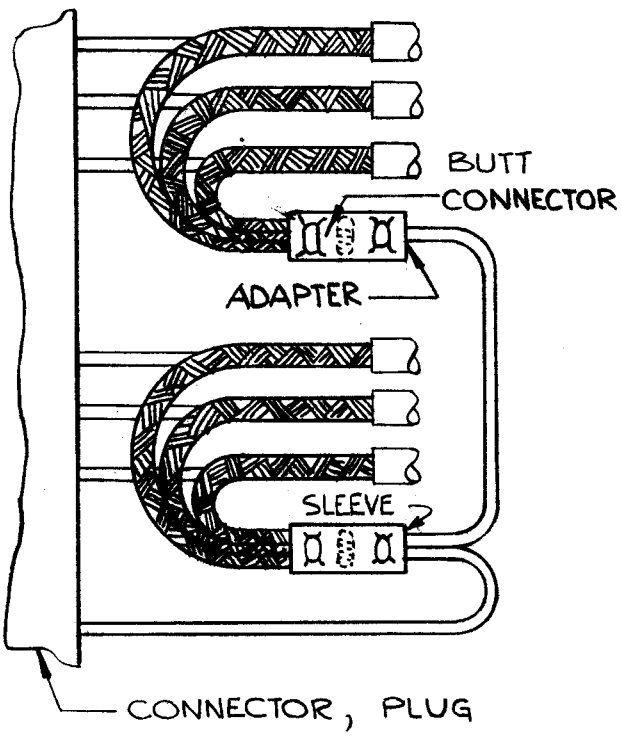
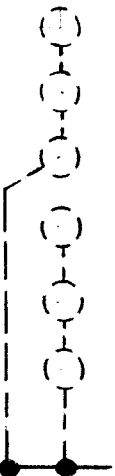
TYPE	SYMBOL		HARDWARE	Nº REQD	DESCRIPTION
	WIRING	CABLE			
4A			DSC 51 PARALLEL CON	AR	<u>PREFERRED</u> CONNECTOR CONNECTOR, PLUG TYPICAL FOR SHIELD TERMINATION IN EXCESS OF THE MAX Nº. PERMITTED BY TABLES 1 OR 2. FOR SINGLE SPLICE SHARE SHIELDS EQUALLY OR WITH A MAX DIFFERENCE OF 1 (ONE) BETWEEN SPLICE CONNECTORS. THE MAX Nº OF SHIELD TERMINATIONS AT EACH CONNECTOR GOVERNED BY THE LIMITATIONS OF TABLES 1 OR 2 NOTE:- EACH SPLICE & ASSOCIATED CABLES MUST BE COVERED BY AN INDIVIDUAL INSL. SLEEVE
			MS25190 -A-20 WIRE	AR	
			CSP 220 SLEEVE *	1 PER SPLICE	

* SEE PAGE 24

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TYPE	SYMBOL		HARDWARE	N ^o REQD	DESCRIPTION
	WIRING	CABLE			
4B			DSC44 SPlice CON	AR	
		OR 	M525190 -A-20 WIRE SLEEVE ADAPTER CSP 220 SLEEVE *	AR AR AR 1 PER SPlice	

* SEE PAGE 24

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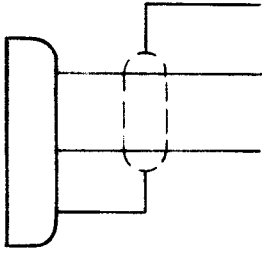
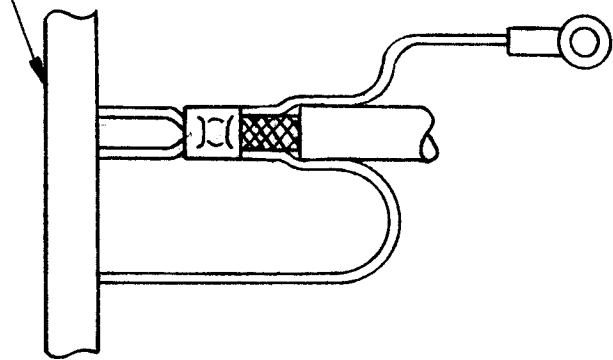
TYPE	SYMBOL		HARDWARE	N° REQD	DESCRIPTION
	WIRING	CABLE			
5			DSC 45 INNER SLEEVE DSC 46 OUTER SLEEVE MS25190 -A-20 WIRE CSP220 INS. SLEEVE *	1 1 AR 1 PER SHLD TERM	CONNECTOR, PLUG THIS METHOD MAY BE USED WITH MS-A, B, & C SERIES CONNECTORS TO ENABLE THE SHIELD TERMINATION TO BE CONTAINED WITHIN THE BACK SHELL OF THE CONNECTOR SEE DS55 FOR SELECTION OF: INNER, OUTER, & INS. SLEEVES.

