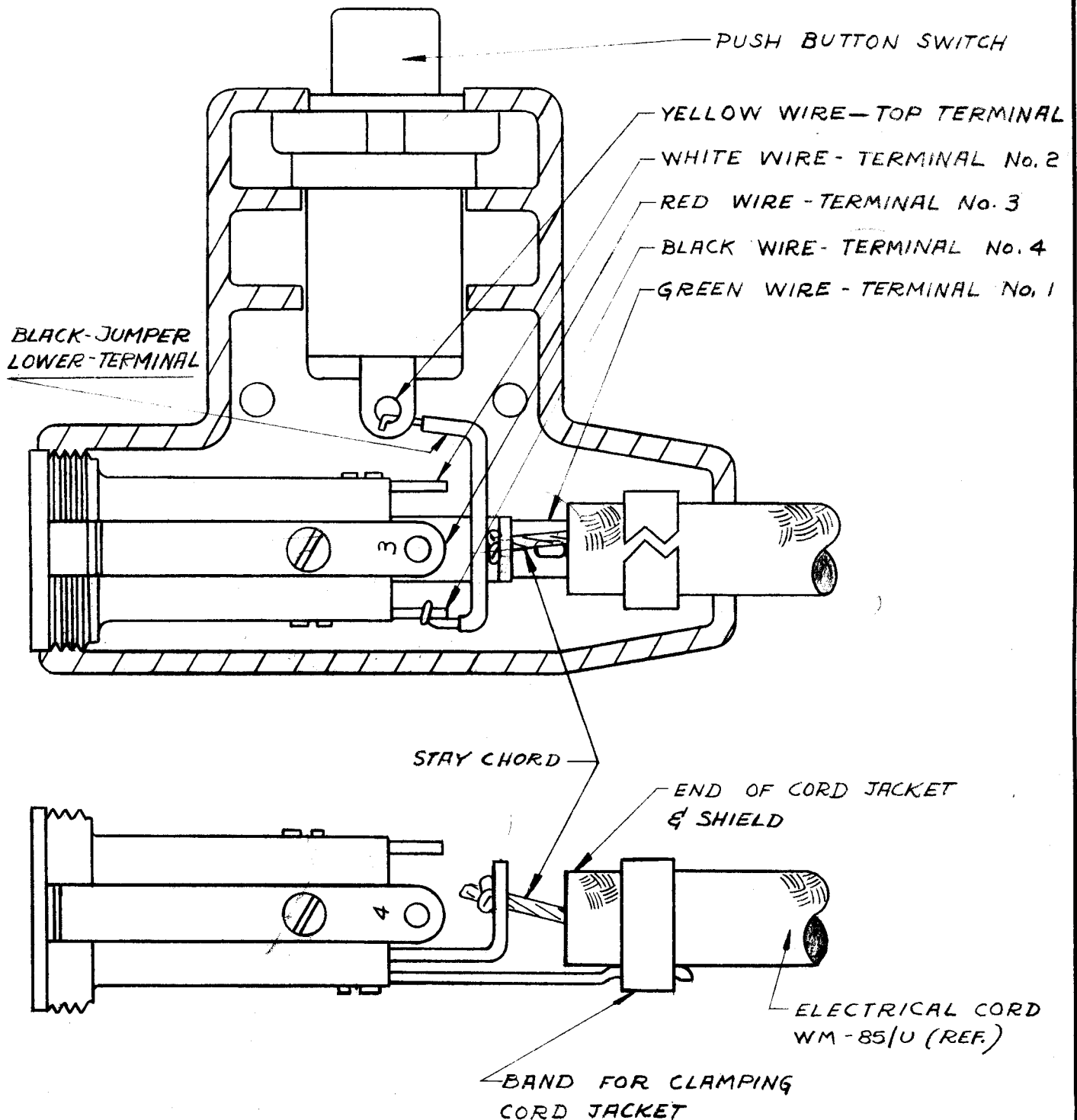




STANDARDS SHEET



PLUG CONNECTOR U-94 A/U DETAILS & WIRE CONNECTIONS

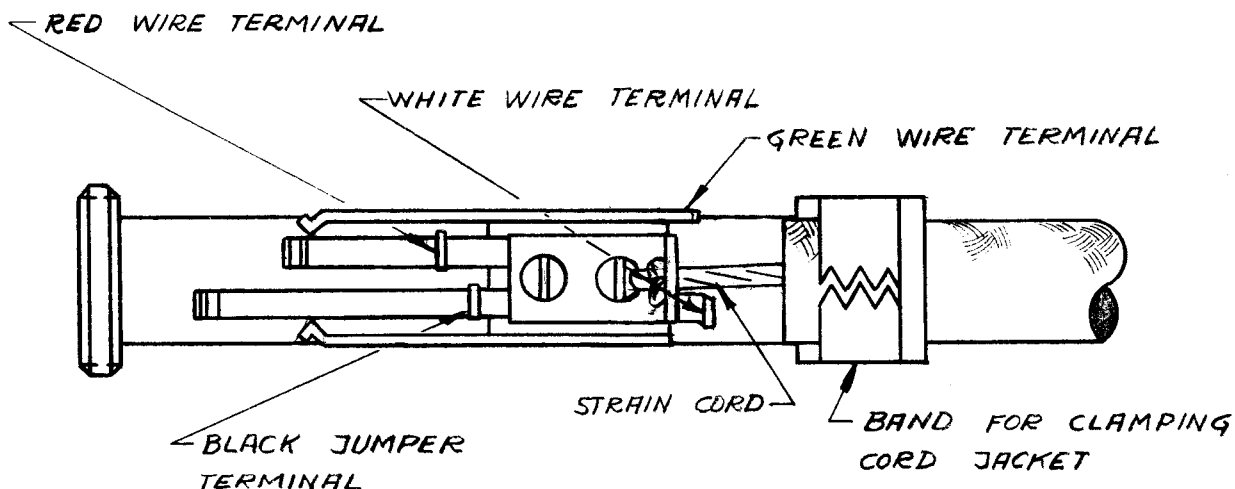
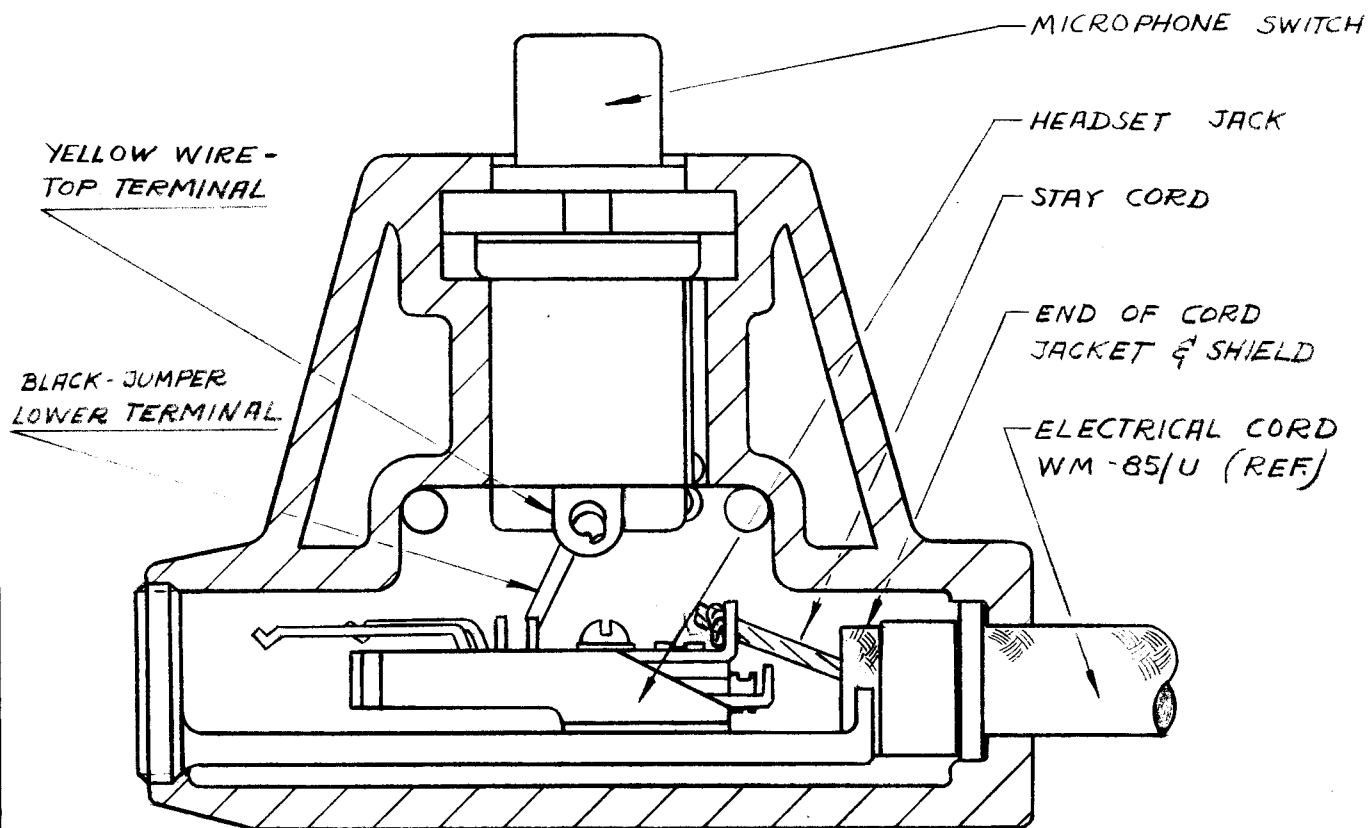
DRAWN	S. SHREVE	CLASSIFICATION	STANDARD
CHECKED	W. H. MCKENNA	CABLING DETAILS	DS-59
STRESSED		MICROPHONE & HEADSET CABLES	
APPROVED	<i>[Signature]</i>	JACKS & CONNECTORS	

