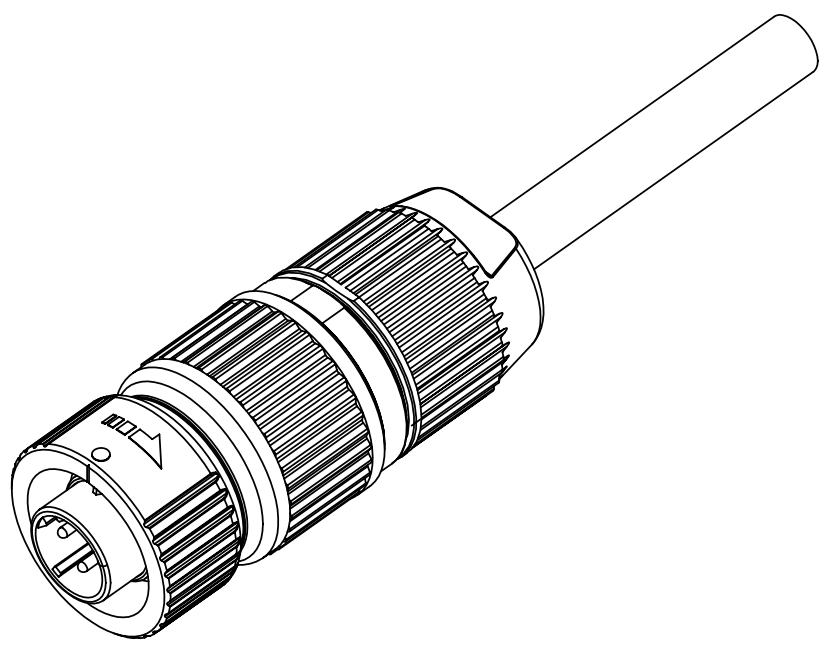
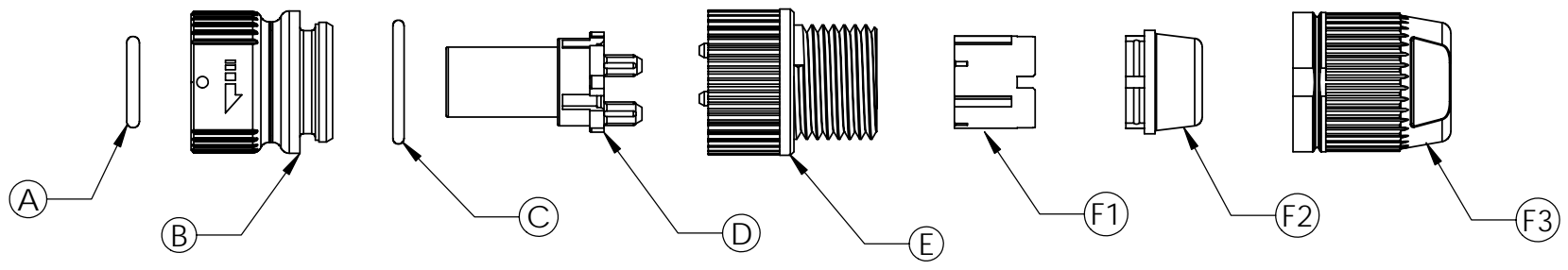


8 7 6 5 4 3 2



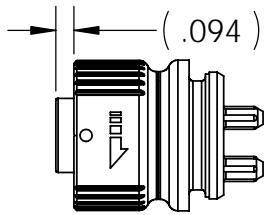
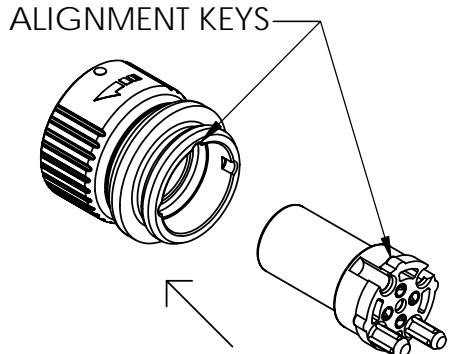
ITEM	P/N	DESCRIPTION	
A	103033	INTERFACE SEAL (ORANGE)	
B	107855-XX	HOUSING ASSY	
C	107997	HARAX SEAL (GREEN)	
D	107998	INSULATOR ASSY	
E	107995	BACKSHELL ASSY	
F1	107996	TERMINATION KIT	SPLICING
F2			SEAL
F3			COLLET

