



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**SHIELDED CABLES**

**TABLE OF CONTENTS**

<b><u>PARAGRAPH</u></b>		<b><u>PAGE</u></b>
<b>1.</b>	<b><u>GENERAL DATA</u></b>	<b>2</b>
	A. High Energy Impulses	2
	B. Functions of a Shield	2
	C. Functions of a Shielded Cable	2
	D. Configurations of Shielded Cable	3
<b>2.</b>	<b><u>PROCEDURES TO ATTACH A SHIELDED CABLE TO AN ELECTRICAL CONNECTOR</u></b>	<b>3</b>
	A. Connection of a Shield to the Connector Strain Relief	3
	B. Connection of a Shield to the Connector Backshell through a Faying Surface Bond	4
<b>3.</b>	<b><u>RELATED DATA IN OTHER SWPM SUBJECTS</u></b>	<b>5</b>
	A. Bonding and Grounding of Electrical Connectors	5
	B. Faying Surface Bond	6
	C. Overall Shield Termination	6
	D. Strain Relief Shield Termination	6
	E. Peripheral Shield Termination	6
	F. Shield Braid Retainer Strip Termination	6
	G. Connector Assembly	6

**20-25-00**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**SHIELDED CABLES**

This Subject gives the general data about:

- The functions of a shielded cable in the aircraft
- The configurations of a shielded cable
- The procedures to attach a shield to an electrical connector
- Related data in other subjects of the Standard Wiring Practices Manual (SWPM).

**1. GENERAL DATA**

**A. High Energy Impulses**

It is necessary to keep a high energy impulse out of a wire on the aircraft because:

- It can be read, in error, as data by the electronic equipment on the aircraft
- It can cause damage to the electronic equipment that is connected to the wires.

**B. Functions of a Shield**

A shield supplies the necessary protection for the wires and the equipment when it transmits the unwanted energy from the conductors in the shield to the electrical ground through these routings:

- From the shield to the plug connector strain relief to the plug connector backshell
- From the plug connector backshell to the plug connector
- From the plug connector to the receptacle connector
- From the receptacle connector to the ground of the aircraft structure.

The shield on a shielded cable only does its function correctly when these conditions occur:

- There is a low electrical impedance at each interface in the routing
- The length of the connection between the interfaces is short; the more sensitive the electrical circuit is, the shorter the connection between the shield and the backshell must be
- The shield coverage is in proportion to the sensitivity of the electrical circuits that the shield protects; very sensitive electrical circuits must have 100 percent coverage and less sensitive electrical circuits can have less than 100 percent coverage.

**C. Functions of a Shielded Cable**

A shielded cable does not let:

- The high energy, electrical impulses, that are caused by lightning, go into the wires in the shield
- The high intensity radio frequency (HIRF) energy from the different radio sources that are external to the aircraft go into the wires in the shield
- The radio frequency energy from the different electrical and electronic sources in the aircraft go into the wires in the shield
- The radio frequency energy from the wires in the shield come out and cause the incorrect performance of other equipment or systems on the aircraft.

**20-25-00**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**SHIELDED CABLES**

**D. Configurations of Shielded Cable**

A shielded cable is an electrical cable that has a conductive shield around the wires in the cable. Usually, the conductive shield is metal.

Different shielded cables have shields that are made with:

- Braided, round conductors
- Braided, flat conductors
- Wrapped, round conductors
- Wrapped, flat conductors
- Wrapped, foil conductor
- A mixture of the braided or wrapped conductors.

Some shielded cables:

- Have one layer of shield material
- Have more than one layer of shield material
- Have insulation on top of the shield
- Do not have insulation on top of the shield
- Have insulation between the shields.

**2. PROCEDURES TO ATTACH A SHIELDED CABLE TO AN ELECTRICAL CONNECTOR**

There are 2 usual procedures.

**A. Connection of a Shield to the Connector Strain Relief**

Refer to Figure 1.

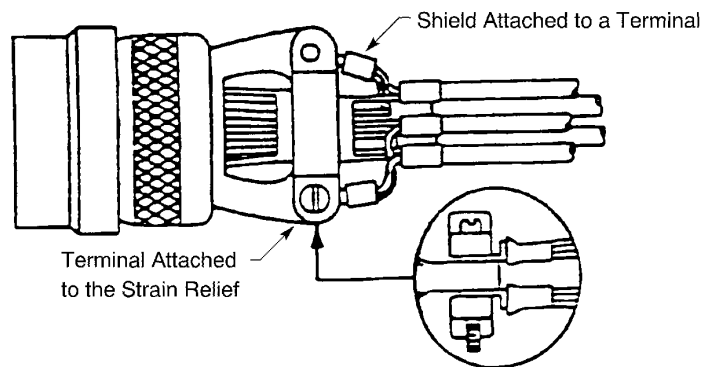
Either of these connections is satisfactory:

- The shield is attached directly to a terminal and the terminal is attached to the connector strain relief.
- One end of a shield ground wire is attached to the shield and the other end is attached to a terminal that is subsequently attached to the connector strain relief.

**20-25-00**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
SHIELDED CABLES



2445689 S00061545001\_V1

SHIELD CONNECTED TO THE CONNECTOR STRAIN RELIEF

Figure 1

**B. Connection of a Shield to the Connector Backshell through a Faying Surface Bond**

**NOTE:** This procedure is recommended to connect the shields of the electrical circuits that are sensitive.

Refer to Figure 2 and Figure 3.

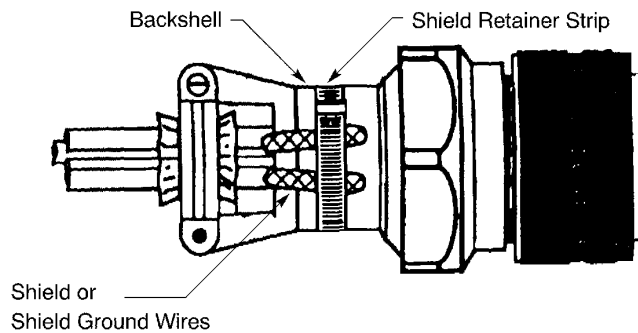
To keep the faying surface bond in position, either of these connections is satisfactory:

- A shield retainer strip is used to press the shield against the surface of the backshell
- The internal components in the backshell and the position of the shield in relation to these components make the bond.

**20-25-00**



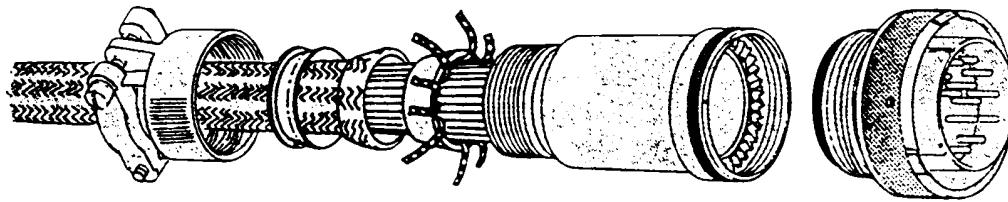
707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
SHIELDED CABLES



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SHIELD CONNECTION WITH A SHIELD RETAINER STRIP

Figure 2



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SHIELD CONNECTION WITH A PERIPHERAL BACKSHELL

Figure 3

3. RELATED DATA IN OTHER SWPM SUBJECTS

A. **Bonding and Grounding of Electrical Connectors**

For the procedure to make low impedance bond between the receptacle connector and the aircraft structure, refer to Subject 20-20-00.

**20-25-00**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**SHIELDED CABLES**

**B. Faying Surface Bond**

For the procedures to install a faying surface bond, refer to Subject 20-20-00.

**C. Overall Shield Termination**

For the procedures to install overall shield braid on wire bundles, refer to Subject 20-25-11.

**D. Strain Relief Shield Termination**

For the procedures to assemble and maintain connections from the shield to the connector strain relief, refer to Subject 20-25-12.

**E. Peripheral Shield Termination**

For the procedures to assemble and maintain connections from the shield to the internal components in the backshell, refer to Subject 20-25-13.

**F. Shield Braid Retainer Strip Termination**

For the procedures to assemble and maintain connections that use a shield retainer strip to connect the shield to the backshell, refer to Subject 20-25-14.

**G. Connector Assembly**

For the procedures to connect the connector plug to the connector receptacle so that a low impedance interface occurs, refer to the Subject for the assembly of the connector.

**20-25-00**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

**TABLE OF CONTENTS**

<u><b>PARAGRAPH</b></u>		<u><b>PAGE</b></u>
<b>1.</b>	<b><u>GENERAL DATA</u></b>	<b>2</b>
	A. Lightning Strike Energy	2
	B. Susceptible Areas	2
	C. Bonds or Grounds of Connectors	3
<b>2.</b>	<b><u>GENERAL CONDITIONS FOR OVERBRAID SHIELDS</u></b>	<b>3</b>
	A. Identification	3
	B. Selection of an Overbraid Shield Sleeve	3
	C. Conditions for the Installation of an Overbraid Shield	3
	D. Shield Ground Wires, Short Wire Bundle Branches, and Adjacent Wires	4
	E. Wire Bundle Ties	5
<b>3.</b>	<b><u>ASSEMBLY OF AN OVERBRAID SHIELD WITHOUT SOLDER</u></b>	<b>5</b>
	A. Overbraid Shield Sleeve Installation	5
	B. Connection of Overbraid Shields	8
	C. Overbraid Shield Termination	9
<b>4.</b>	<b><u>ASSEMBLY OF AN OVERBRAID SHIELD WITH SOLDER</u></b>	<b>11</b>
	A. Overbraid Shield Installation	11
	B. Connection of Overbraid Shields with a Shield Ground Wire Soldered to the Shield	12
	C. Connection of Overbraid Shields with the Shield Ground Wires Soldered Together	13
	D. Overbraid Shield Termination	14
<b>5.</b>	<b><u>ASSEMBLY OF A SHIELD GROUND WIRE WITH SHIELDED WIRE</u></b>	<b>16</b>
	A. General Conditions	16
	B. Shield Ground Wire Assembly	16
<b>6.</b>	<b><u>MODIFICATION OF A WIRE BUNDLE WITH AN OVERBRAID SHIELD</u></b>	<b>19</b>
	A. Installation of a New Wire	19

**20-25-11**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

Critical system wiring has shielded wires and overbraid shields for protection. This Subject gives these procedures for overbraid shields:

- Installation
- Repair
- Rework.

**1. GENERAL DATA**

**A. Lightning Strike Energy**

Lightning strike energy:

- Can be transferred or coupled through non-metallic skin panels to electrical wiring and equipment
- Can have a sufficient magnitude to cause a system failure if it is not attenuated.

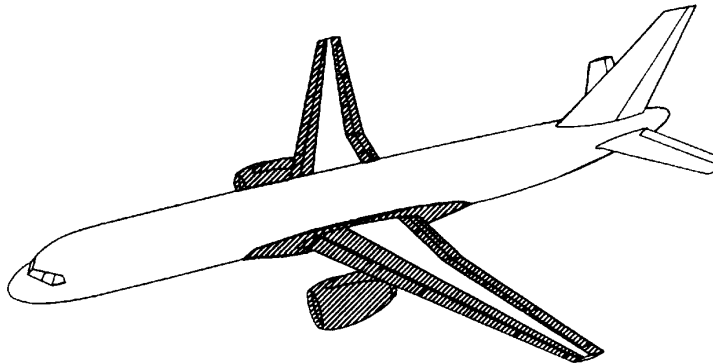
As a result of extensive studies, the aircraft have lightning protection which include:

- Transient suppression filters
- Metallic shields over the wire bundles.

**B. Susceptible Areas**

Refer to Figure 1 for the usual areas where electrical wiring is susceptible to interference or damage from lightning; the areas of the wheel wells are included.

**NOTE:** Almost all wire bundles in the susceptible areas have braided, metallic overbraid shields for protection.



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**AREAS SUSCEPTIBLE TO DAMAGE OR INTERFERENCE FROM LIGHTNING**

**Figure 1**

**20-25-11**





**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

**C. Bonds or Grounds of Connectors**

When it is necessary to bond or ground connectors, circuits, or backshell hardware to maintain lightning protection, refer to Subject 20-20-00.