* SEE PAGE 24

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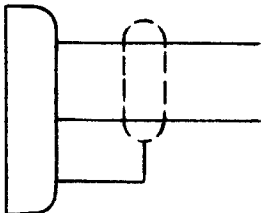
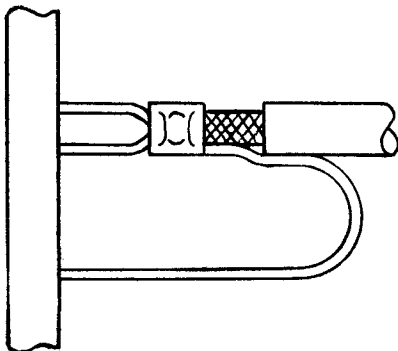
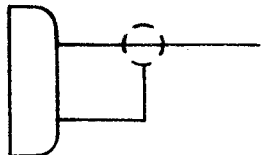
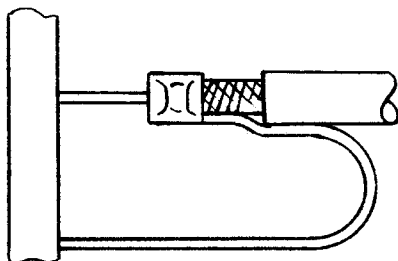
TYPE	SYMBOL		HARDWARE	NO REQD	DESCRIPTION
	WIRING	CABLE			
6			DSC 45 INNER SLEEVE DSC 46 OUTER SLEEVE MS25190 -A-20 WIRE MS25036 TERMINAL CSP220 INS. SLEEVE *	1 1 A/R 1 1	CONNECTOR, PLUG OR RECEPT.  TYP EXAMPLE OF THE USE OF INNER & OUTER SLEEVES FOR THE DUAL ROLE OF SHIELD TERMINAL & WIRE SPLICE SEE DS55 FOR SELECTION OF: INNER, OUTER, & INS. SLEEVES NOTE: RESTRICTED TO STATIC GROUNDS

* SEE PAGE 24

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TYPE	SYMBOL				DESCRIPTION
	WIRING	CABLE			
7			DSC 45 INNER SLEEVE	1 AR 1	CONNECTOR 
			DSC 46 OUTER SLEEVE		
			MS25190 -A-20 WIRE		
			CSP220 INS SLEEVE *		
					 SHIELD TERMINATION FOR SINGLE COND & TWISTED PAIR (TYP FOR TRIPLE TWISTED) AT A CONNECTOR PIN SEE DS55 FOR SELECTION OF INNER, OUTER & INS. SLEEVE

* SEE PAGE 24

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TYPE	SYMBOL		HARDWARE	N° REQD	DESCRIPTION
	WIRING	CABLE			
8			DSC 45 INNER SLEEVE	1	CONNECTOR
			DSC 46 OUTER SLEEVE	1	
			MS25190 -A-20 WIRE	AR	
			MS25036 TERMINAL	1	
			CSP220 INS SLEEVE	1	
			*		
					TYP SHIELD TERMINATION AT A GRD POINT - FOR CASES WHERE CONDUCTORS ARE ENCLOSED UNDER A COMMON BRAIDED SHIELD SEE DS 55 FOR SELECTION OF INNER, OUTER, & INS SLEEVES

* SEE PAGE 24

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TYPE	SYMBOL		HARDWARE	N ^o REQD	DESIGNATION
	WIRING	CABLE			
9			DSC 45 INNER SLEEVE DSC 46 OUTER SLEEVE MS25190 -A-20 WIRE MS25036 TERMINAL CSP220 INS SLEEVE *	1 1 AR 1	TYP FOR SHIELD TERMINATION AT A GRD POINT - FOR ADJACENT WIRES AT A TERMINAL BOARD SEE DS 55 FOR SELECTION OF: INNER, OUTER, & INS SLEEVES