				TOLERANCES U.O.S UNITS - INCHES DECIMAL TOL. .XX ±.010 .XXX ±.005 ANGLES ± 3°		MATERIAL N/A		DRAWN & DATE DAS 12/16/04		ALDEN PRODUCTS COMPANY 117 N. MAIN ST., BROCKTON, MA 02301-3996 PHONE: (508)-427-7000	
				FILLETS & RADII TO BE .03 MOLDED DRAFT 6° P/S MAX.		FINISH N/A		CHECK & DATE GN 12/17/04		DRAWING TITLE ASSEMBLY INSTRUCTIONS PULSE PLUS PLUG	
				CTF = CRITICAL TO FUNCTION GD&T PER ANSI Y14.5				APPR'D & DATE MS 12/20/04		DRAWING NO. AI-PULSE PLUS-1	
- ORIGINAL ISSUE, DAS		12/20/04		MS				MFG. & DATE		REV. -	
REV.	DESCRIPTION OF CHANGE			DATE	APPR.	FLAT	Φ 001/IN	A SIZE	SHT NO. 1 OF 5 SCALE 1:1		
						PERP	Φ 001/IN				
						PARA	Φ 001/IN				

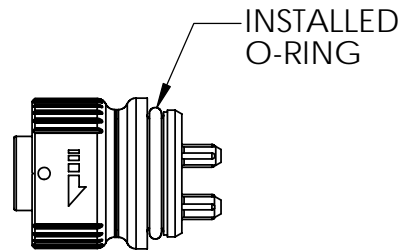
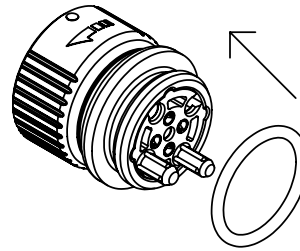
8 7 6 5 4 3 2 1

*THIS DOCUMENT IS TO BE USED ONLY TO THE BENEFIT OF ALDEN PRODUCTS CO., IS TO BE KEPT PRIVATE & CONFIDENTIAL, & IS NOT TO BE COPIED EXCEPT ON WRITTEN AUTHORIZATION OF ALDEN PRODUCTS CO.

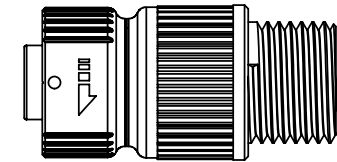
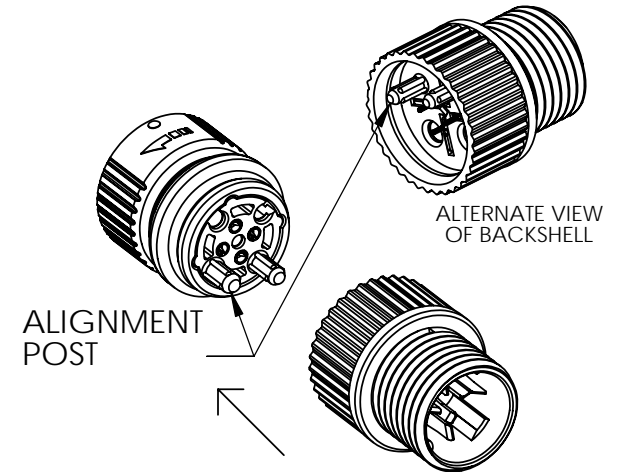
STEP 1.
ORIENT ALIGNMENT KEYS AND SLOTS ON HOUSING ASSY (B) AND INSULATOR ASSY (D) AND PRESS INTO PLACE. DISTANCE FROM FACE OF HOUSING ASSY (B) TO FACE OF INSULATOR ASSY (D) IS APPROXIMATELY .094".