REV. 4 NOV. 4/63

EMC 71867



STANDARDS SHEET

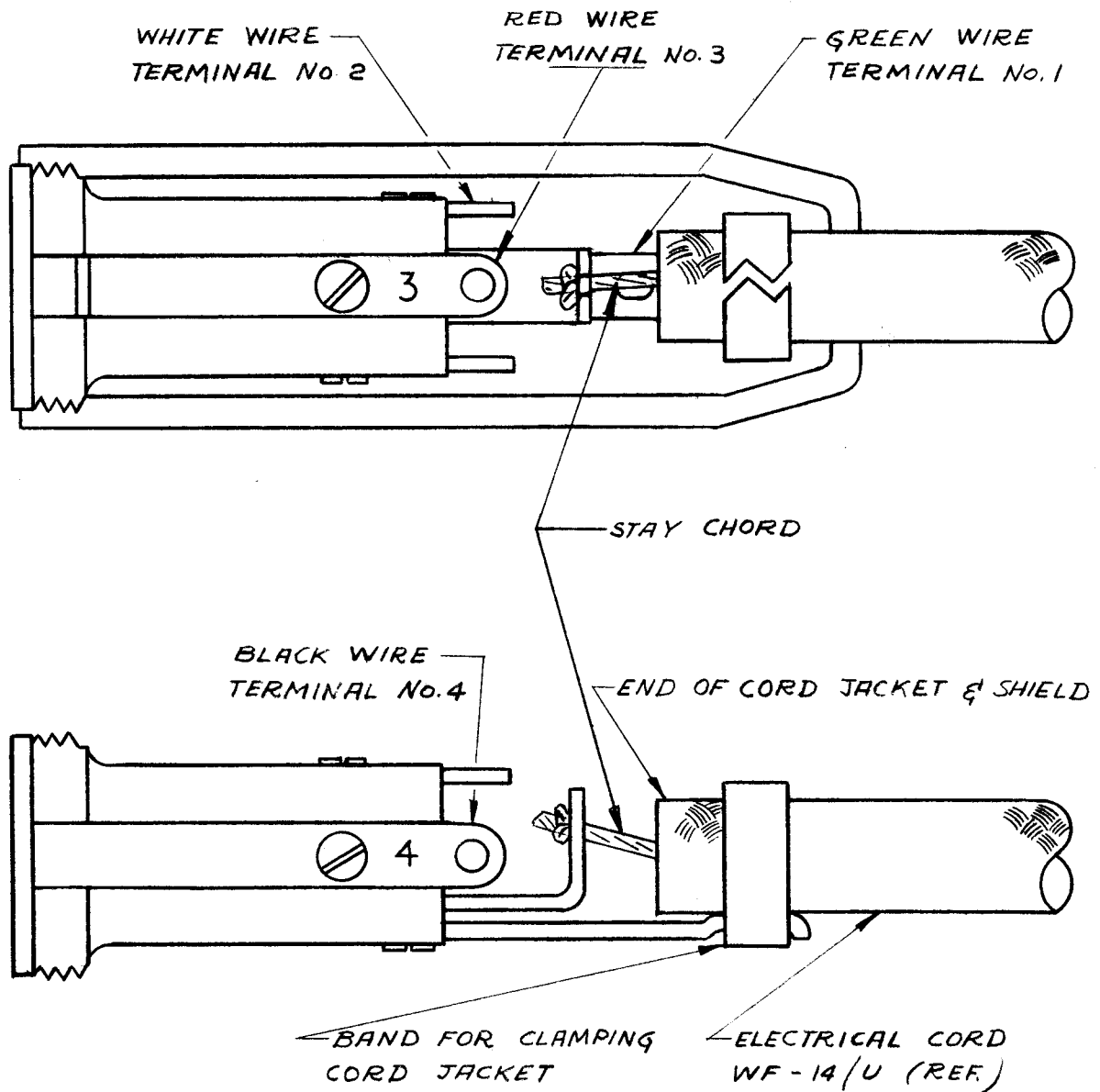


PLUG CONNECTOR U-94/U DETAILS & WIRE CONNECTIONS

DRAWN	S. SCHRATNER	CLASSIFICATION	STANDARD
CHECKED	W. H. KENNEDY	<u>CABLING DETAILS</u> MICROPHONE & HEADSET CABLES JACKS & CONNECTORS	DS-59
STRESSED			
APPROVED			
Rushby NOV. 4/63		FMC 71867	



STANDARDS SHEET



PLUG CONNECTOR U-92A/U DETAILS & WIRE CONNECTIONS

DRAWN	S. SCHRATTNER	CLASSIFICATION	STANDARD
CHECKED	W. H. HICKSON	<u>CABLING DETAILS</u>	DS-59
STRESSED		MICROPHONE & HEADSET CABLES	
APPROVED	<i>[Signature]</i>	JACKS & CONNECTORS	

Rusty NOV. 4/63

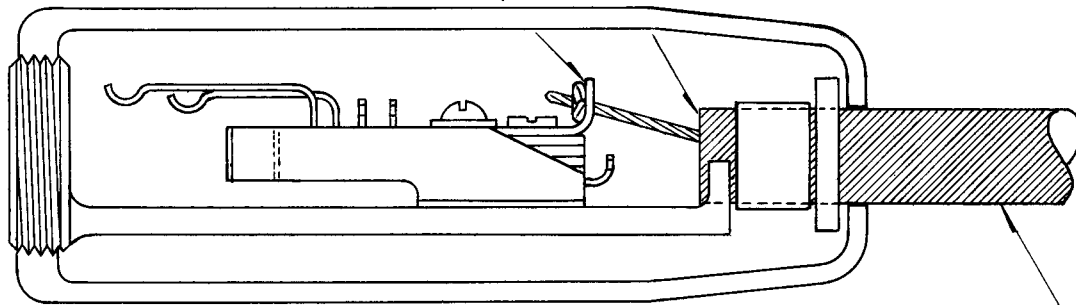
FMC 71867



STANDARDS SHEET

STAY CORD HOOK ON TO ANCHOR SLOT

END OF CORD JACKET & SHIELD CONDUCTOR

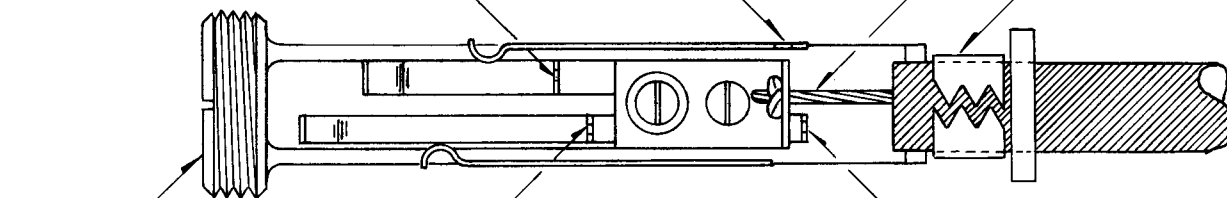
WF-14/U ELECTRICAL CORD
(REF)

GREEN WIRE TERMINAL

CLAMPING BAND SECURING
ELECTRICAL CORD JACKET

RED WIRE TERMINAL

STAY CORD



JACK

WHITE WIRE TERMINAL

BLACK WIRE TERMINAL

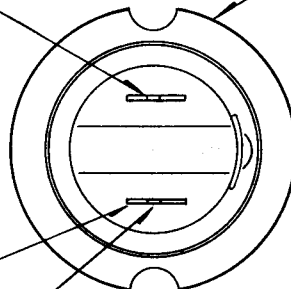
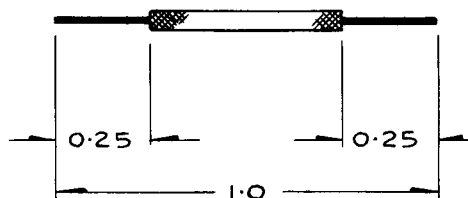
Plug Connector U-92/U Details and Wire Connections

DRAWN	SEUNG OCT 63	CLASSIFICATION	STANDARD
CHECKED	WHM/KC/WW	CABLING DETAILS	
STRESSED		Microphone and Headset Cables	DS - 59
APPROVED	<i>[Signature]</i>	Jacks and Connectors	
NOV. 4/63		FMC 71867	