**2. GENERAL CONDITIONS FOR OVERBRAID SHIELDS**

**A. Identification**

A wire bundle that has an overbraid shield installed must be identified with a W number at these locations:

- Within 18 inches of all connectors
- Within 18 inches of all shield terminations
- At branches
- Every six feet.

An example is W3108.

**B. Selection of an Overbraid Shield Sleeve**

For the selection of a shield sleeve material for an overbraid shield, the shield must have the same or higher temperature grade as the wire bundle.

**Table 1**  
**SHIELD SLEEVE MATERIALS**

Description	Temperature Grade	Boeing Standard	Assembly Procedure
Overbraid Shield, Tin Coated	B	BAC3108-()	Paragraph 3.
			Paragraph 4.
Overbraid Shield, Nickel Coated	D	BAC3106-()	Paragraph 3.

**NOTE:** The BAC3106-() overbraid shield is nickel coated and must be assembled without solder.

**NOTE:** For sizes and suppliers of shield sleeve materials, refer to Subject 20-00-11.

**C. Conditions for the Installation of an Overbraid Shield**

Overbraid shields must be:

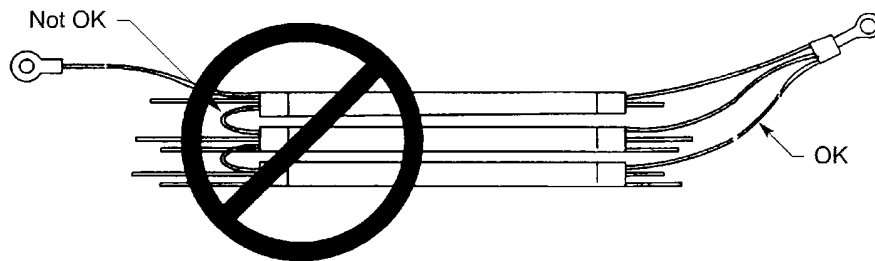
- A tight fit on the wire bundle
- Attached to ground at both ends.
- Terminated within 4 inches of the center of a seal fitting.

The overbraid shields of the wire bundle and the individual shield ground wires of the cables must not be installed so that they are connected from shield to shield. Refer to Figure 2.

**20-25-11**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
OVERBRAID SHIELDS ON WIRE BUNDLES



2445693 S00061545006\_V1

CONFIGURATION OF SHIELD GROUND WIRES AND OVERBRAID SHIELDS

Figure 2

**D. Shield Ground Wires, Short Wire Bundle Branches, and Adjacent Wires**

It is not necessary to install an overbraid shield on these wires when they are 6 inches or less in length:

- Shield ground wires of each shielded cable of the wire bundle
- Short branches of a wire bundle.

**NOTE:** The length of an unshielded wire must be kept as short as possible.

Shield ground wires and short wire bundle branches must have either of these type of protection from the abrasive overbraid shield:

- A heat shrinkable sleeve; refer to Subject 20-10-14
- The necessary layers of TFE Teflon tape.

Refer to Figure 3.

Adjacent wires must have protection from the abrasive overbraid shield. The protection is given by the installation of an expando sleeve. Refer to Subject 20-00-11.

**NOTE:** If the separation of the adjacent wires and the overbraid shield is not possible with an expando sleeve, the satisfactory alternatives are:

- A heat shrinkable sleeve; refer to Subject 20-10-14
- The necessary layers of TFE Teflon tape.

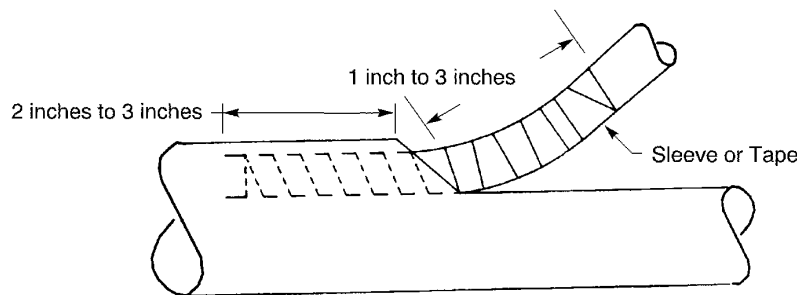
These conditions are applicable:

- It is not necessary for the sleeve of a shielded wire to obey the conditions for color code separation
- A layer of TFE Teflon tape must be installed on each end of an expando sleeve
- If the overbraid shield is soldered, a layer of TFE Teflon tape must be installed on the wire bundle or cable directly under the soldered area of the shield.

20-25-11



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**



2445694 S00061545007\_V1

**PROTECTION OF A SHORT WIRE BUNDLE BRANCH**  
**Figure 3**

**E. Wire Bundle Ties**

Refer to Subject 20-10-11.

Wire bundle ties:

- Must be installed on the overbraid shield every 4 inches, unless it is specified that the bundle must be tied every 2 inches
- Must be used to hold the end of a layer of tape
- Must be used to support a branch of a wire bundle
- Are not necessary under the overbraid shield.

**3. ASSEMBLY OF AN OVERBRAID SHIELD WITHOUT SOLDER**

**A. Overbraid Shield Sleeve Installation**

- (1) Make a selection of a shield sleeve material from Table 1.

Make sure that the shield is the correct size for a tight fit on the wire bundle.

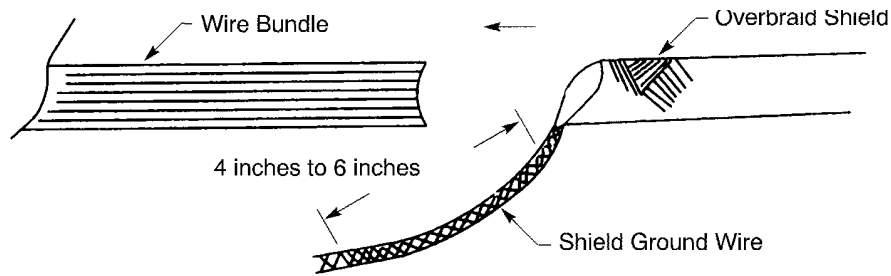
**NOTE:** For alternative shield sleeve materials, refer to Subject 20-00-11.

- (2) Cut the necessary length of the shield so that a 4 inch to 6 inch shield ground wire can be made at both ends.
- (3) Make a hole in the shield 4 inches 6 inches from each end. Refer to Figure 4.  
Make sure that the location of the hole is correct in relation to the configuration of the wire harness.

**20-25-11**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
OVERBRAID SHIELDS ON WIRE BUNDLES



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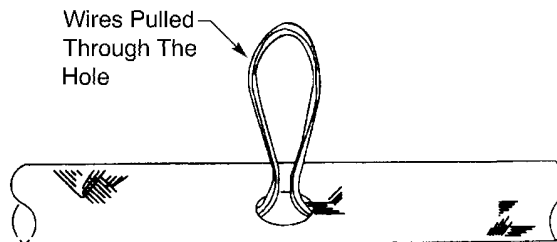
INSTALLATION OF THE OVERBRAID SHIELD SLEEVE ON THE WIRE HARNESS

Figure 4

- (4) Put the necessary length of an expando sleeve on the wire bundle.
- (5) Put a layer of TFE Teflon tape or a heat shrinkable sleeve on the ends of the expand sleeve so that either the tape or the heat shrinkable sleeve:
  - Makes an overlap with the expando sleeve
  - Extend 1 inch to 2 inches beyond the end of the overbraid shield sleeve.
- (6) Pull the shield sleeve on the wires or cables  
Make sure that the hole is the correct position on the wire bundle.

**CAUTION:** DO NOT INSTALL THE SHIELD SLEEVE ON A WIRE HARNESS TIE.

- (7) If it is possible, pull the wires or cable through the hole. Refer to Figure 5.



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WIRES PULLED THROUGH THE HOLE IN THE SHIELD SLEEVE

Figure 5

- (8) If the wires or cables cannot be pulled through the hole in the shield sleeve because of the configuration of the wire harness, a shield sleeve can be installed on each wire or cable. Refer to Figure 6.

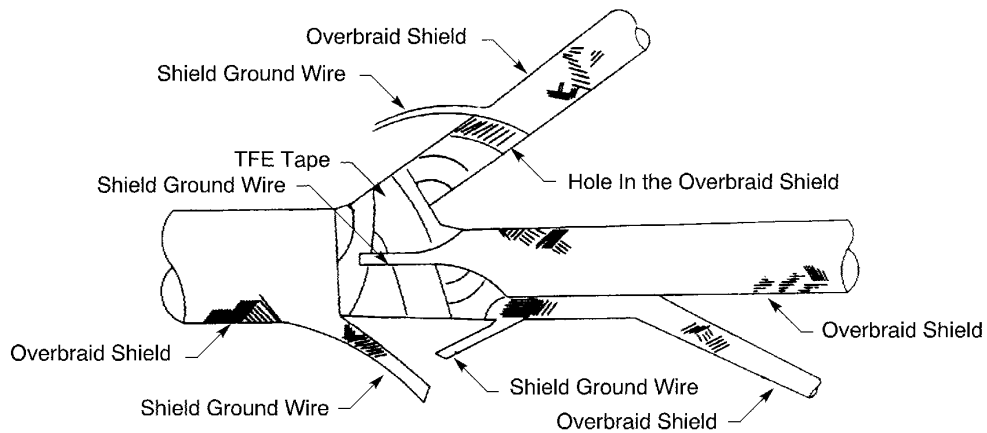
**NOTE:** To make the installation easier, more than one shield sleeve can be installed on the wire bundle; refer to Figure 7. These conditions are applicable:

- Each shield sleeve is installed on the wires or cable that are attached to the same connector
- A larger wire bundle diameter is permitted.

20-25-11



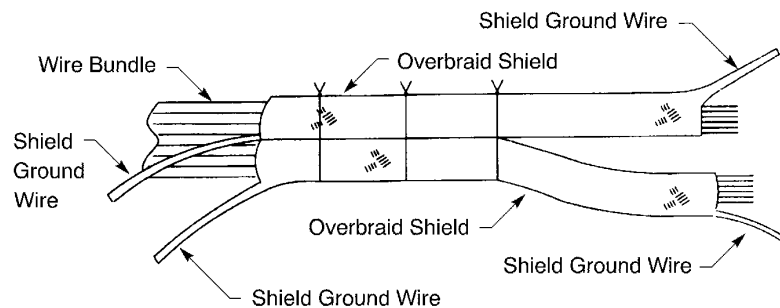
**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**



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**OVERBRAID SHIELD SLEEVE INSTALLED ON EACH WIRE OR CABLE**

**Figure 6**



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**MORE THAN ONE OVERBRAID SHIELD SLEEVE INSTALLED ON A WIRE BUNDLE**

**Figure 7**

- (9) Install an expando sleeve on each shield sleeve. Refer to Paragraph 2.D.

**20-25-11**



## 707, 727-787 STANDARD WIRING PRACTICES MANUAL

### OVERBRAID SHIELDS ON WIRE BUNDLES

- (10) Assemble the necessary quantity of wire harness ties in the applicable positions on the wire harness.

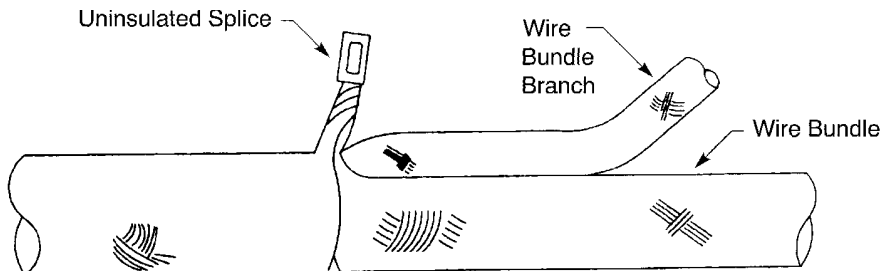
Refer to Paragraph 2.E. and Subject 20-10-11.

**CAUTION:** DO NOT INSTALL AN EXPANDO SLEEVE ON A WIRE HARNESS TIE.

#### B. Connection of Overbraid Shields

- (1) On the end of the shield ground wires at the 2 adjacent ends of the overbraid shields on the wire bundle, move the strands of the shield ground wires apart.
- (2) Twist the two ends of the shield ground wires together.
- (3) Find the equivalent wire size of the attached shield ground wires at approximately one inch from the wire bundle.
- (4) Install an uninsulated splice on the attached shield ground wires so that the end of the splice is 1 inch maximum from the wire bundle.