STEP 2.
ASSEMBLE HARAX SEAL (C) ONTO BACK OF HOUSING ASSY (B).



STEP 3.
ORIENT ALIGNMENT POSTS AND HOLES ON INSULATOR ASSY (D) AND BACKSHELL ASSY (E) AND PRESS ONTO HOUSING ASSY (B). THERE SHOULD BE NO GAP BETWEEN HOUSING ASSY (B) AND BACKSHELL ASSY (E).



TOLERANCES U.O.S
UNITS - INCHES
DECIMAL TOL.
.XX ±.010
.XXX ±.005
ANGLES ± 3°

FILLETS & RADII TO BE .03
MOLDED DRAFT 6° P/S MAX.

CTF = CRITICAL TO FUNCTION

GD&T PER ANSI Y14.5

∠	FLAT	∅ 001/IN
⊥	PERP	∅ 001/IN
//	PARA	∅ 001/IN

MATERIAL

SEE SHEET 1

FINISH

SEE SHEET 1

DRAWN & DATE

SEE SHEET 1

CHECK & DATE

SEE SHEET 1

APPR'D & DATE

SEE SHEET 1

MFG. & DATE

ALDEN

PRODUCTS COMPANY

117 N. MAIN ST., BROCKTON, MA 02301-3996
PHONE: (508)-427-7000

DRAWING TITLE

**ASSEMBLY INSTRUCTIONS
PULSE PLUS PLUG**

A

SHT NO.
2 OF 5

DRAWING NO.

AI-PULSE PLUS-1

REV.

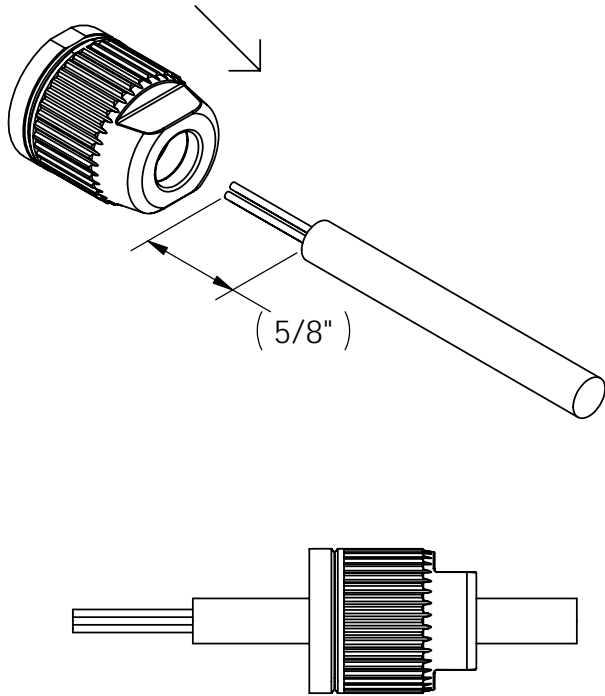
-

SEE SHEET 1

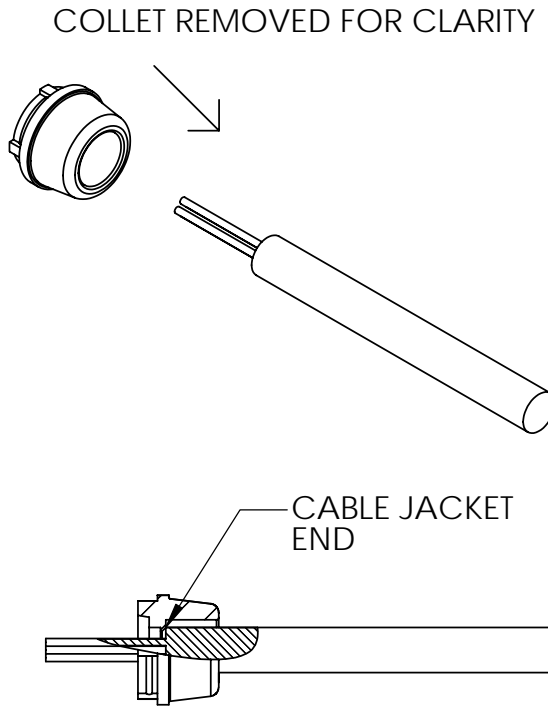
REV. DESCRIPTION OF CHANGE DATE APPR.