* SEE PAGE 24

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TYPE	SYMBOL		HARDWARE	N ^o REQD	DESCRIPTION
	WIRING	CABLE			
10A			DSC 51 PARALLEL CON	1	CONNECTOR, PLUG OR RECEPT TYP FOR COMMON SHIELD PICK-UP AT ADJACENT SHIELDED CABLES METHOD MAY BE EXPANDED AS SHOWN IN TYPES 3 & 4
		CSP 220 INS SLEEVE *	1		
10B SEE NEXT SHEET			DSC 44 SPICE CON	1	 * SEE PAGE 24
			CSP 220 INS SLEEVE *	1	
			SEE DS55 FOR SELECTION OF INNER & OUTER SLEEVES & ASSOCIATED INS SLEEVES CONNECTOR OR T.B. TYP FOR COMMON SHIELD PICK-UP AT SEPARATED SHIELDED CABLES NOTE - THIS METHOD MAY BE USED FOR SHIELD TERMINATION AT A CONNECTOR PIN, T.B. OR GRD BY THE ADDITION OF AN EXTRA WIRE IN THE CAP- & TERM IF REQD		
DSC 45 INNER SLEEVE	1	DSC 46 OUTER SLEEVE	1		
MS 25274 CAP	1	MS 25190 -A-20 WIRE	AR		
CSP 220 INS SLEEVE *	2				

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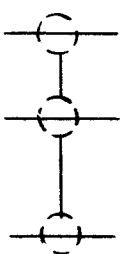
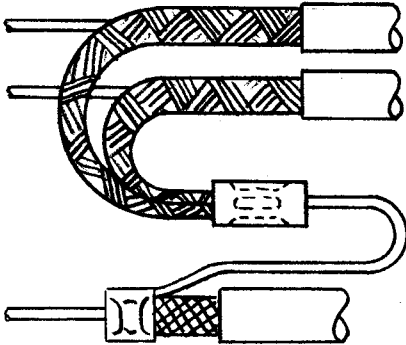
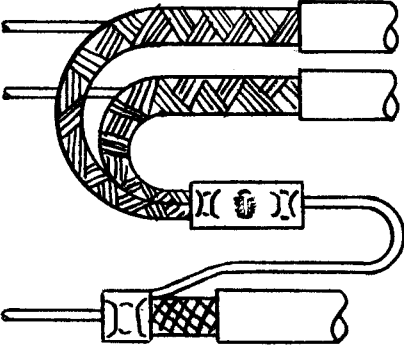
TYPE	SYMBOL		HARDWARE	NO REQD	DESCRIPTION
	WIRING	CABLE			
10B			DSC 45 INNER SLEEVE	1	SEE DS55 FOR SELECTION OF INNER & OUTER SLEEVES AND ASSOCIATED INS SLEEVE TYPICAL FOR COMMON SHIELD PICK UP AT SEPARATED SHIELDED CABLES. NOTE: THIS METHOD MAY BE USED FOR SHIELD TERMINATION AT A CONNECTOR PIN, T.B., OR GRD BY THE ADDITION OF AN EXTRA WIRE IN THE CON & TERM. IF REQD.
			DSC 46 OUTER SLEEVE	1	
			DSC 51 PARALLEL CON	1	
			MS25190 -A-20 WIRE	AR	
			CSP 220 INS SLEEVE *	3	

* SEE PAGE 24

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TYPE	SYMBOL		HARDWARE	Nº REQD	DESCRIPTION
	WIRING	CABLE			
10C	 	DS51 PARALLEL CON	1		
		MS25190 -A-20 WIRE	AR		
		DS45 INNER SLEEVE	1		
		DS46 OUTER SLEEVE	1		
		CSP220 INS SLEEVE *	2		
		DS44 SPlice CON	1		
		ADAPTER	1		
		MS25190 -A-20 WIRE	AR		
		DS45 INNER SLEEVE	1	TYP FOR COMMON SHIELD PICK-UP AT A COMBINATION OF ADJACENT & SEPARATED CABLES	
		DS46 OUTER SLEEVE	1		NOTE 1: (1) ONE CSP220 INS SLEEVE OVER SPlice & CABLE WHOSE SHIELDS ARE POKED OUT. (2) ONE CSP220 INS SLEEVE OVER SEPARATED CABLE(S)
		CSP220 INS SLEEVE *	2		