STANDARDS SHEET

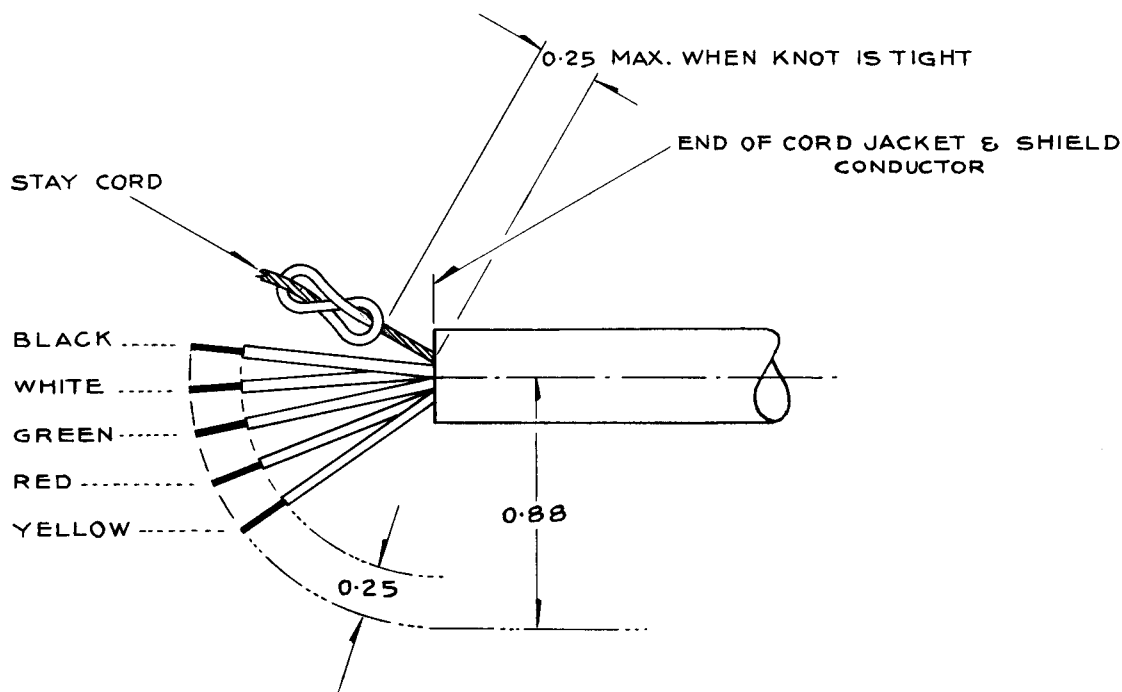
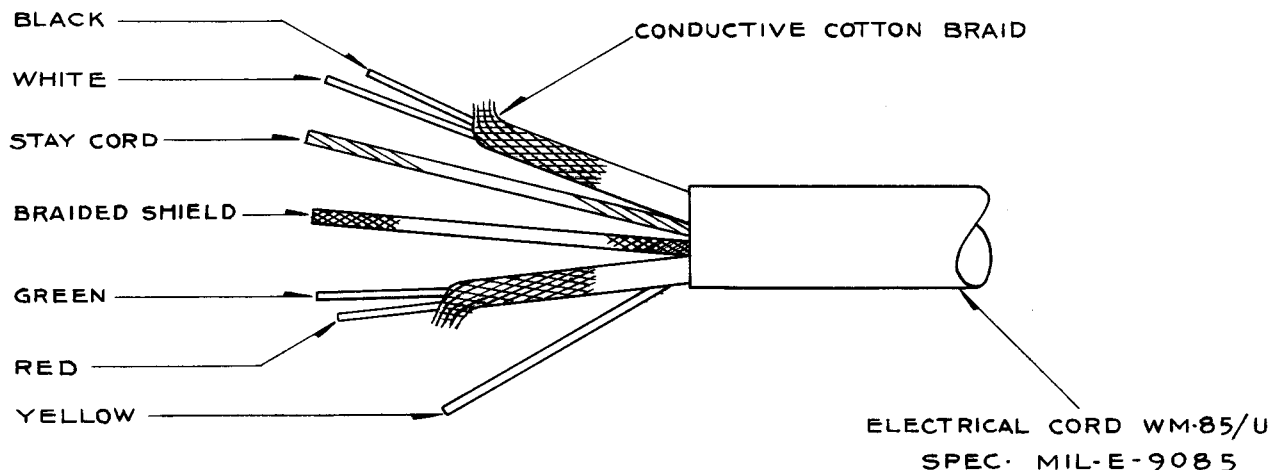
TERMINAL FOR YELLOW WIRE

MICROPHONE SWITCH
(PUSH-BUTTON TYPE)VIEW LOOKING AT
TERMINAL ENDSFOR U-94-A/U
TERMINAL FOR BLACK JUMPERFOR U-94/U
TERMINAL FOR BLACK WIRE
AND BLACK JUMPERMICROPHONE SWITCHBLACK JUMPER

Microphone Switch and Jumper Details

DRAWN -	SFGUNG SEP. 63	CLASSIFICATION	STANDARD
CHECKED	W.H. HARRINGTON	CABLING DETAILS	
STRESSED		Microphone and Headset Cables	DS - 59
APPROVED	<i>[Signature]</i>	Jacks and Connectors	
Revised Nov. 4/63		FMC 71867	

STANDARDS SHEET



Stripping Details For WM-85/U Electric Cord
For Jack U-94A/U
(See Page 11)

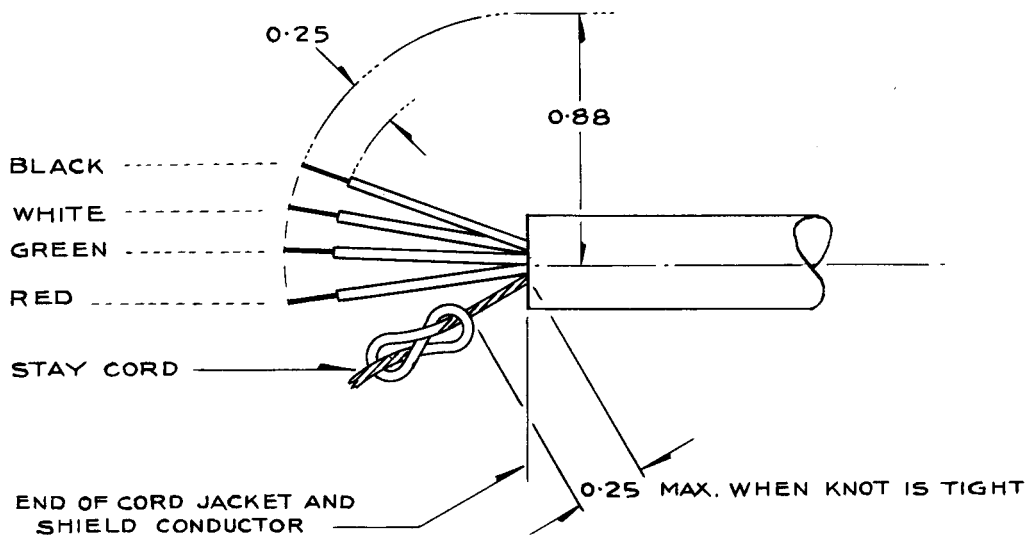
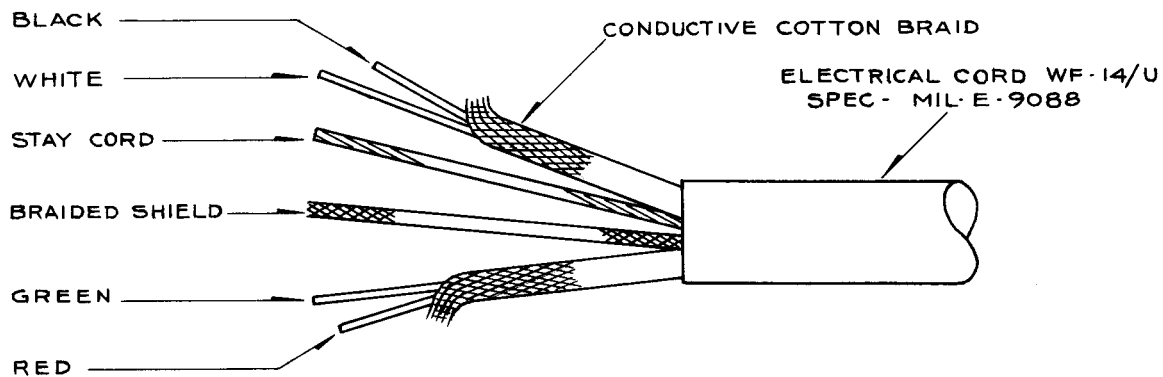
DRAWN — SEUNG SEP 63	CLASSIFICATION	STANDARD
CHECKED W.H. McKEOWN	CABLING DETAILS	
STRESSED	Microphone and Headset Cables	DS - 59
APPROVED 	Jacks and Connectors	