*THIS DOCUMENT IS TO BE USED ONLY TO THE BENEFIT OF ALDEN PRODUCTS CO., IS TO BE KEPT PRIVATE & CONFIDENTIAL, & IS NOT TO BE COPIED EXCEPT ON WRITTEN AUTHORIZATION OF ALDEN PRODUCTS CO.

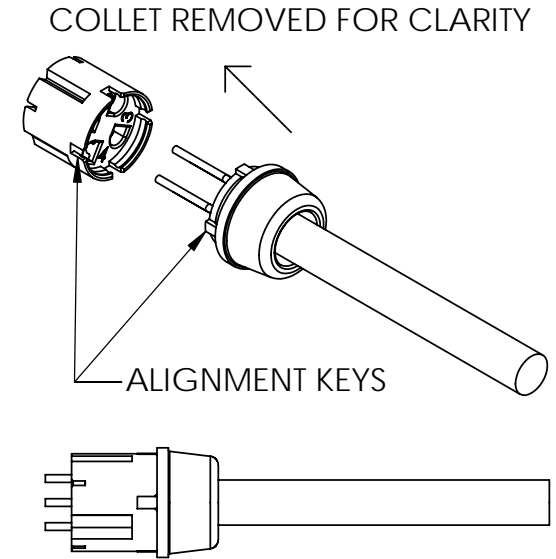
STEP 4.
STRIP CABLE JACKET 5/8" AND
SLIDE COLLET (F3) OVER CABLE.



STEP 5.
FEED CONDUCTORS THROUGH SEAL (F2)
AND PUSH UNTIL END OF CABLE JACKET IS
BUTTED UP AGAINST THE SEAL (F2). SEE
PARTIAL SECTION.



STEP 6.
FEED INDIVIDUAL CONDUCTORS
THROUGH THE APPROPRIATE HOLES IN
THE SPLICING (F1). ORIENT
ALIGNMENT KEYS AND SLOTS ON THE
SEAL (F2) AND THE SPLICING (F1)
AND SNAP TOGETHER. HOLD PRESSURE
ON THE CABLE JACKET AND SEAL SO
CABLE IS NOT PUSHED BACK.