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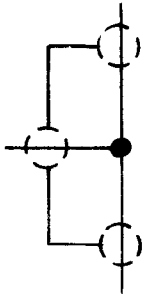
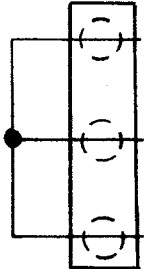
B.C. BEASLEY

TERMINATION AND/OR SPLICES
OF WIRES AND CABLES

DS54



STANDARDS SHEET

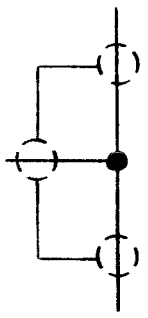
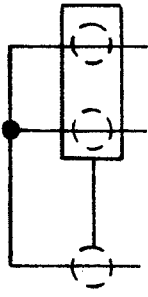
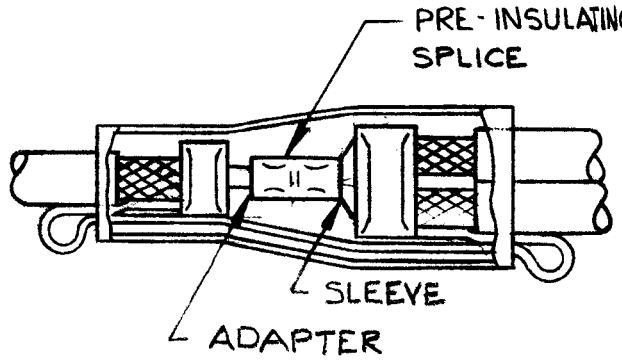
TYPE	SYMBOL		HARDWARE	NO REQD	DESCRIPTION
	WIRING	CABLE			
IIA			DSC 45 INNER SLEEVE	1	CONNECTOR, PLUG OR RECEPT. →  INSIDE BOX - TYP FOR COMMON SHIELD TERMINATION AT 3 WIRE SPLICE SEE DSC 55 FOR SELECTION OF INNER & OUTER SLEEVES
			DSC 46 OUTER SLEEVE	1	
			SLEEVE	1	
			CAP MS25274	1	
			CSP220- INS. SLEEVE *	1	
					

SEE PAGE 24

DRAWN	BL. BEASLEY	7/65	CLASSIFICATION	STANDARD
CHECKED	W.H.		TERMINATION AND/OR SPLICES OF WIRES AND CABLES	DS54
STRESSED				
APPROVED	BL. BEASLEY			



STANDARDS SHEET

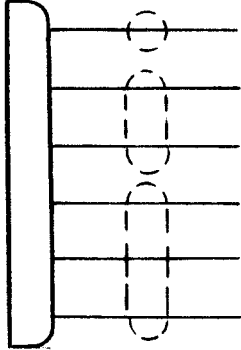
TYPE	SYMBOL		HARDWARE	Nº REQD	DESCRIPTION
	WIRING	CABLE			
IIC			DSC45 INNER SLEEVE	1	 PRE-INSULATING SPLICE SLEEVE ADAPTER CABLE - TYP FOR COMMON SHIELD TERMINATION AT 3 WIRE SPLICE TYPICAL FOR SPLICE IN WIRES SUPPORTED BY CABLE
			DSC46 OUTER SLEEVE	1	
			SLEEVE MS25181-	1	
			SPLICE CONN	1	
			ADAPTER	1	
			MS25190 -A-20 WIRE	AR	
			CSP220 INS SLEEVE	1	
			*		

* SEE PAGE 24

DRAWN	STUART 5/7/65	CLASSIFICATION	STANDARD
CHECKED	<i>[Signature]</i>	TERMINATION AND/OR SPLICES OF WIRES AND CABLES	DS54
STRESSED			
APPROVED	B.C. BEASLEY		