Refer to Subject 20-30-12 and Figure 8.

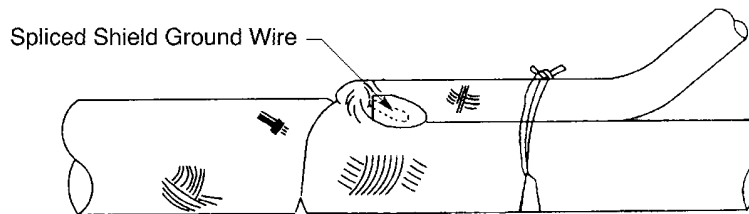


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#### CONNECTION OF TWO OVERBRAID SHIELDS

Figure 8

- (5) Make the spliced shield ground wire flat against the overbraid shield on the wire bundle. Refer to Figure 9.



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#### POSITION OF THE SPLICE AGAINST THE OVERBRAID SHIELD

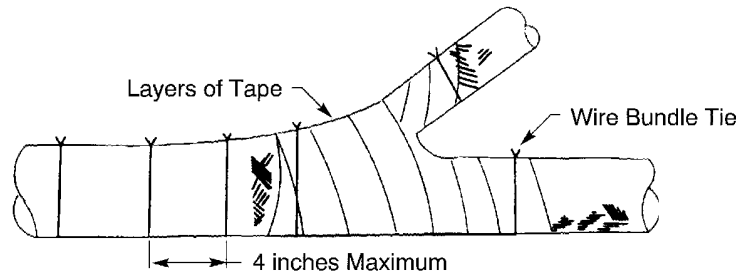
Figure 9

- (6) Put a layer of TFE Teflon tape wrap over the connection of the overbraid shields on the wire bundle. Refer to Figure 10.

**20-25-11**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**



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**TAPE ON THE CONNECTION OF THE OVERBRAID SHIELDS**

**Figure 10**

**C. Overbraid Shield Termination**

**Table 2**  
**SHIELD GROUND WIRE TERMINALS**

Overbraid Shield			Boeing Standard
Inside Diameter (inch)	Number of Conductors	Number of Ends	
0.109	24	96	BACT12AC3
0.172	24	168	BACT12AC8
0.203	24	384	BACT12AC12
0.375	48	384	BACT12AC12
0.500	48	528	BACT12AC15
0.781	48	864	BACT12AC19
0.875	48	336	BACT12AC15
1.00	48	864	BACT12AC19

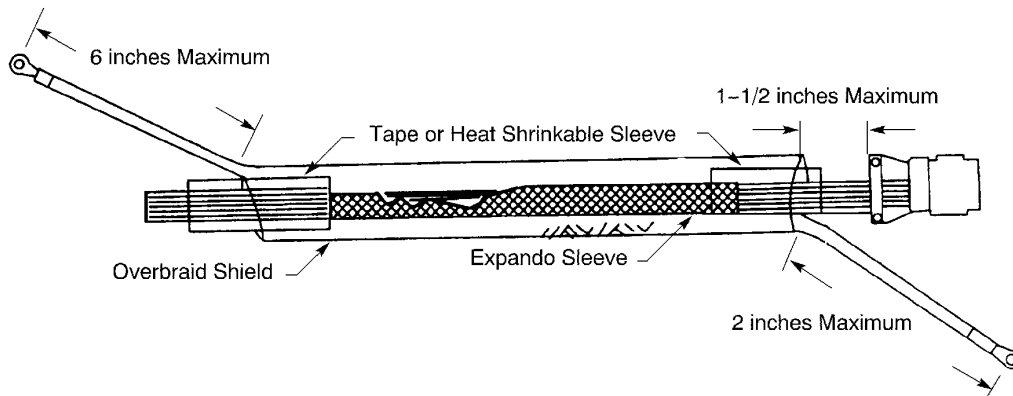
- (1) On each end of the overbraid shield, cut the shield ground wire so that it is a maximum length of:
  - 2.0 inches for termination at a connector strain relief
  - 6 inches for other terminations.
- (2) Move the strands of the shield apart on the last 1/2 inch of each shield ground wire.
- (3) Twist the strands of the shield to make a wire.
- (4) Make a selection of a terminal from Table 2.
- (5) Assemble a terminal on each shield ground wire. Refer to Subject 20-30-11 and Figure 11.

**NOTE:** To make it easier to put the terminal on the shield ground wire, the terminal can be twisted in the same direction as the twisted strands of the shield.

**20-25-11**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**



2445702 S00061545017\_V1

**TERMINATION OF A SHIELD GROUND WIRE**

**Figure 11**

- (6) Install the necessary length of a heat shrinkable sleeve on the end of the overbraid shield. Refer to Figure 12.

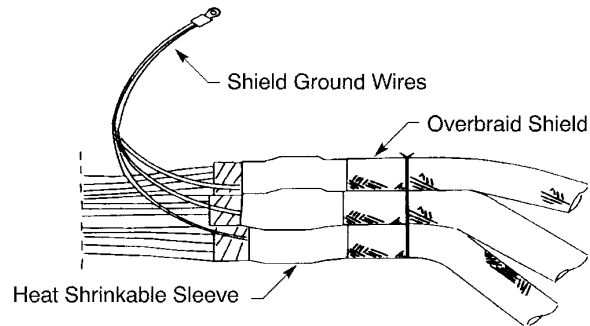
Make sure that the end of the sleeve extends 1/2 inch to 3/4 inch beyond the location where the shield ground wire comes out of the shield.

**20-25-11**





707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
OVERBRAID SHIELDS ON WIRE BUNDLES



2445703 S00061545018\_V1

TERMINATION OF THE OVERBRAID SHIELD

Figure 12

4. ASSEMBLY OF AN OVERBRAID SHIELD WITH SOLDER

A. **Overbraid Shield Installation**

Refer to Paragraph 3.A. for the procedure to install the shield.

**NOTE:** When it is necessary to terminate the overbraid shield on a connector with a Sunbank S2408-XX-XX cable clamp, make sure that the ends of the expando sleeve and the TFE tape are:

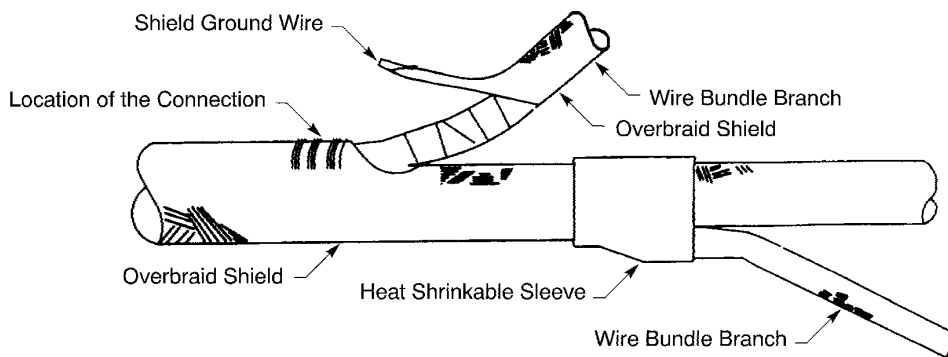
- Under the clamp
- A minimum of 1/2 inch from the connector grommet.

20-25-11



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
OVERBRAID SHIELDS ON WIRE BUNDLES

B. Connection of Overbraid Shields with a Shield Ground Wire Soldered to the Shield



2445704 S00061545019\_V1

CONNECTION OF A BRANCH SHIELD TO THE WIRE BUNDLE SHIELD

Figure 13

**NOTE:** This procedure cannot be used for nickel coated overbraid shield. For nickel coated overbraid shield, refer to Paragraph 3.

- (1) Make a selection of the location on the overbraid shield of the wire bundle where the shield ground wire at the end of the overbraid shield of the wire bundle branch can be soldered. Make sure that the distance from the end of the branch shield to the bundle shield is not greater than 0.25 inch.

**NOTE:** The assembly of the necessary number of wire bundle ties at the ends of adjacent shields can make the solder procedure easier.

- (2) At the location of the connection, put the end of the shield ground wire under 3 to 12 strands of the overbraid shield on the wire bundle. Refer to Figure 13.
- (3) Apply solder to the shield ground wire and the surface of the shield so that the length of the soldered area is:
  - At least equal to the diameter of the wire bundle
  - Not less than 0.25 inch.

- (4) Remove the length of the unwanted shield ground wire from the end of the soldered area.
- (5) Put a heat shrinkable sleeve over the soldered area. Refer to Figure 13.

**NOTE:** If it is necessary, the sleeve can be installed over the wire bundle ties from Step 4.B.(1).

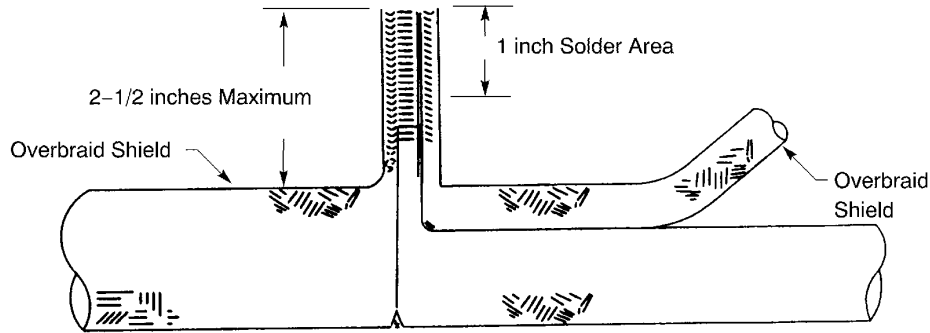
- (6) Shrink the sleeve into position. Refer to Subject 20-10-14.

20-25-11



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

**C. Connection of Overbraid Shields with the Shield Ground Wires Soldered Together**



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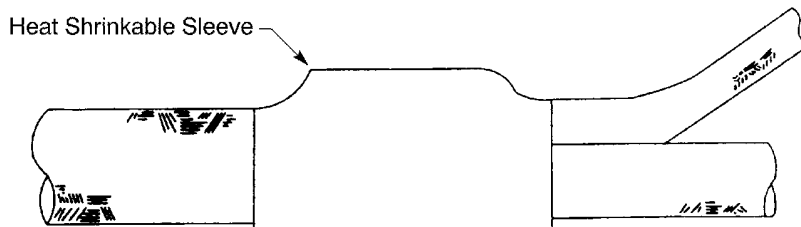
**CONNECTION OF A BRANCH SHIELD TO THE WIRE BUNDLE SHIELD**

**Figure 14**

- (1) Make the shield ground wires of the adjacent overbraid shields flat.
- (2) Cut both of the shield ground wires so that the distance from the end of the wires to the shield on the wire bundle is 2-1/2 inches maximum.  
Refer to Figure 14.
- (3) Solder the shield ground wires together.  
Make sure that the solder is applied from the end of the wires to 1 inch from the ends.
- (4) Fold the soldered wires so that they are against the overbraid shield.
- (5) Put a heat shrinkable sleeve over the soldered area.
- (6) Shrink the sleeve into position. Refer to Figure 15 and Subject 20-10-14.