Nov. 4/63

FMC 71867



STANDARDS SHEET



Stripping Details For WF-14/U Electric Cord
For Jack U-92A/U
(See Page 11)

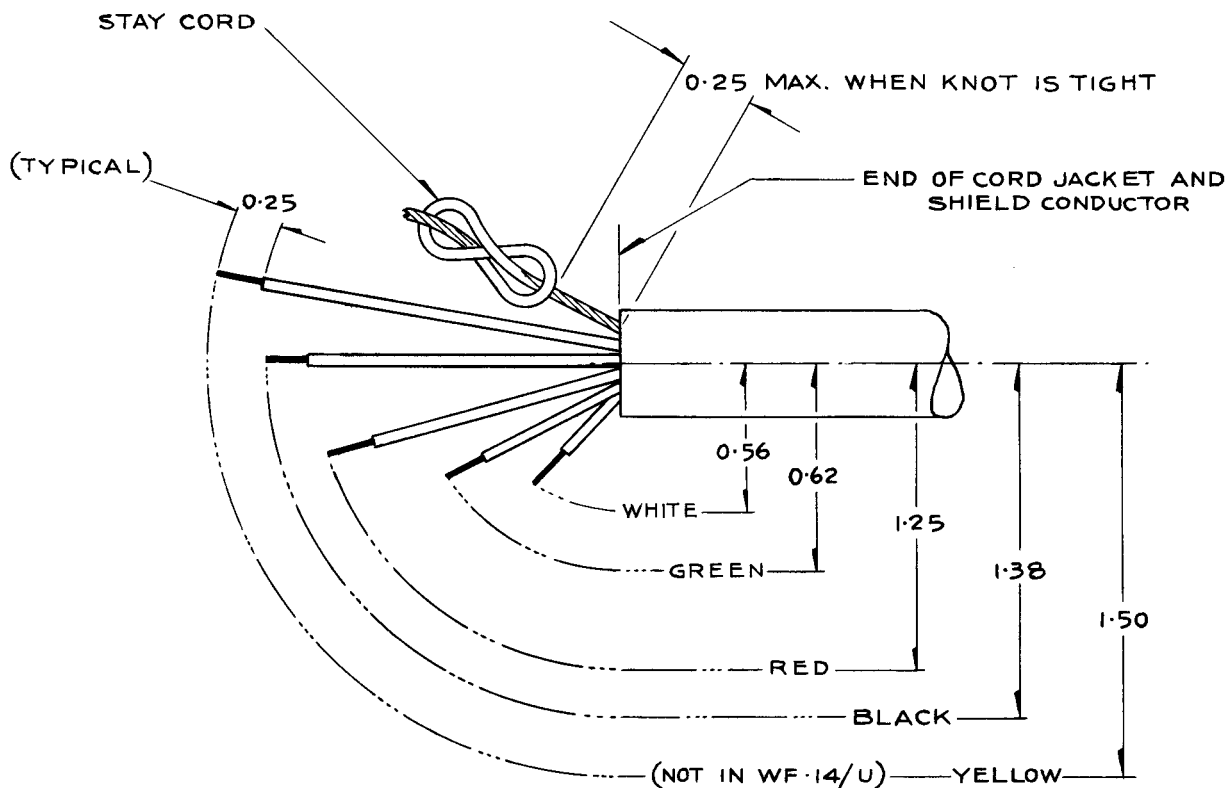
DRAWN	DATE	CLASSIFICATION	STANDARD
CHECKED	W.H. MCKEOWN	CABLING DETAILS	
STRESSED		Microphone and Headset Cables	DS - 59
APPROVED		Jacks and Connectors	

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STANDARDS SHEET



CONDUCTOR	CONNECTIONS
GREEN	TIP (MICROPHONE LOW)
RED	RING (MICROPHONE HIGH)
WHITE	RING (HEADSET HIGH)
BLACK	SWITCH (HEADSET LOW)
BLACK JUMPER	SLEEVE & SWITCH
YELLOW	SWITCH (MICROPHONE SWITCH)
SHIELD	NO CONNECTION (MICROPHONE SHIELD)

Stripping Details For WF-14/U and WM-85/U Electric Cords
 For Old Style Jacks U-92/U and U-94/U
 (See Page 12)