STANDARDS SHEET

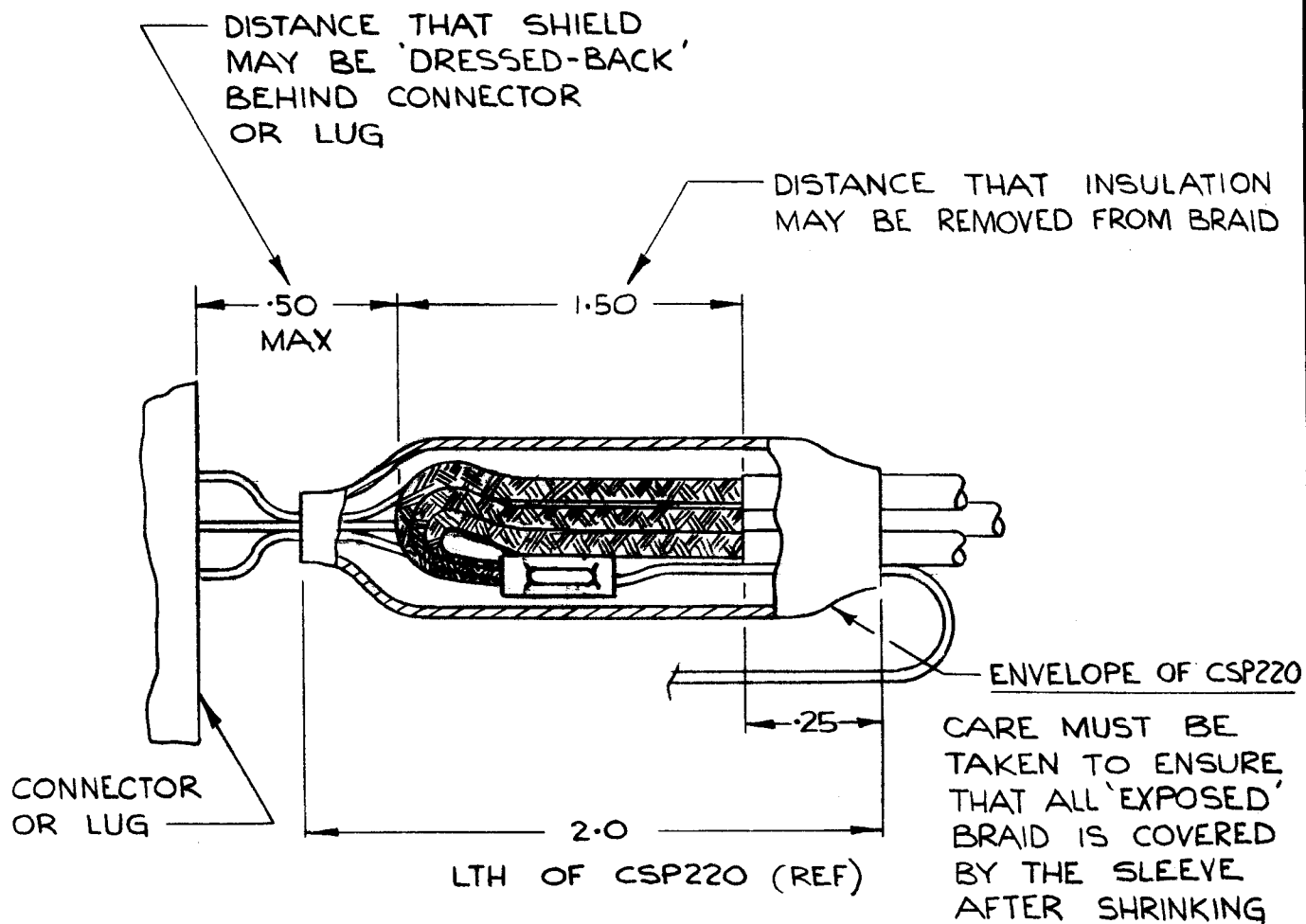
TYPE	SYMBOL		HARDWARE	N° REQD	DESCRIPTION
	WIRING	CABLE			
12			CSP 220 INS SLEEVE *	1 1 1	TERMINATION OF FLOATING SHIELDS TYPICAL FOR SINGLE SHIELDED, TWISTED PAIR OR TRIPLE SHIELDED CABLE  SEE DS55 FOR SLEEVE SELECTION

* SEE PAGE 24

DRAWN	RJ. STUART 2/7/65	CLASSIFICATION	STANDARD
CHECKED	<i>W.H.M.</i>	TERMINATION AND/OR SPLICES OF WIRES AND CABLES	DS54
STRESSED			
APPROVED	B.C. BEASLEY		