**20-25-11**

**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

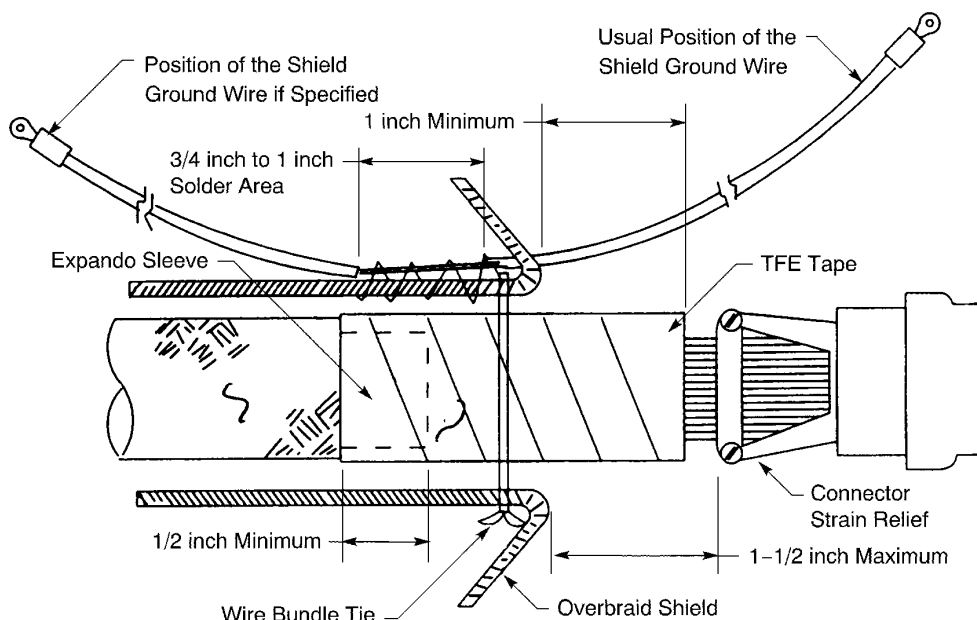


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**POSITION OF THE HEAT SHRINKABLE SLEEVE**

**Figure 15**

**D. Overbraid Shield Termination**



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**OVERBRAID SHIELD TERMINATION AT THE CONNECTOR STRAIN RELIEF**

**Figure 16**

- (1) Prepare the shield ground wire:
  - (a) Make a selection of a shield ground wire. Refer to Subject 20-10-15.
  - (b) Cut a length of the wire so that it is a maximum of:
    - 2.0 inches for termination at a connector strain relief
    - 6 inches for other terminations.
  - (c) Assemble one of these terminals on end of the shield ground wire:
    - A general purpose terminal
    - A high temperature terminal.

**20-25-11**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

Refer to Subject 20-30-11.

- (d) Remove 3/4 inch to 1 inch of insulation from the other end of the wire.
- (2) Prepare the overbraid shield. Refer Figure 16.
  - (a) Fold the shield back so that the distance from the location where the shield is folded to:
    - The end of the shield is, at the minimum, equal to the diameter of the wire bundle
    - The end of the TFE tape is 1-1/2 inches maximum.

**NOTE:** A white wire bundle tie can be assembled to hold the shield in position so it can be folded back.

- (b) Make a small hole in the shield at the location where the shield is folded.
- (3) Put the end of the shield ground wire without any solder through the hold in the shield.
- (4) At the location for the connection of the shield ground wire to the shield, put the end of the wire under 3 to 6 strands of the overbraid shield on the wire bundle.

Refer to Figure 16.

- (5) Apply solder to the shield ground wire and the surface of the shield so that all of the strands of the shield that touch the shield ground wire are soldered.
- (6) Put the necessary length of a heat shrinkable sleeve on the connection of the shield ground wire and the overbraid shield so that the sleeve is over the free end of the shield. Refer to Figure 17.

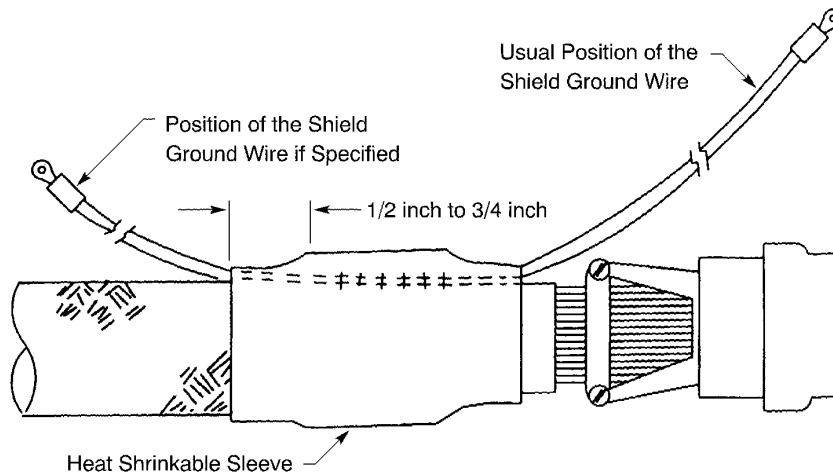
Make sure that the rearward end of the sleeve is 1/2 inch minimum beyond either of these locations:

- The rearward end of the shield
- The rearward end of the soldered area.

**20-25-11**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
OVERBRAID SHIELDS ON WIRE BUNDLES



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POSITION OF THE HEAT SHRINKABLE SLEEVE  
Figure 17

5. **ASSEMBLY OF A SHIELD GROUND WIRE WITH SHIELDED WIRE**

**NOTE:** Shield ground wires that are assembled with shielded wire are only necessary when the specified length of the shield ground wire is greater than 6 inches.

A. **General Conditions**

When a ground wire that is assembled with a shielded wire terminates the shield at a dual termination ground, the unshielded distance between the end of the shield and the end of the ground wire terminal must be:

- 3 inches minimum
- 3-1/2 inches maximum.

B. **Shield Ground Wire Assembly**

Table 3  
SHIELDED WIRE TYPES

Wire Specification	Type
BMS 13-31	III
	VII
BMS 13-51	IX
	XV
	XXX

20-25-11



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

Table 4  
**SHIELD CAU OF SHIELDED WIRE OR CABLE**

Wire			Shield Size (CAU)
Size (AWG)	Specification	Class	
22	BMS 13-51	1	6
		2	11
		3	12
20	BMS 13-31	1	9
		2	18
		3	19
	BMS 13-51	1	7
		2	13
		3	14
18	BMS 13-31	1	10
		2	20
		3	22
	BMS 13-51	1	8
		2	15
		3	16
16	BMS 13-31	1	10
		2	22
		3	24
	BMS 13-51	1	8
		2	16
		3	18
14	BMS 13-31	1	13
		2	25
		3	27
12	BMS 13-31	1	14
		2	28
		3	31

**20-25-11**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**OVERBRAID SHIELDS ON WIRE BUNDLES**

**Table 5**  
**CAU OF CONDUCTOR SIZES**

Wire Size (AWG)	Conductor Size (CAU)
22	8
20	12
18	19
16	24
14	38
12	59

- (1) Make a selection of a shielded wire or cable for the shield ground wire from Table 3 and Table 4.
- (2) Find the total CAU of the wire or wires and the shield.

**NOTE:** CAU is Circular Area Units. Refer to Subject 20-30-22.

- (a) Find the CAU of the shield in Table 4.
  - (b) Find the CAU of the conductor in Table 5.
  - (c) Add the CAU of the conductor multiplied by the number of conductors to the CAU of the shield.
- (3) With the total CAU, make a selection of a terminal. Refer to Subject 20-30-11.
- (4) Prepare the shielded wire for the assembly of the terminal:
  - (a) Remove the necessary length of the outer insulation of the wire or cable plus:
    - 1/8 inch more for a cable with 1 conductor
    - 1 inch to 1-1/4 inches more for a cable with more than 1 conductor.Refer to Subject 20-30-11 for the necessary length.
  - (b) Fold the shield back over the outer insulation.
  - (c) Remove the necessary length of the inner insulation from the each conductor. Refer to Subject 20-30-11.
  - (d) Fold the shield back over the conductor or conductors.
  - (e) For cables with more than 1 conductor, install a 1-1/2 inch to 1-3/4 inch length of heat shrinkable sleeve on the cable.  
Refer to Subject 20-10-11.
- (5) Assemble the terminal. Refer to Subject 20-30-11.

**NOTE:** If the insulation build-up of the wire combination is too large for the terminal, one of the conductors may be doubled back.

**20-25-11**



# 707, 727-787

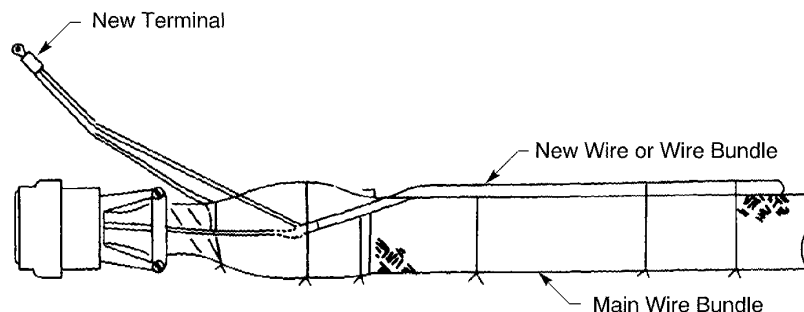
## STANDARD WIRING PRACTICES MANUAL

### OVERBRAID SHIELDS ON WIRE BUNDLES

#### 6. MODIFICATION OF A WIRE BUNDLE WITH AN OVERBRAID SHIELD

This paragraph gives the procedure to add a wire or wires to a wire bundle when it is not possible to open the overbraid shield.

##### A. Installation of a New Wire



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#### INSTALLATION OF A NEW WIRE OR WIRE BUNDLE

Figure 18

- (1) Install the overbraid shield on the new wire as if it were a different wire bundle. Refer to Paragraph 3. for nickel or tin coated over braid shield or Paragraph 4. for tin coated overbraid shield.

**NOTE:** TFE tape wrap can be used as the alternative to a heat shrinkable sleeve at the branches or shield terminations. Make sure to assemble wire bundle ties to hold the ends of tape.

- (2) Align the locations of termination of the new bundle with the terminations of the main wire bundle. Refer to Figure 18.

**NOTE:** It is not necessary to assemble wire bundle ties on tape or sleeves of the new bundle.

- (3) Terminate the shield ground wire of the new bundle in the same terminal as the main bundle:
  - (a) Remove the terminal from the shield ground wire of the main bundle.
  - (b) Assemble a new terminal on the shield ground wires of the new bundle and the main bundle.

Refer to Paragraph 3. for nickel or tin coated overbraid shield or Paragraph 4. for tin coated overbraid shield.

**20-25-11**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**OVERBRAID SHIELDS ON WIRE BUNDLES**

- (4) Remove the wire bundle ties from the overbraid shield of the main bundle that is adjacent to the shield of the new bundle.

**NOTE:** Do not remove ties that hold the TFE tape or heat shrinkable sleeve over a soldered area.

- (5) Assemble new wire bundles ties every 4 inches to hold the new bundle to the main bundle. Refer to Figure 18.

**20-25-11**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

#### TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Backshell Part Numbers	2
B. Spacer Part Numbers	5
2. <u>NECESSARY TOOLS</u>	7
A. Connector Backshell Tools	7
3. <u>BACKSHELL DISASSEMBLY</u>	7
A. Backshell Disassembly	7
4. <u>BACKSHELL ASSEMBLY</u>	7
A. General Data	7
B. Applicable Conditions for Backshell Assembly	11
C. Applicable Conditions for Strain Relief Assembly	13
D. Necessary Materials	13
E. Assembly of the Terminal Lug on the Shield Ground Wire	14
F. Backshell Assembly	14
G. Strain Relief Assembly - Straight Backshell	16
H. Strain Relief Assembly - 45 Degree or 90 Degree Backshell	22

**20-25-12**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

This Subject gives the procedures to assemble strain relief backshells that terminate shields with shield ground wires and terminal lugs. For the procedures to assemble other strain relief backshells, refer to:

- Subject 20-60-09 for the assembly of backshells that do not terminate a shield
- Subject 20-25-13 for the assembly of backshells that terminate shields with inner and outer ground rings
- Subject 20-25-14 for the assembly of backshells that terminate shields with a shield terminator band
- Subject 20-25-15 for the assembly of backshells that have a braided shield sock.