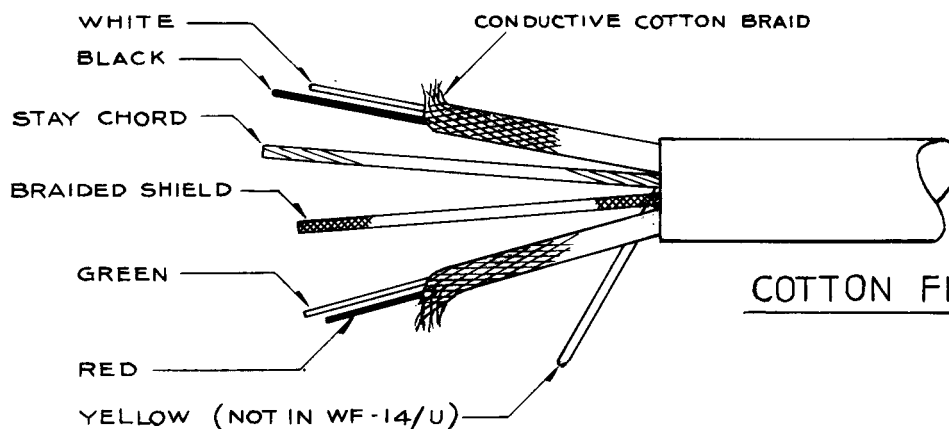
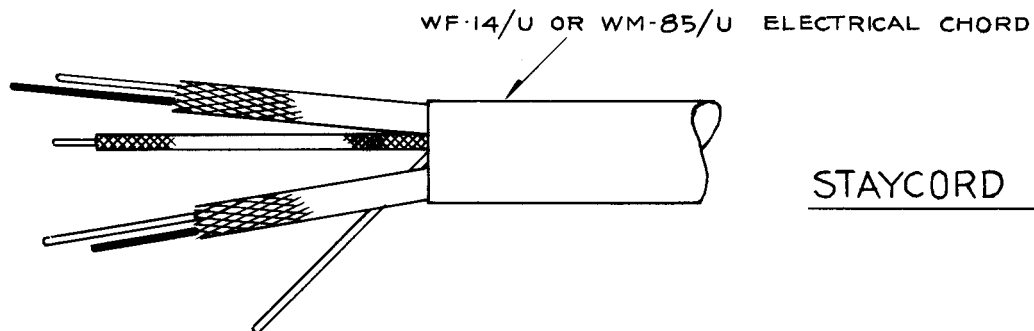
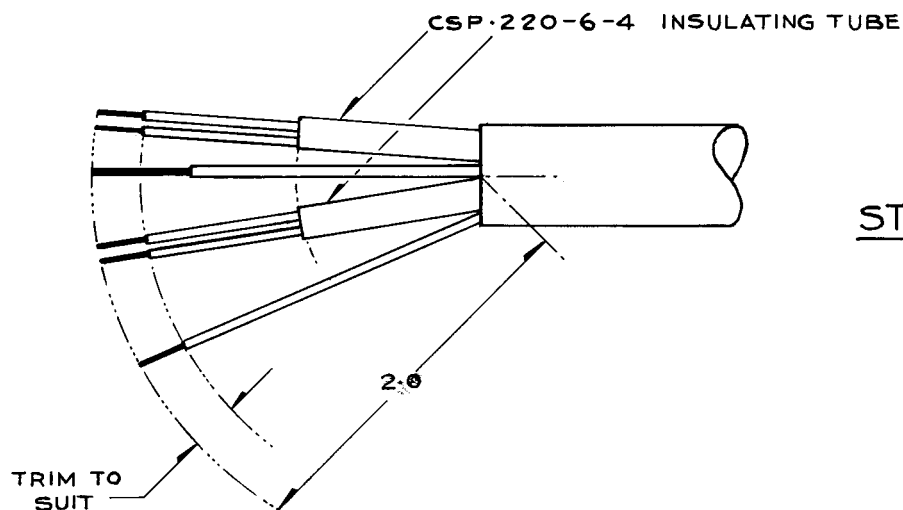
DRAWN	SPUNG SEP 63	CLASSIFICATION	STANDARD
CHECKED	W.H.M. KEOH	CABLING DETAILS	
STRESSED		Microphone and Headset Cables	DS - 59
APPROVED	<i>[Signature]</i>	Jacks and Connectors	

[Signature] Nov. 4/63

FMC 71867



STANDARDS SHEET

COTTON FILLER REMOVEDSTAYCORD REMOVEDSTRIPPING DETAILS

Stripping Details For WF-14/U and WM-85/U Electric Cords
For Connector and Terminal Blocks
(See Page 12)

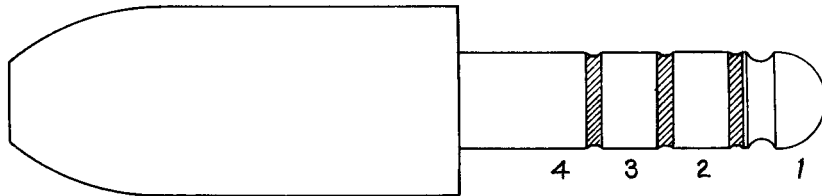
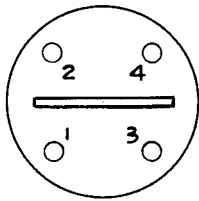
DRAWN -	SPGUNG SEP 63	CLASSIFICATION	STANDARD
CHECKED	WHMCKEOWN	CABLING DETAILS	
STRESSED		Microphone and Headset Cables	DS - 59
APPROVED	<i>[Signature]</i>	Jacks and Connectors	

[Signature] NOV. 4/63

FMC 71867



STANDARDS SHEET



TERMINAL	CONDUCTOR	CONNECTIONS
1	GREEN	TIP (MICROPHONE LOW)
2	WHITE	RING (HEADSET HIGH)
3	RED	RING (MICROPHONE HIGH)
4	BLACK	SLEEVE (HEADSET LOW)
	SHIELD	NO CONNECTION

Connection Details For U-93A/U Plug

DRAWN —	STG — OCT 63	CLASSIFICATION	STANDARD
CHECKED	W. H. YCKEDWY	CABLING DETAILS	
STRESSED		Microphone and Headset Cables	DS - 59
APPROVED	<i>[Signature]</i>	Jacks and Connectors	
Lump, NOV. 4/63		FMC 71867	



STANDARDS SHEET

ELECTRICAL CORD END PREPARATIONFOR U-92A/U AND U-94A/U JACKS

- A. TRIM 2 INCHES OFF THE OUTER JACKET FROM THE END OF THE ELECTRIC CORD WM-85/U or WF-14/U.
- B. PUSH BACK THE END OF OUTER JACKET AT LEAST 1/16 INCH AND TRIM, THE COTTON FILLER AND THE BLACK CONDUCTIVE COTTON COVERING ON EACH PAIR OF TWISTED WIRES, AT THE END OF THE OUTER JACKET, ALSO CUT THE SHIELD BRAID OFF AT THE END OF OUTER JACKET.
- C. ALLOW THE OUTER JACKET TO SLIDE BACK TO ITS ORIGINAL POSITION. THIS IS NECESSARY TO ENSURE THAT THE CONDUCTIVE COTTON AND THE SHIELD BRAID DO NOT TOUCH ANY PART OF THE JACK CONNECTIONS.
- D. TRIM AND STRIP THE WIRE INSULATION AS SHOWN ON PAGE 7 FOR JACKS U-92A/U, AND ON PAGE 6 FOR JACKS U-94A/U. FOR OLD STYLE JACKS U-92/U AND U-94/U TRIM AND STRIP TO PAGE 8.
- E. THE COTTON STAY CORD IS TO BE STRETCHED BEFORE TIEING THE KNOT TO ENSURE THAT NO STRAIN WILL BE IMPOSED ON THE WIRES AFTER SOLDERING AND ASSEMBLY. WHEN THE STAY CORD IS SUITABLY TIED, TRIMMED AND INSERTED IN THE ANCHOR SLOT THERE SHALL BE NO STRAIN ON THE CONDUCTORS WHEN A PULL OF 20 POUNDS IS APPLIED TO THE ELECTRICAL CORD TENDING TO SEPARATE IT FROM THE JACK.
- F. THE END OF THE ELECTRICAL CORD IS TO BE SECURED TO THE JACK WITH THE CLAMPING BAND OVER THE OUTER JACKET AS SHOWN.
- G. THE ENDS OF WIRES SHALL BE TINNED PRIOR TO SOLDERING.
- H. ALL CONNECTIONS SHALL BE SOLDERED TO THE PROPER TERMINALS AS SHOWN ON PAGES 1-2-3-4 & 5.