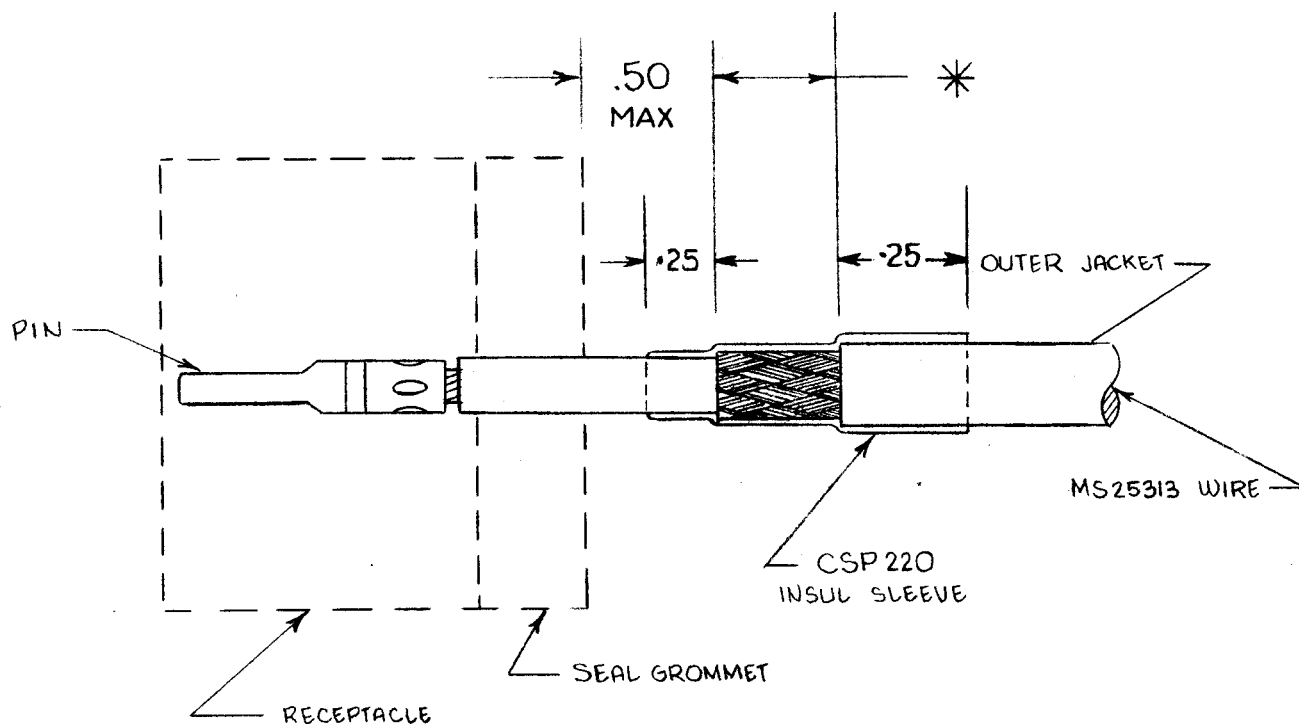
STANDARDS SHEET

INSTL. OF CSP220 INS. SLEEVES

DRAWN	RJSTUART 13/7/65	CLASSIFICATION	STANDARD
CHECKED	<i>W.H.</i>	TERMINATION AND/OR SPLICES OF WIRES AND CABLES	DS 54
STRESSED			
APPROVED	B.L. BEASLEY		



STANDARDS SHEET



* STRIP OUTER JACKET AND PULL BACK THE BRAID A SUFFICIENT DISTANCE TO ALLOW USE OF A PIN INSERTION TOOL. WHEN PIN IS IN RECEPTACLE, THE BRAID IS TO BE PUSHED FORWARD AND A CSP 220 SLEEVE HEAT SHRUNK INTO PLACE AS SHOWN.

MULTIPLE CONDUCTOR WIRES ARE TO BE ASSEMBLED IN A SIMILAR MANNER

DRAWN	DE HAVILLAND	CLASSIFICATION	STANDARD
CHECKED	UNPUBLISHED	TERMINATION AND/OR SPLICES OF WIRES AND CABLES	DS-54
STRESSED			
APPROVED	B.C.B.		