#### 1. PART NUMBERS AND DESCRIPTION

##### A. Backshell Part Numbers

Table 1  
BACKSHELL PART NUMBERS

Part Number	Configuration	Description	Supplier
620AA028Z1-()	90 Degree	Anti-Rotation Teeth, Stainless Steel	Glenair
620AS048ZM-()	90 Degree	Anti-Rotation Teeth, Stainless Steel	Glenair
620HA048ZM-()	90 Degree	Anti-Rotation Teeth, Stainless Steel	Glenair
AS85049-38S()	Straight	Anti-Rotation Teeth, Aluminum	QPL
BACC10HD	Straight	Stainless Steel	Boeing
BACC10HE	90 Degree	Stainless Steel	Boeing
BACC10HF	Straight	Aluminum	Boeing
BACC10HG	90 Degree	Aluminum	Boeing
BACC10JV()A	Straight	Ground Spring, Aluminum	Boeing
BACC10JV()S	Straight	Ground Spring, Stainless Steel	Boeing
BACC10JW()A	90 Degree	Ground Spring, Aluminum	Boeing
BACC10JW()S	90 Degree	Ground Spring, Stainless Steel	Boeing
BACC10KA	Straight	Anti-Rotation Teeth, Stainless Steel	Boeing
BACC10KB	90 Degree	Anti-Rotation Teeth, Stainless Steel	Boeing
BACC10KC	45 Degree	Anti-Rotation Teeth, Stainless Steel	Boeing
BACC10KD	Straight	Anti-Rotation Teeth, Aluminum	Boeing
BACC10KE	90 Degree	Anti-Rotation Teeth, Aluminum	Boeing
BACC10KF	45 Degree	Anti-Rotation Teeth, Aluminum	Boeing
G8993-()	Straight	Anti-Rotation Teeth, Aluminum	Glenair
G8993M()	Straight	Anti-Rotation Teeth, Aluminum	Glenair
G8994-()	90 Degree	Anti-Rotation Teeth, Aluminum	Glenair
G8994M()	90 Degree	Anti-Rotation Teeth, Aluminum	Glenair
M85049-38S()	Straight	Anti-Rotation Teeth, Aluminum	QPL
S1347-()	90 Degree	Aluminum	Sunbank
S2277-()	45 Degree	Aluminum	Sunbank

20-25-12



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

Table 1 BACKSHELL PART NUMBERS (Continued)

Part Number	Configuration	Description	Supplier
S2408-()	Straight	Aluminum	Sunbank

Table 2

#### APPROVED SUPPLIERS OF BOEING STANDARD BACKSHELL PART NUMBERS

Backshell	Supplier
BACC10HD	Glenair
	Electro Adapter
	Sunbank
BACC10HE	Electro Adapter
	Glenair
	Sunbank
BACC10HF	Electro Adapter
	Glenair
	Sunbank
BACC10HG	Electro Adapter
	Glenair
	Sunbank
BACC10JV(A)	Glenair
BACC10JV(S)	Glenair
BACC10JW(A)	Glenair
BACC10JW(S)	Glenair
BACC10KA	Glenair
	Sunbank
BACC10KB	Glenair
	Sunbank
BACC10KC	Glenair
	Sunbank
BACC10KD	Glenair
	Sunbank
BACC10KE	Glenair
	Sunbank

20-25-12



707, 727-787

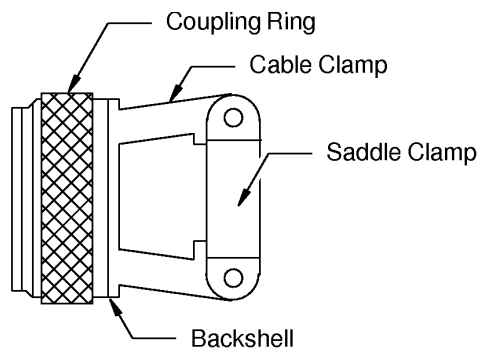
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### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

Table 3

#### ALTERNATIVE STRAIN RELIEF BACKSHELLS

Specified Backshell		Alternative Backshell	
Part Number	Supplier	Part Number	Supplier
BACC10HD	Boeing	BACC10HD()A	Boeing
		BACC10KA	Boeing
BACC10HE	Boeing	BACC10HE()A	Boeing
		BACC10KB	Boeing
BACC10HF	Boeing	BACC10KD	Boeing
BACC10HG	Boeing	BACC10HG()A	Boeing
		BACC10KE	Boeing
M85049/38S	QPL	AS85049/38S	QPL
G8993M()	Glenair	BACC10HF()A	Boeing
		G8993-()	Glenair
G8993M()NF	Glenair	BACC10HF()C	Boeing
G8994M()	Glenair	BACC10HG()A	Boeing
		G8993-()	Glenair
G8994M()NF	Boeing	BACC10HG()C	Boeing



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#### STRAIGHT STRAIN RELIEF BACKSHELL

Figure 1

20-25-12

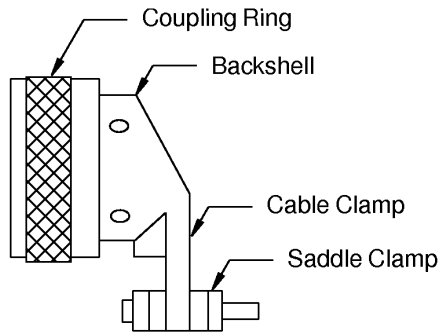
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Page 4  
Oct 15/2015



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**



2447743 S00061545027\_V1

**90 DEGREE STRAIN RELIEF BACKSHELL**

**Figure 2**

**B. Spacer Part Numbers**

**Table 4**  
**SPACER PART NUMBERS**

Connector Shell Size		Spacer		Reference
Minimum	Maximum	Part Number	Supplier	
8	16	NAS1056C5-()	QPL	Figure 3
		NAS1056C6-()	QPL	Figure 3
		NAS1057T1-()	QPL	Figure 4
		NAS1057W1-()	QPL	Figure 4
		NAS43DD1-()	QPL	Figure 5
18	28	NAS1056E5-()	QPL	Figure 3
		NAS1056E6-()	QPL	Figure 3
		NAS1057T3-()	QPL	Figure 4
		NAS1057W3-()	QPL	Figure 4
		NAS43DD3-()	QPL	Figure 5
36	36	BACS13S297B	Boeing	-

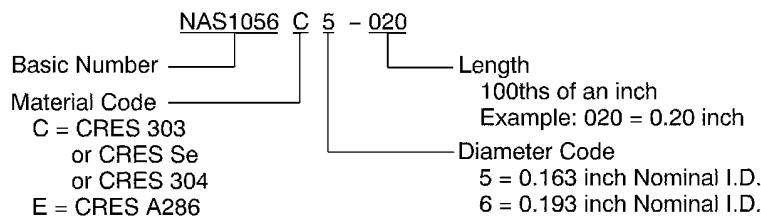
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**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**

Table 5  
**APPROVED SUPPLIERS OF BOEING STANDARD SPACERS**

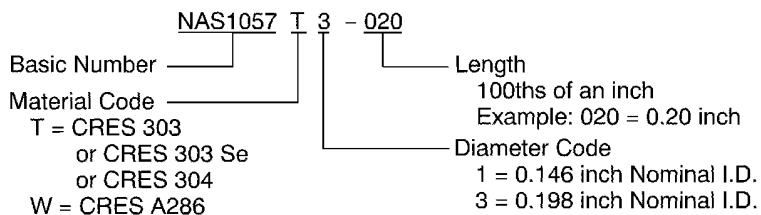
Spacer	Supplier
BACS13S	Thomas & Betts



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**NAS1056 SPACER PART NUMBER STRUCTURE**

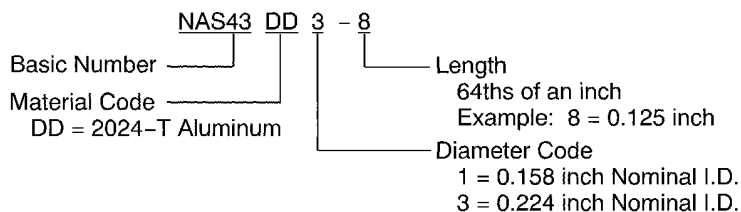
Figure 3



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**NAS1057 SPACER PART NUMBER STRUCTURE**

Figure 4



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**NAS43 SPACER PART NUMBER STRUCTURE**

Figure 5

**20-25-12**





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

#### 2. NECESSARY TOOLS

##### A. Connector Backshell Tools

Table 6  
CONNECTOR BACKSHELL TOOLS

Backshell Tool	Part Number	Supplier
Strap Wrench	AT508K	Aircraft Tools
	ST2596G	Boeing
	ST2596C	Boeing
	TG-70	Glenair
Torque Driver	-	Available source
Torque Wrench	-	Available source

#### 3. BACKSHELL DISASSEMBLY

##### A. Backshell Disassembly

- (1) If the backshell has safety wire, remove the safety wire from the cable clamp screws and the backshell coupling ring.
- (2) Remove the strain relief clamp screws.
- (3) Put the saddle bars, the screws, and the washers in a safe place.
- (4) Make a selection of a strap wrench from Table 6.
- (5) Disengage the threads of the backshell and the connector.

#### 4. BACKSHELL ASSEMBLY

For the procedure to assemble a backshell without a shield ground wire termination, refer to Subject 20-60-09.

##### A. General Data

Table 7  
BACKSHELL INSTALLATION TORQUE VALUES

Shell Size	Torque Wrench		Torque Value (inch-pounds)			
	Position (degree)	Reference	Aluminum Backshell		Stainless Steel Backshell	
			Minimum	Maximum	Minimum	Maximum
08	0	Figure 6	35	40	85	90
	45	Figure 7	35	40	85	90
	90	Figure 8	40	45	100	105

20-25-12



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

Table 7 BACKSHELL INSTALLATION TORQUE VALUES (Continued)

Shell Size	Torque Wrench		Torque Value (inch-pounds)			
	Position (degree)	Reference	Aluminum Backshell		Stainless Steel Backshell	
			Minimum	Maximum	Minimum	Maximum
09	0	Figure 6	35	40	85	90
	45	Figure 7	35	40	85	90
	90	Figure 8	40	45	100	105
10	0	Figure 6	40	45	85	90
	45	Figure 7	40	45	85	90
	90	Figure 8	45	50	100	105
11	0	Figure 6	40	45	85	90
	45	Figure 7	40	45	85	90
	90	Figure 8	45	50	100	105
12	0	Figure 6	55	60	85	90
	45	Figure 7	55	60	85	90
	90	Figure 8	60	65	100	105
13	0	Figure 6	55	60	85	90
	45	Figure 7	55	60	85	90
	90	Figure 8	60	65	100	105
14	0	Figure 6	65	70	120	125
	45	Figure 7	65	70	120	125
	90	Figure 8	75	80	140	145
15	0	Figure 6	65	70	120	125
	45	Figure 7	65	70	120	125
	90	Figure 8	75	80	140	145
16	0	Figure 6	75	80	120	125
	45	Figure 7	75	80	120	125
	90	Figure 8	90	95	140	145
17	0	Figure 6	75	80	120	125
	45	Figure 7	75	80	120	125
	90	Figure 8	90	95	140	145
18	0	Figure 6	95	100	140	145
	45	Figure 7	95	100	140	145
	90	Figure 8	115	120	160	165
19	0	Figure 6	95	100	140	145
	45	Figure 7	95	100	140	145
	90	Figure 8	115	120	160	165

20-25-12



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

Table 7 BACKSHELL INSTALLATION TORQUE VALUES (Continued)

Shell Size	Torque Wrench		Torque Value (inch-pounds)			
	Position (degree)	Reference	Aluminum Backshell		Stainless Steel Backshell	
			Minimum	Maximum	Minimum	Maximum
20	0	Figure 6	105	110	165	170
	45	Figure 7	105	110	165	170
	90	Figure 8	125	130	190	195
21	0	Figure 6	105	110	165	170
	45	Figure 7	105	110	165	170
	90	Figure 8	125	130	190	195
22	0	Figure 6	105	110	165	170
	45	Figure 7	105	110	165	170
	90	Figure 8	125	130	190	195
23	0	Figure 6	105	110	165	170
	45	Figure 7	105	110	165	170
	90	Figure 8	125	130	190	195
24	0	Figure 6	105	110	165	170
	45	Figure 7	105	110	165	170
	90	Figure 8	125	130	190	195
25	0	Figure 6	105	110	165	170
	45	Figure 7	105	110	165	170
	90	Figure 8	125	130	190	195
28	0	Figure 6	110	115	165	170
	45	Figure 7	110	115	165	170
	90	Figure 8	130	135	190	195
32	0	Figure 6	120	125	170	175
	45	Figure 7	120	125	170	175
	90	Figure 8	140	145	190	195