TYPICAL WIRING

POSITION	COLOR
1	YELLOW
2	WHITE
3	ORANGE
4	BLUE

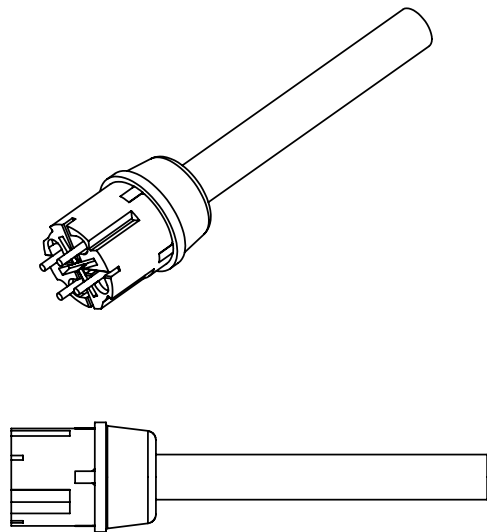


REAR VIEW

				TOLERANCES U.O.S UNITS - INCHES DECIMAL TOL. .XX ±.010 .XXX ±.005 ANGLES ± 3°		MATERIAL SEE SHEET 1		DRAWN & DATE SEE SHEET 1		ALDEN PRODUCTS COMPANY 117 N. MAIN ST., BROCKTON, MA 02301-3996 PHONE: (508)-427-7000	
				FILLETS & RADII TO BE .03				CHECK & DATE SEE SHEET 1		DRAWING TITLE ASSEMBLY INSTRUCTIONS PULSE PLUS PLUG	
				MOLDED DRAFT 6° P/S MAX.		FINISH SEE SHEET 1		APPR'D & DATE SEE SHEET 1			
				CTF = CRITICAL TO FUNCTION				MFG. & DATE		DRAWING NO. AI-PULSE PLUS-1	
SEE SHEET 1				GD&T PER ANSI Y14.5						REV. -	
REV.	DESCRIPTION OF CHANGE			DATE	APPR.	FLAT PERP PARA	Φ 001/IN Φ 001/IN Φ 001/IN	A SIZE		SHT NO. 3 OF 5 SCALE 1:1	
*THIS DOCUMENT IS TO BE USED ONLY TO THE BENEFIT OF ALDEN PRODUCTS CO., IS TO BE KEPT PRIVATE & CONFIDENTIAL, & IS NOT TO BE COPIED EXCEPT ON WRITTEN AUTHORIZATION OF ALDEN PRODUCTS CO.											

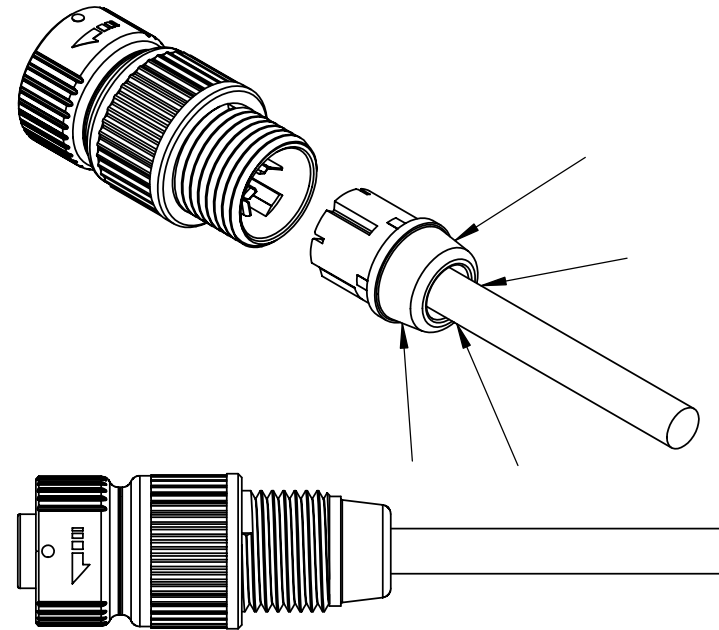
STEP 7.
TRIM INDIVIDUAL CONDUCTORS FLUSH WITH
END OF SPLICING (F1).

COLLET REMOVED FOR CLARITY



STEP 8.
ORIENT ALIGNMENT KEYS AND SLOTS ON THE BACKSHELL ASSY (E)
AND THE SPLICING (F1). PRESS SPLICING (F1) INTO BACKSHELL
ASSY (E). HOLD PRESSURE ON THE CABLE JACKET AND SEAL (F2) SO
CABLE IS NOT PUSHED BACK. THIS WILL TERMINATE ALL CONDUCTORS.