DRAWN		CLASSIFICATION	STANDARD
CHECKED	W.H. McKEOWN	<u>CABLING DETAILS</u> Microphone and Headset Cables - Jacks and Connectors	DS-59
STRESSED			
APPROVED			

Nov. 2/62

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STANDARDS SHEET

ELECTRICAL CORD END PREPARATIONFOR CONNECTORS AND TERMINAL BLOCKS

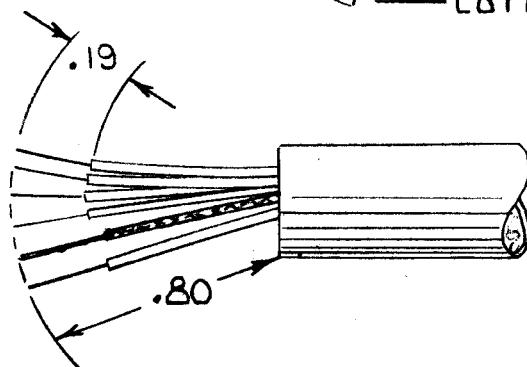
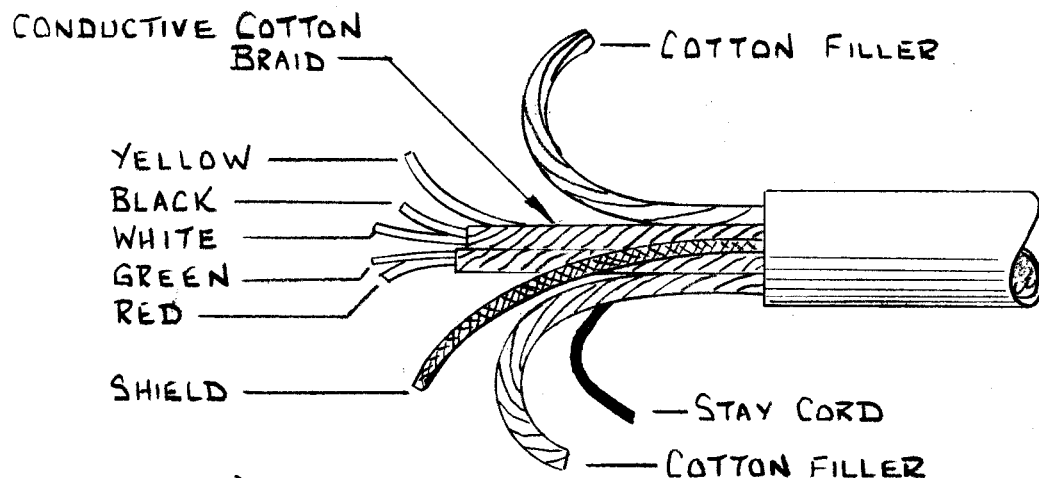
- A. TRIM 2 INCHES OFF THE OUTER JACKET FROM THE END OF ELECTRIC CORD WM-85/U OR WF-14/U.
- B. TRIM COTTON FILLER AND STAY CORD, OFF AT THE END OF OUTER JACKET. DO NOT DISTURB THE BLACK CONDUCTIVE COTTON COVERING ON THE TWISTED PAIRS AT THIS STAGE.
- ① C. GENTLY LOOSEN AND EASE BACK THE BRAID OVER THE COTTON CORE. CUT OFF 1/2 INCH OFF THE EXPOSED CORE. RETURN THE BRAID EXTENDING AND COMPRESSING WHERE THE CORE WAS REMOVED.
- D. SLIDE A GSP-220-6-4 HEAT SHRINKABLE TUBE OVER THE BLACK CONDUCTIVE COVERING ON EACH TWISTED PAIR AND HEAT SHRINK INTO PLACE BUTTED TIGHT AGAINST END OF OUTER JACKET. TRIM OFF EXCESS BLACK COVERING AT OUTER END OF INSULATION TUBE, AS SHOWN ON PAGE 9.
- E. TRIM ENDS OF INDIVIDUAL CONDUCTORS TO PROPER LENGTH TO SUIT CONNECTOR PIN OR TERMINAL USED.
- F. SEE PAGES 13 & 14 RESPECTIVELY - FOR END PREPARATION OF WM-85/U INTERPHONE CORD WHEN USED WITH U-79/U RECEPTACLE AND U-77/U PLUG.

DRAWN		CLASSIFICATION	STANDARD
CHECKED	W.H. McKEOWN	CABLING DETAILS	
STRESSED		Microphone and Headset Cables - Jacks and Connectors	DS-59
APPROVED			

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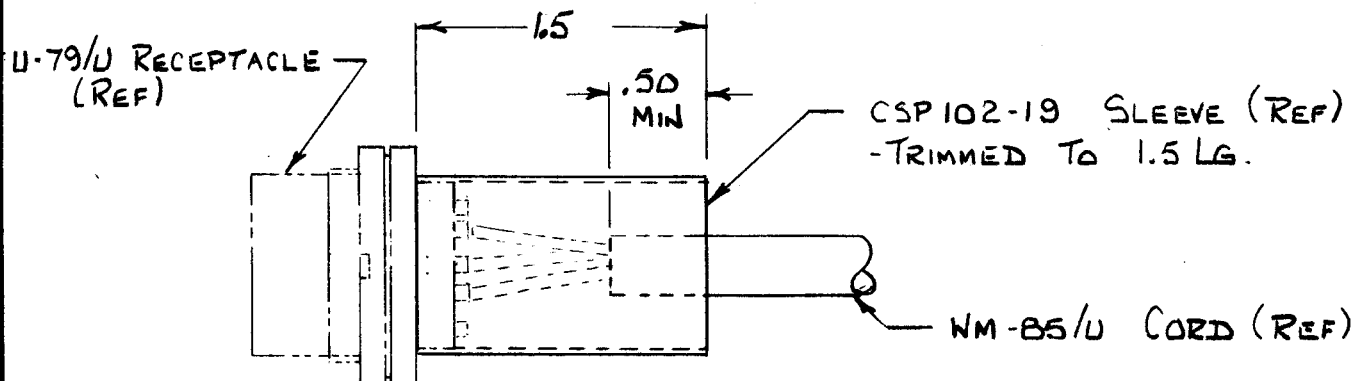
17 Dec 63
 DRN: CAYGILL
 CHK:
 APP: B. C. BOWLER