20-25-12

Page 9

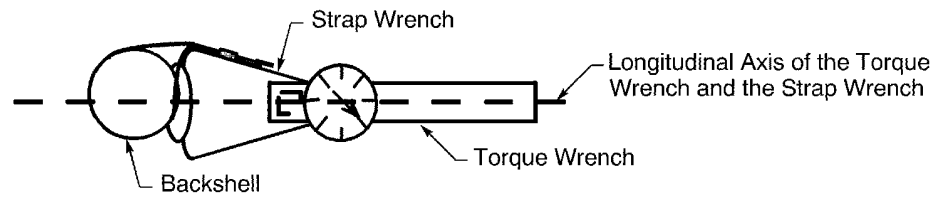
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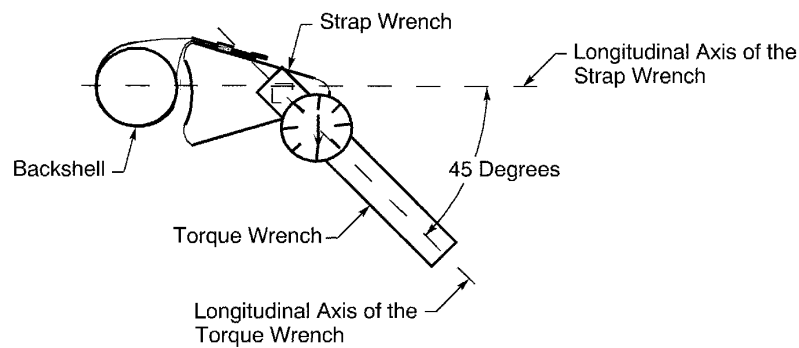


**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**



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**TORQUE WRENCH IN THE 0 DEGREE POSITION**  
**Figure 6**



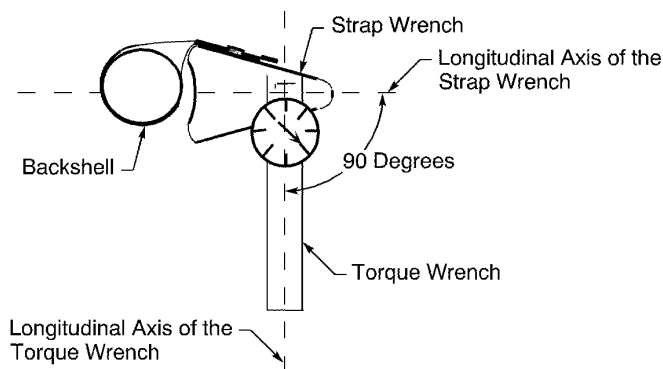
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**TORQUE WRENCH IN THE 45 DEGREE POSITION**  
**Figure 7**

**20-25-12**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**



2447761 S00061545033\_V1

**TORQUE WRENCH IN THE 90 DEGREE POSITION**

**Figure 8**

**B. Applicable Conditions for Backshell Assembly**

**CAUTION:** DO NOT USE RIGHT ANGLE (90 DEGREES) STRAIN RELIEF CABLE CLAMPS OR BACKSHELLS WITH FIBER OPTIC CABLES. THE BEND RADIUS OF THE FIBER OPTIC CABLE WILL BE LESS THAN THE REQUIRED MINIMUM BEND RADIUS OF THE CABLE. DAMAGE TO THE CABLE OR OPTICAL FIBER CAN OCCUR.

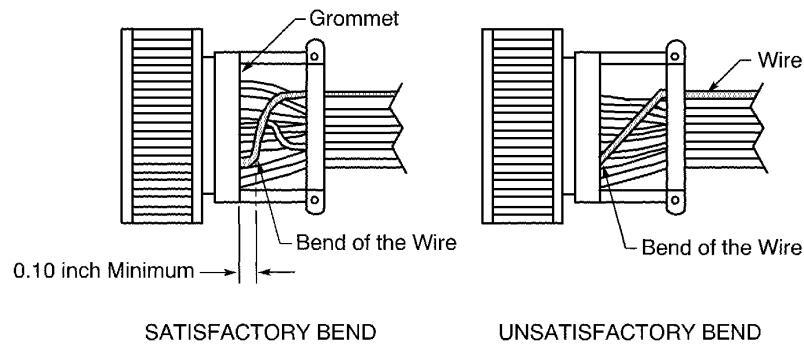
These conditions are applicable for a wire harness in a backshell with a cable clamp:

- Strain must not be put on the wires
- The wires must not have tension that pulls the seal webs of the grommet out of their shape
- The crimp barrel of a contact cannot be seen in the rear grommet of an environmental connector
- When a wire makes an exit from the rear of the connector grommet at an angle that is less than 60 degrees, the distance from the rear of the grommet to the bend must be 0.10 inch minimum
- Safety wire must be installed on the coupling ring of the backshell if the applicable conditions occur; refer to Subject 20-60-07.

**20-25-12**



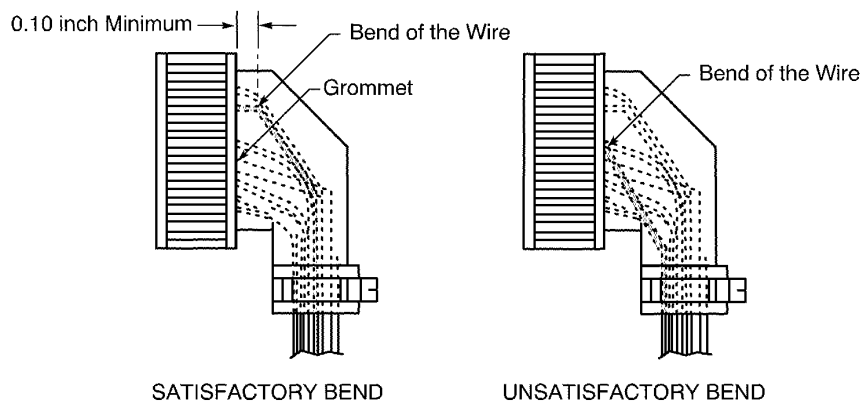
**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**



2447763 S00061545035\_V1

**BEND OF THE WIRE IN A STRAIGHT BACKSHELL**

**Figure 9**



2447764 S00061545036\_V1

**BEND OF THE WIRE IN A 90 DEGREE BACKSHELL**

**Figure 10**

**20-25-12**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

#### C. Applicable Conditions for Strain Relief Assembly

**CAUTION:** DO NOT USE RIGHT ANGLE (90 DEGREES) STRAIN RELIEF CABLE CLAMPS OR BACKSHELLS WITH FIBER OPTIC CABLES. THE BEND RADIUS OF THE FIBER OPTIC CABLE WILL BE LESS THAN THE REQUIRED MINIMUM BEND RADIUS OF THE CABLE. DAMAGE TO THE CABLE OR OPTICAL FIBER CAN OCCUR.

These conditions are applicable for the assembly of the strain relief:

- The wires must not go across each other in the cable clamp
- The wire harness must have a minimum of two layers of tape for protection
- The tape must not be between the saddle bar and the backshell leg
- The wire harness must be held tightly in the cable clamp
- The cable clamp must not crush the wire harness
- The cable clamp screws must be tight.

The diameter of a wire harness must be increased when these conditions occur:

- The cable clamp does not hold the wire harness tightly
- The wire harness has a small number of wires
- The contact assemblies are installed only near the outer edge of the connector grommet

These conditions are applicable for the layers of tape:

- The forward and rear edges of the tape must extend a minimum of 0.06 inch farther than the edges of the saddle bar
- The edge of one layer is a maximum of 0.05 inch from the edge of a different layer
- For U shaped tape, each layer makes a 100 percent overlap.

Spacers must be installed between the saddle bar and the backshell leg when these conditions occur:

- The diameter of the wire harness is much larger than the diameter of the clamp
- The clamp crushes the wire harness before the screws are fully tightened.

#### D. Necessary Materials

**Table 8**  
**NECESSARY MATERIALS**

Material	Temperature Grade	Description	Part Number or Specification	Supplier
Filler Rod	C	Silicone	69B47691-()	Boeing
			BMS1-52	Boeing
	D	PTFE	AMS 3656	QPL
Tape	D	Silicone	912-10X12	Arlon
			Scotch 70	3M
		PTFE	P-212HD	Permacel
			P-421	Permacel
			P-440	Permacel
Tape, U Shaped	C	Silicone, 0.5 inch width	10-62034-1	Boeing
		Silicone, 0.4 inch width	10-62034-2	Boeing

**20-25-12**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

#### E. Assembly of the Terminal Lug on the Shield Ground Wire

Table 9  
EQUIVALENT STUD SIZE

Screw Diameter (inch)	Equivalent Stud Size
0.1120	4
0.1380	6
0.1640	8

Table 10  
RECOMMENDED TERMINAL LUGS

Maximum Temperature Grade	Boeing Standard Terminal Lug
B	BACT12AC()
D	BACT12M()

- (1) Measure the diameter of the cable clamp screw.
- (2) Find the equivalent size of the stud for the terminal lug. Refer to Table 9.
- (3) Make a selection of a terminal lug. Refer to Table 10 and Subject 20-30-11.

Make sure that:

- The type of terminal lug is applicable for the type of the shield ground wire
- The type of the terminal lug is applicable for the location of the installation of the connector
- The stud size hole of the terminal lug is applicable for the cable clamp screw.

- (4) Assemble the terminal lug. Refer to Subject 20-30-11.

#### F. Backshell Assembly

- (1) Make a selection of a strap wrench from Table 6.
- (2) Put the necessary backshell components on the wire harness.  
Make sure that the cable clamp of the backshell is pointed away from the end of the wire harness.
- (3) Install the contacts in the connector. Refer to the Subject that is applicable for the assembly of the connector.
- (4) Put the wires into their positions.  
Make sure that:
  - The wires do not go across each other
  - The wires do not have tension that pulls the seal web out of its shape
  - Strain is not put on the wires.
- (5) If the backshell has anti-rotation teeth, examine the teeth of the backshell through the inspection hole. Refer to Figure 11.

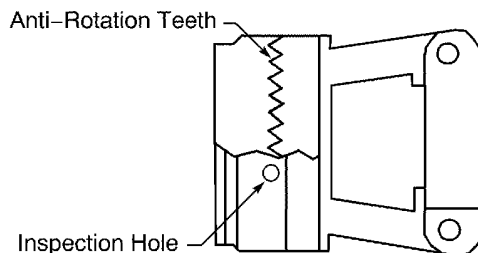
Make sure that the backshell teeth are engaged with the connector teeth. Refer to Figure 12.

**20-25-12**





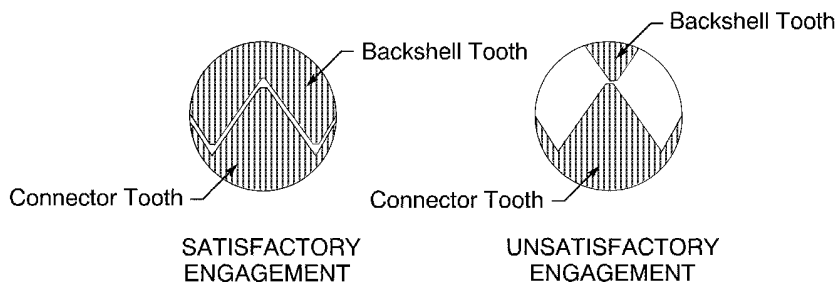
**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**



2447767 S00061545037\_V1

**BACKSHELL WITH ANTI-ROTATION TEETH**

**Figure 11**



2447772 S00061545038\_V1

**ENGAGEMENT OF THE CONNECTOR TEETH AND THE BACKSHELL TEETH**

**Figure 12**

- (6) Tighten the backshell on the connector with the strap wrench.

Make sure that:

- The backshell does not make more than 1/8 turn with the strap wrench
- The backshell is in the correct clock position.

**CAUTION:** DO NOT TIGHTEN THE BACKSHELL MORE THAN NECESSARY. DAMAGE TO THE BACKSHELL CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CONNECTOR OR THE BACKSHELL.

- (7) If the backshell has set screws, tighten one of the set screws.  
(8) Try to loosen the backshell manually.

**NOTE:** The backshell is installed correctly when the backshell does not move in relation to the connector.

- (9) If the backshell is loose, do Step 4.F.(6) through Step 4.F.(8) again.  
(10) Assemble the strain relief.

Refer to:

- Paragraph 4.G. for the assembly of the strain relief of a straight backshell
- Paragraph 4.H. for assembly of the strain relief of a 45 degree or a 90 degree backshell.