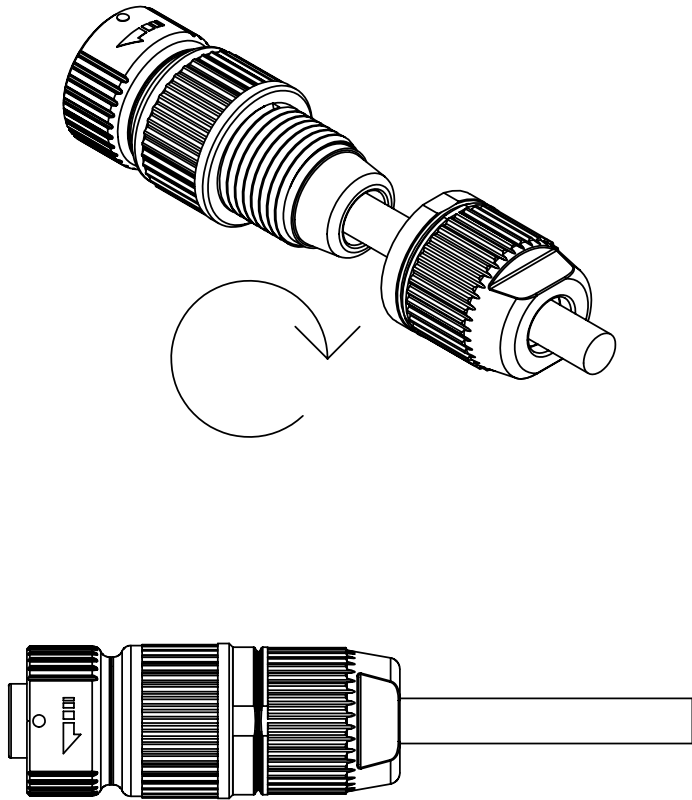
COLLET REMOVED FOR CLARITY



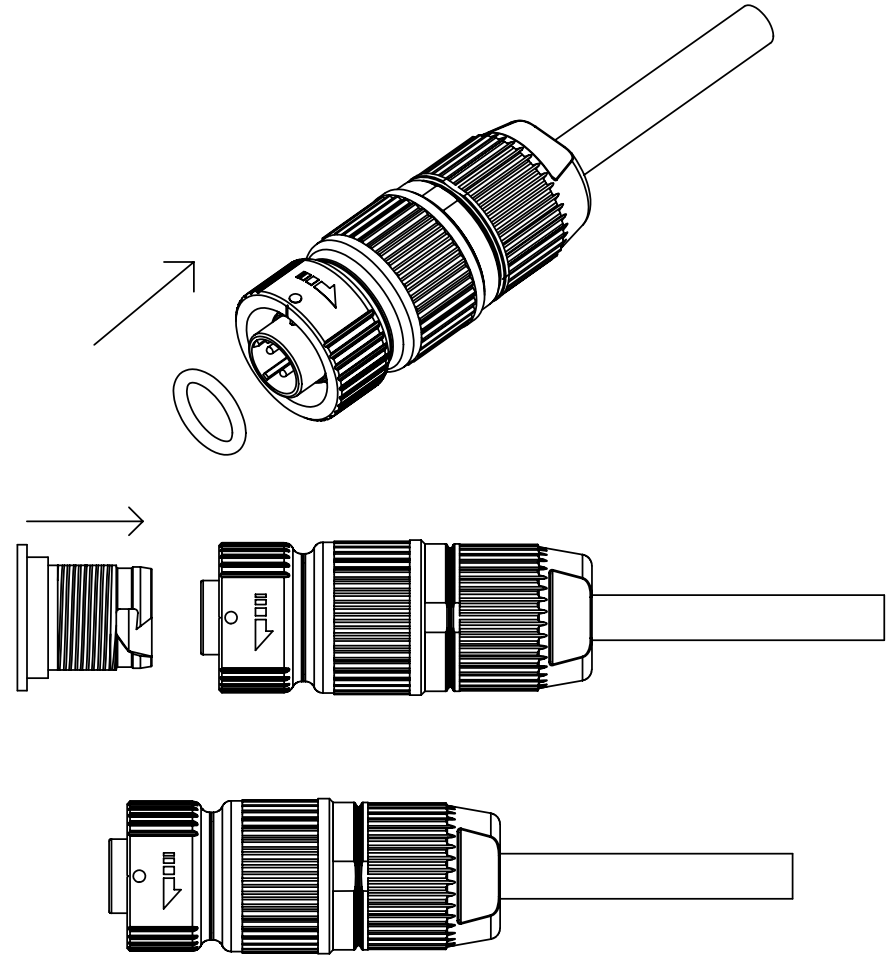
A

				TOLERANCES U.O.S UNITS - INCHES DECIMAL TOL. .XX ±.010 .XXX ±.005 ANGLES ± 3°		MATERIAL SEE SHEET 1		DRAWN & DATE SEE SHEET 1		ALDEN PRODUCTS COMPANY 117 N. MAIN ST., BROCKTON, MA 02301-3996 PHONE: (508)-427-7000	
				FILLETS & RADII TO BE .03		FINISH SEE SHEET 1		CHECK & DATE SEE SHEET 1		DRAWING TITLE ASSEMBLY INSTRUCTIONS PULSE PLUS PLUG	
				MOLDED DRAFT 6° P/S MAX.		GD&T PER ANSI Y14.5		APPR'D & DATE SEE SHEET 1		DRAWING NO. AI-PULSE PLUS-1	
				CTF = CRITICAL TO FUNCTION		SEE SHEET 1		MFG. & DATE		REV. -	
SEE SHEET 1		DESCRIPTION OF CHANGE		DATE		APPR.		A SIZE		SHT NO. 4 OF 5 SCALE 1:1	
REV.		DESCRIPTION OF CHANGE		DATE		APPR.		A SIZE		SHT NO. 4 OF 5 SCALE 1:1	
*THIS DOCUMENT IS TO BE USED ONLY TO THE BENEFIT OF ALDEN PRODUCTS CO., IS TO BE KEPT PRIVATE & CONFIDENTIAL, & IS NOT TO BE COPIED EXCEPT ON WRITTEN AUTHORIZATION OF ALDEN PRODUCTS CO.											

STEP 9.
 SLIDE COLLET (F3) UP CABLE AND THREAD ONTO BACKSHELL ASSY(E). TIGHTEN UNTIL THERE IS NO GAP. USE SOFT-GRIP PLIERS TO GRASP BACKSHELL ASSY (E) AND 13mm WRENCH ON COLLET (F3).