STANDARDS SHEET

STRIPPING DETAILS

PREPARE END OF SHIELD
AS SPECIFIED ON PAGE 12
PARA. 'C'

COTTON FILLER, STAYCORD
& CONDUCTIVE COTTON BRAID
TO TERMINATE AT OUTER JACKET
TERMINATION. COLOURED WIRES
& SHIELDING FINISH AS ABOVE.



CABLE END TO BE POTTED IN ACCORDANCE WITH PPS. 9.05 ISS. 1
AMEND. 2

END PREPARATION & POTTING FOR WM-BS/U INTERPHONE CORD WHEN
USED WITH U-79/U EXTERNAL RECEPTACLE.

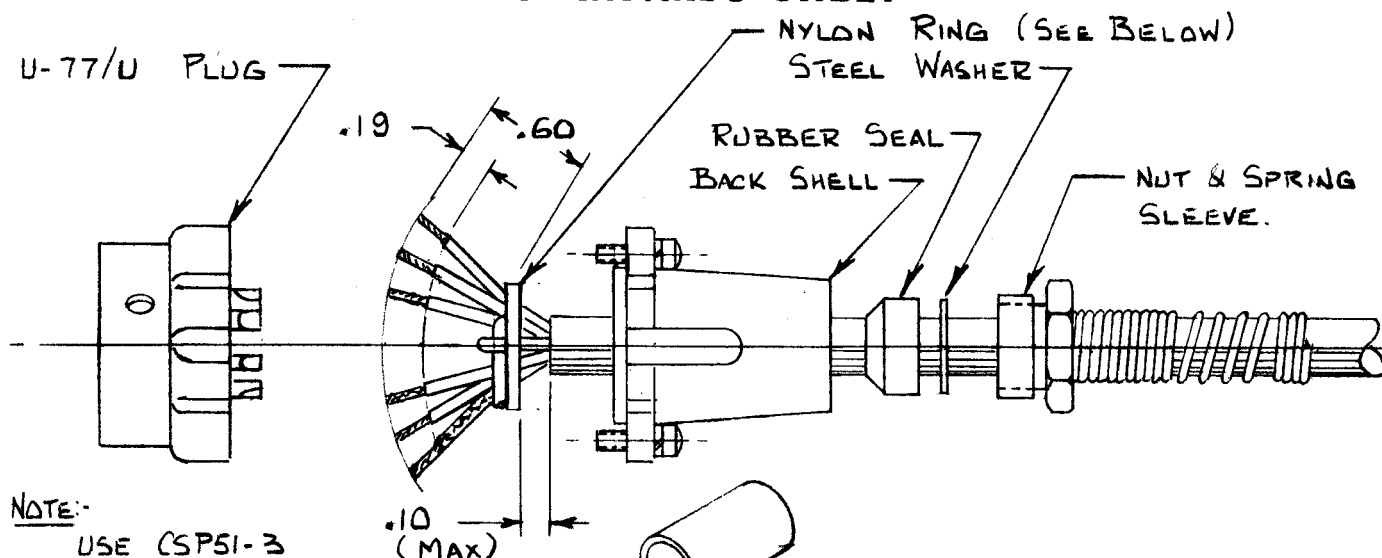
DRAWN	J.R. CAYGILL	CLASSIFICATION	STANDARD
CHECKED	W.H. MCKEOWN	CABLING DETAILS	DS 59
STRESSED		MICROPHONE & HEADSET CABLES	
APPROVED		JACKS AND CONNECTORS	

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15 JUL 63
17 DEC 63
DRN - CAYGILL
CKD - W.H. MCKEOWN
APP - B.C. DEAN



STANDARDS SHEET

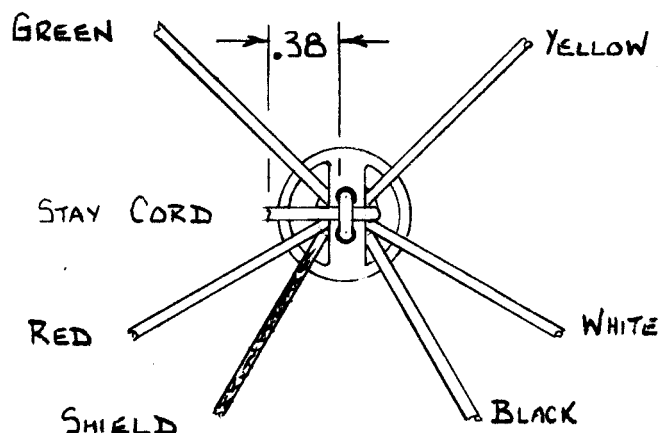


NOTE:-

USE CPSI-3
INSUL. SLEEVE OVER
SHIELD & ASSOCIATED
PIN.

METHOD OF SECURING
STAY CORD TO NYLON RING

NOTE:- STAY CORD ONLY,
SHOWN FOR CLARITY.



METHOD OF THREADING
CONDUCTOR THRU NYLON RING

STRIPPING DETAILS:- PREPARE END
OF SHIELD AS SPECIFIED ON PAGE 12
PARA 'C'

COTTON FILLER & CONDUCTIVE
COTTON TO TERMINATE AT OUTER
JACKET TERMINATION.

COLOURED WIRES & SHIELD
TRIM & TERMINATE AS SHOWN
ABOVE.

END PREPARATION & ASSY OF WM-85/U INTERPHONE CORD WHEN
USED WITH U-77/U PLUG.

DRAWN	J.R. CAYGILL	CLASSIFICATION	STANDARD
CHECKED	W.H. McKOWN	CABLING DETAILS	DS 59
STRESSED		MICROPHONE & HEADSET CABLES	
APPROVED	B.C. BEASLEY	JACKS AND CONNECTORS	

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