**20-25-12**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

#### G. Strain Relief Assembly - Straight Backshell

Table 11  
CABLE CLAMP SCREW TORQUE VALUES

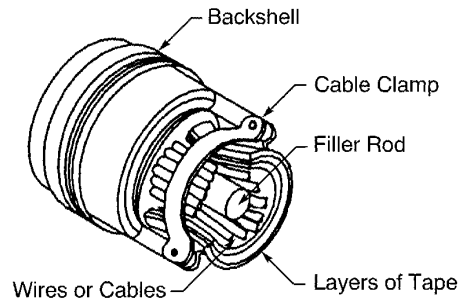
Screw Size	Torque (inch-pounds)	
	Minimum	Maximum
4	10	12
6	15	23
8	25	30

- (1) Make a selection of a torque driver from Table 6.
- (2) Make a selection of a tape from Table 8.  
Make sure that the tape is a minimum of 0.12 inch wider than the saddle bar.  
**NOTE:** An equivalent tape is a satisfactory alternative. Refer to Subject 20-00-11.  
**NOTE:** A thicker tape is recommended when the difference between the initial diameter of the wire harness and the inner diameter of the strain relief is large.
- (3) Align the screw holes in a saddle bar with the screw holes in the legs of the backshell.
- (4) Make a mark on the wire harness at the center of the width of the saddle bar.
- (5) If the assembled contacts are installed only near the outer edge of the connector grommet:
  - (a) Make a selection of a filler rod from Table 8.
  - (b) Put the filler rod in the center of the group of wires where the saddle bars go across the wire harness. Refer to Figure 13.

20-25-12



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS**



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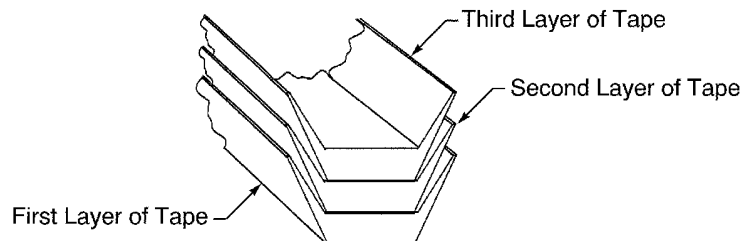
**POSITION OF THE FILLER ROD**

**Figure 13**

- (6) Put a minimum of two layers of tape on the wires or cables at the location of the mark.

Make sure that:

- The outer diameter of the wire harness with the layers of tape is larger than the inner diameter of the strain relief
- The center of the layers of tape is aligned with the center of the saddle bar
- The edge of the tape extends a minimum of 0.06 inch farther than each edge of the saddle bar
- The edge of one layer of the tape is a maximum of 0.05 inch from the edge of a different layer of tape
- For U shaped tape, each layer of tape makes a 100 percent overlap.



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**CONFIGURATION OF THE LAYERS OF U SHAPED TAPE**

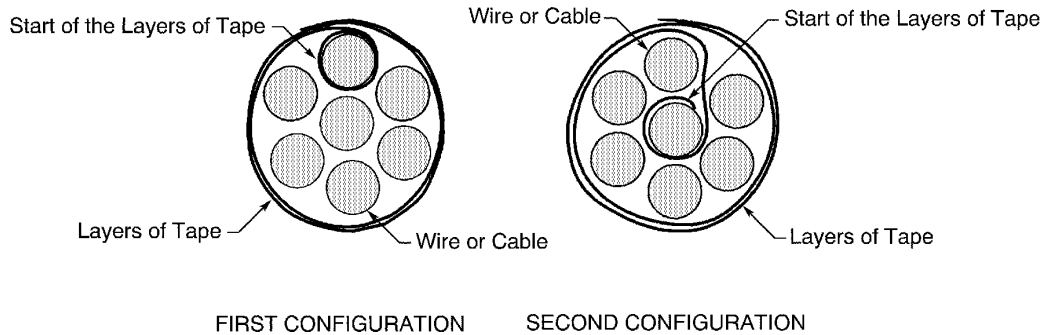
**Figure 14**

**20-25-12**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

- (a) Wind the tape around one wire to hold it in its position. Refer to Figure 15.



2447765 S00061545041\_V1

#### CONFIGURATIONS OF THE LAYERS OF TAPE

Figure 15

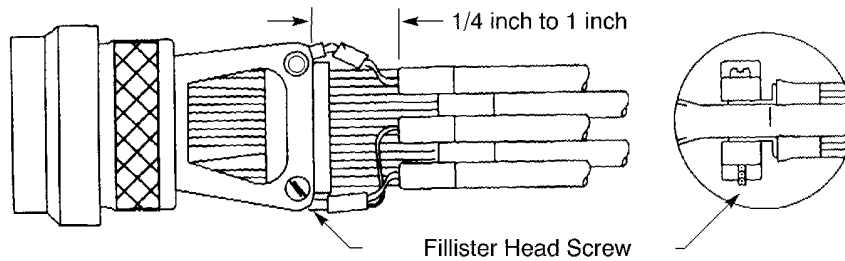
- (b) Continue to wind the tape around the wire harness until the tape is fully installed.
- (7) If spacers are necessary, specified, or installed on the initial backshell assembly, make a selection of a spacer from Table 4.
- Make sure that the spacer is the smallest that can make a tight fit of the wire harness in the strain relief.
- NOTE:** A minimum of two spacers are necessary, one for each screw.
- NOTE:** The initial spacers can be installed again if they do not have damage.
- (8) If lockwashers are supplied, put a lockwasher on each screw.
- (9) If 1 to 4 terminal lugs must be installed, put each terminal lug in its position. Refer to Figure 16.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS



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#### CABLE CLAMP CONFIGURATION WITH 1 TO 4 TERMINAL LUGS

Figure 16

- (a) Put a screw through a hole in a saddle bar.
- (b) Put a terminal lug on the screw.
- (c) If spacers are necessary, put a spacer on the screw.
- (d) Put the saddle bar with the screw against the backshell legs.
- (e) Put the screw through the hole in the backshell leg.

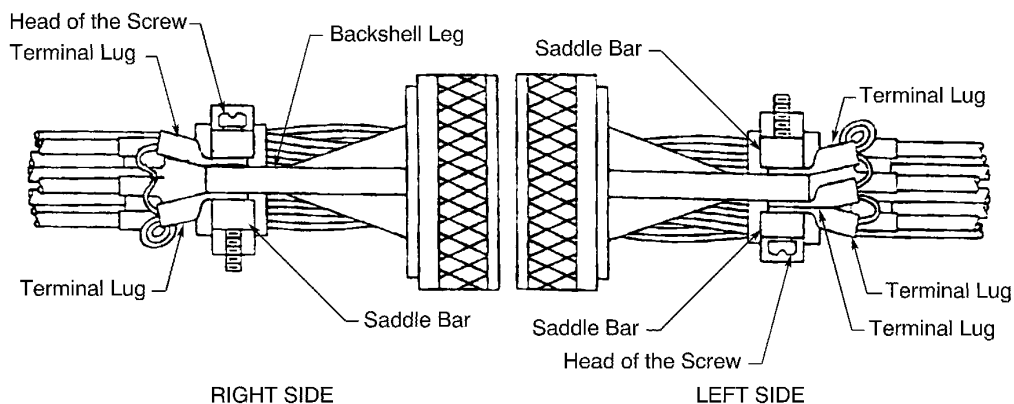
From the rear of the backshell, make sure that the head of the screw on the right is pointed up and the head on the screw on the left is pointed down.
- (f) If the wire harness has more terminal lugs, put a terminal lug on the screw.
- (g) Put the other saddle bar against the backshell legs.
- (h) Engage the threads of the screw and the threads of the nut.
- (i) Put a screw through the empty hole in the saddle bar.

From the rear of the backshell, make sure that the head of the screw on the right is pointed up and the head on the screw on the left is pointed down.
- (j) If the wire harness has more terminal lugs, put a terminal lug on the screw.
- (k) Push the screw through the hole in the backshell leg.
- (l) If the wire harness has more terminal lugs, put a terminal lug on the screw.
- (m) If spacers are necessary, put a spacer on the screw.
- (n) Engage the threads of the screw and the threads of the nut.
- (10) If 5 terminal lugs must be installed, put each terminal lug in its position. Refer to Figure 17.

**20-25-12**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS



2445712 S00061545043\_V1

#### CABLE CLAMP CONFIGURATION WITH 5 TERMINAL LUGS

Figure 17

- (a) Put a screw through a hole in a saddle bar.
- (b) Put a terminal lug on the screw.
- (c) Put a different terminal lug on the screw.
- (d) If spacers are necessary, put a spacer on the screw.
- (e) Put the saddle bar with the screw against the backshell legs.
- (f) Put the screw through the hole in the backshell leg.

From the rear of the backshell, make sure that the head of the screw on the right is pointed up and the head on the screw on the left is pointed down.

- (g) Put a terminal lug on the screw.
- (h) Put the other saddle bar against the backshell legs.
- (i) Engage the threads of the screw and the threads of the nut.
- (j) Put a screw through the empty hole in the saddle bar.

From the rear of the backshell, make sure that the head of the screw on the right is pointed up and the head on the screw on the left is pointed down.

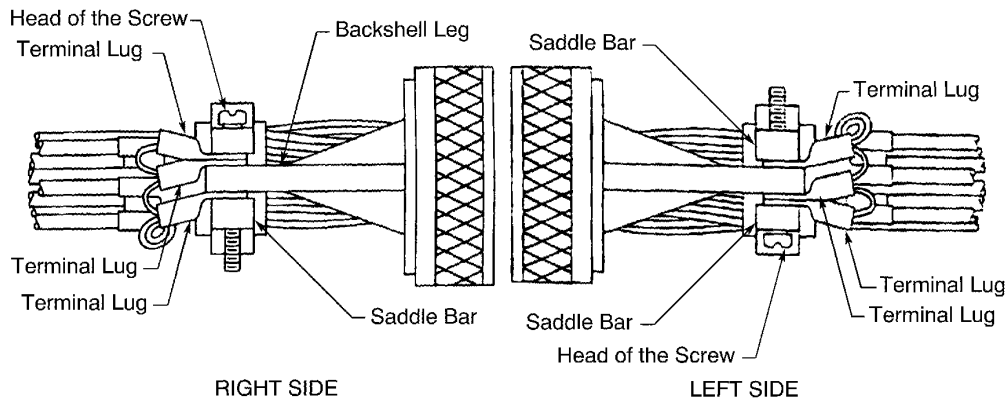
- (k) Put a terminal lug on the screw.
- (l) Put the screw through the hole in the backshell leg.
- (m) If spacers are necessary, put a spacer on the screw.
- (n) Put the remaining terminal lug on the screw.

**20-25-12**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

- (o) Engage the threads of the screw and the threads of the nut.
- (11) If the 6 terminal lugs must be installed, put each terminal lug in its position. Refer to Figure 18.



2445713 S00061545044\_V1

#### CABLE CLAMP CONFIGURATION WITH 6 TERMINAL LUGS

Figure 18

- (a) Put a screw through a hole in a saddle bar.
- (b) Put a terminal lug on the screw.
- (c) Put a different terminal lug on the screw.
- (d) If spacers are necessary, put a spacer on the screw.
- (e) Put the saddle bar with the screw against the backshell legs.
- (f) Put the screw through the hole in the backshell leg.

From the rear of the backshell, make sure that the head of the screw on the right is pointed up and the head on the screw on the left is pointed down.

- (g) Put a terminal lug on the screw.
- (h) Put the other saddle bar against the backshell legs.
- (i) Engage the threads of the screw and the threads of the nut.
- (j) Put a screw through the empty hole in the saddle bar.

From the rear of the backshell, make sure that the head of the screw on the right is pointed up and the head on the screw on the left is pointed down.

- (k) Put a terminal lug on the screw.
- (l) Put a different terminal lug on the screw.