STEP 10.
 SLIDE INTERFACE SEAL (A) OVER NOSE OF THE INSULATOR ASSY (D) AND MANIPULATE UNTIL IT IS LOCATED BELOW THE ARROWS ON THE INSIDE OF HOUSING ASSY (B). MATE WITH A PULSE PLUS RECEPTACLE AND THE INTERFACE SEAL (A) WILL BE FULLY SEATED.



TOLERANCES U.O.S UNITS - INCHES DECIMAL TOL. .XX ±.010 .XXX ±.005 ANGLES ± 3°		
FILLETS & RADII TO BE .03		
MOLDED DRAFT 6° P/S MAX.		
CTF = CRITICAL TO FUNCTION		
GD&T PER ANSI Y14.5		
□	FLAT	∅ .001/IN
⊥	PERP	∅ .001/IN
//	PARA	∅ .001/IN

<u>MATERIAL</u>	<u>DRAWN & DATE</u> SEE SHEET 1
SEE SHEET 1	<u>CHECK & DATE</u> SEE SHEET 1
<u>FINISH</u>	<u>APPR'D & DATE</u> SEE SHEET 1
SEE SHEET 1	<u>MFG. & DATE</u>

ALDEN PRODUCTS COMPANY 117 N. MAIN ST., BROCKTON, MA 02301-3996 PHONE: (508)-427-7000	
DRAWING TITLE ASSEMBLY INSTRUCTIONS PULSE PLUS PLUG	
A SIZE	SHT NO. 5 OF 5 SCALE 1:1
DRAWING NO. AI-PULSE PLUS-1	REV. -

SEE SHEET 1	DESCRIPTION OF CHANGE	DATE	APPR.
REV.	DESCRIPTION OF CHANGE	DATE	APPR.
*THIS DOCUMENT IS TO BE USED ONLY TO THE BENEFIT OF ALDEN PRODUCTS CO., IS TO BE KEPT PRIVATE & CONFIDENTIAL, & IS NOT TO BE COPIED EXCEPT ON WRITTEN AUTHORIZATION OF ALDEN PRODUCTS CO.			