**20-25-12**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

- (m) Put the screw through the hole in the backshell leg.
  - (n) If spacers are necessary, put a spacer on the screw.
  - (o) Put the remaining terminal lug on the screw.
  - (p) Engage the threads of the screw and the threads of the nut.
- (12) Tighten the cable clamp screws.
- Make sure that:
- The cable clamp does not crush or pinch the wire harness
  - If the saddle bar and the backshell leg do not touch, the distance between the saddle bar and the backshell leg is approximately equal on each side of the cable clamp
  - The layers of tape are not pinched between the saddle bars and the backshell leg
  - The screws do not cause an interference with a wire harness or a component.
- NOTE:** It is not necessary for the saddle bars to touch the legs of the backshell.
- (13) If the wire harness is not held tightly:
- (a) Remove the cable clamp screws.
  - (b) Wind two layers of tape on the wire harness on the existing layers of tape.
  - (c) Do Step 4.G.(9), Step 4.G.(10), or Step 4.G.(11) again.
  - (d) Do Step 4.G.(12) again.
- (14) Torque the screws to the specified value in Table 11.
- Make sure that:
- The saddle bars are tight against the shield ground wire terminal lug
  - The shield ground wire terminal lug is tight against the backshell leg
  - The clamp does not crush or pinch the wire harness
  - The layers of tape are not pinched between the saddle bars and the backshell leg
  - The screws do not cause an interference with a wire harness or a component.

#### H. Strain Relief Assembly - 45 Degree or 90 Degree Backshell

Table 12  
CABLE CLAMP SCREW TORQUE VALUES

Screw Size	Torque (inch-pounds)	
	Minimum	Maximum
4	10	12
6	15	23
8	25	30

20-25-12





707, 727-787

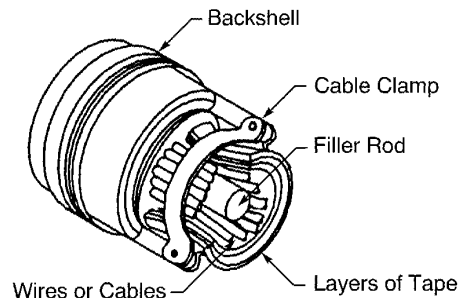
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

Table 13  
FLAT WASHER PART NUMBERS

Part Number	Supplier
NAS620()	Available source

- (1) Make a selection of a torque driver from Table 6.
- (2) Make a selection of a tape from Table 8.  
Make sure that the tape is a minimum of 0.12 inch wider than the saddle bar.  
**NOTE:** An equivalent tape is a satisfactory alternative. Refer to Subject 20-00-11.  
**NOTE:** A thicker tape is recommended when the difference between the initial diameter of the wire harness and the inner diameter of the strain relief is large.
- (3) Align the screw holes in a saddle bar with the screw holes in the legs of the backshell.
- (4) Make a mark on the wire harness at the center of the width of the saddle bar.
- (5) If the assembled contacts are installed only near the outer edge of the connector grommet:
  - (a) Make a selection of a filler rod from Table 8.
  - (b) Put the filler rod in the center of the group of wires where the saddle bar goes across the wire harness. Refer to Figure 19.



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#### POSITION OF THE FILLER ROD

Figure 19

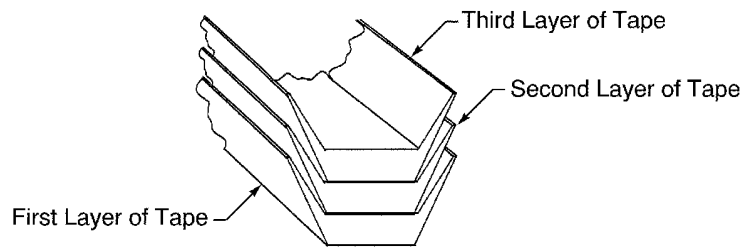
- (6) Put a minimum of two layers of tape on the wires or cables at the location of the mark.  
Make sure that:

**20-25-12**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

- The outer diameter of the wire harness with the layers of tape is larger than the inner diameter of the saddle bars
- The center of the layers of tape is aligned with the center of the saddle bar
- The edge of the tape extends a minimum of 0.06 inch farther than each edge of the saddle bar
- The edge of one layer of the tape is a maximum of 0.05 inch from the edge of a different layer of tape
- For U shaped tape, each layer of tape makes a 100 percent overlap.

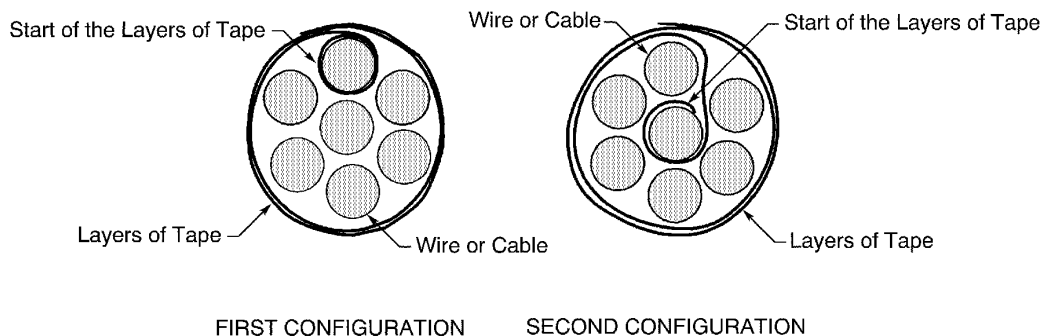


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#### CONFIGURATION OF THE LAYERS OF U SHAPED TAPE

Figure 20

- (a) Wind the tape around one wire to hold it in its position. Refer to Figure 21.



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#### CONFIGURATIONS OF THE LAYERS OF TAPE

Figure 21

- (b) Continue to wind the tape around the wire harness until the tape is fully installed.

**20-25-12**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

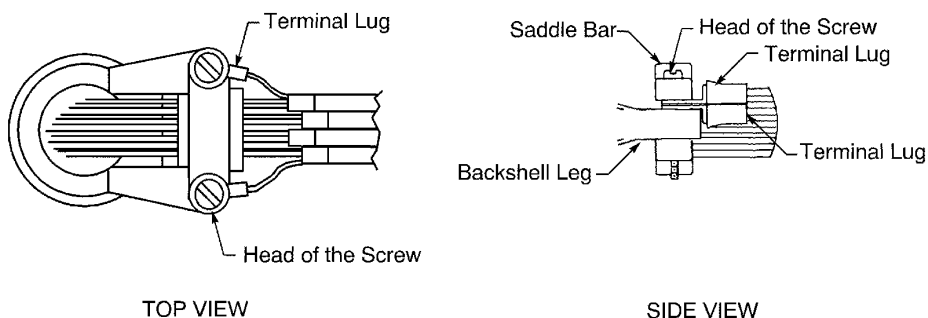
- (7) If spacers are necessary, specified, or installed on the initial backshell assembly, make a selection of a spacer from Table 4.

Make sure that the spacer is the smallest that can make a tight fit of the wire harness in the strain relief.

**NOTE:** A minimum of two spacers are necessary, one for each screw.

**NOTE:** The initial spacers can be installed again if they do not have damage.

- (8) If 1 to 4 terminal lugs must be installed, put each terminal lug in its position. Refer to Figure 22.



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#### CABLE CLAMP CONFIGURATION WITH 1 TO 4 TERMINAL LUGS

Figure 22

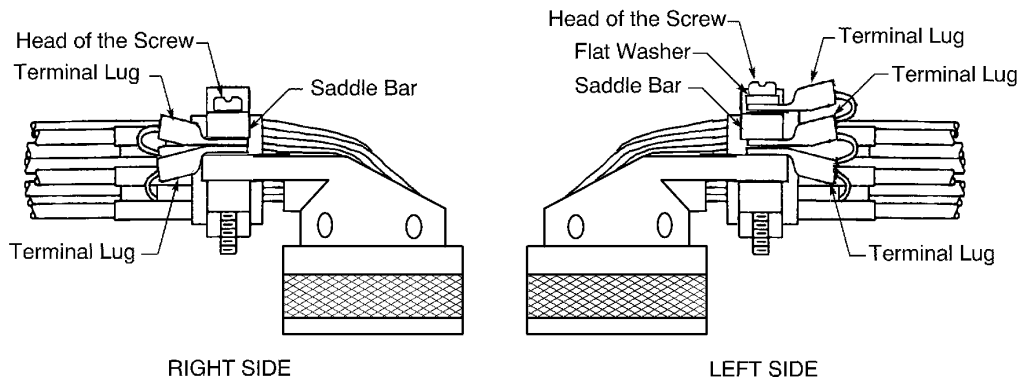
- (a) If lockwashers are supplied, put a lockwasher on each screw.
- (b) Put a screw through a hole in the saddle bar.
- (c) Put a terminal lug on the screw.
- (d) If the wire harness has more terminal lugs, put a terminal lug on the screw.
- (e) If spacers are necessary, put a spacer on the screw.
- (f) Put the saddle bar against the backshell legs.
- (g) Engage the threads of the screw and the threads of the nut.
- (h) Put the remaining screw through the hole in the other end of the saddle bar.
- (i) If the wire harness has more terminal lugs, put the remaining terminal lugs on the screw.
- (j) If spacers are necessary, put a spacer on the screw.
- (k) Engage the threads of the screw and the threads of the nut.

**20-25-12**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

- (9) If 5 terminal lugs must be installed, put each terminal lug in its position. Refer to Figure 23.



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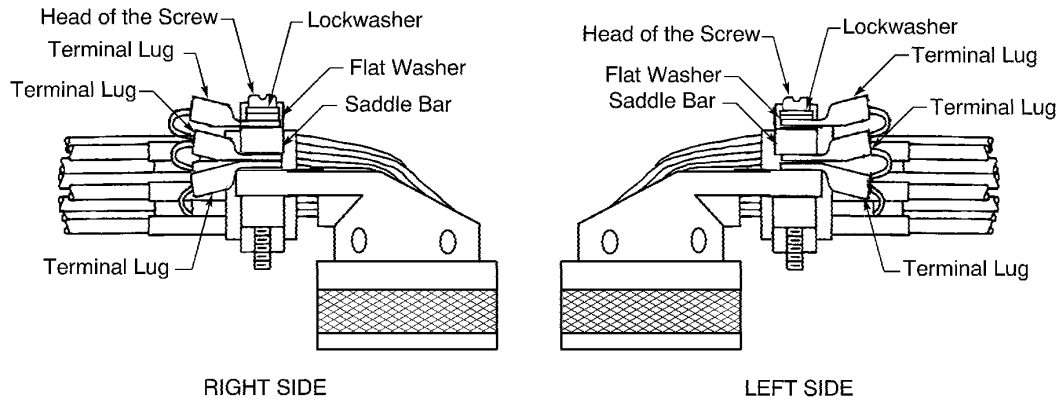
#### CABLE CLAMP CONFIGURATION WITH 5 TERMINAL LUGS

Figure 23

- (a) Make a selection of the applicable size of flat washer from Table 13.
  - (b) If lockwashers are supplied, put a lockwasher on each screw.
  - (c) Put the flat washer on the one of the screws.
  - (d) Put a terminal lug on the screw against the flat washer.
  - (e) Put the screw through the hole in the saddle bar.
  - (f) Put a terminal lug on the screw.
  - (g) Put a different terminal lug on the screw.
  - (h) If spacers are necessary, put a spacer on the screw.
  - (i) Put the saddle bar against the backshell legs.
  - (j) Engage the threads of the screw and the threads of the nut.
  - (k) Put the other screw through the hole on the other end of the saddle bar.
  - (l) Put a terminal lug on the screw.
  - (m) If spacers are necessary, put a spacer on the screw.
  - (n) Put the remaining terminal lug on the screw.
  - (o) Engage the threads of the screw and the threads of the nut.
- (10) If 6 terminal lugs must be installed, put each terminal lug in its position. Refer to Figure 24.

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS



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#### CABLE CLAMP CONFIGURATION WITH 6 TERMINAL LUGS

Figure 24

- (a) Make a selection of the applicable size of flat washer from Table 13.
- (b) If lockwashers are supplied, put a lockwasher on each screw.
- (c) Put a flat washer on each screw.
- (d) Put a terminal lug on the screw against the flat washer.
- (e) Put the screw through the hole in the saddle bar.
- (f) Put a terminal lug on the screw.
- (g) Put a different terminal lug on the screw.
- (h) If spacers are necessary, put a spacer on the screw.
- (i) Put the saddle bar against the backshell legs.
- (j) Engage the threads of the screw and the threads of the nut.
- (k) Put a terminal lug on the remaining screw.
- (l) Put the screw through the hole on the other end of the saddle bar.
- (m) Put a terminal lug on the screw.
- (n) Put a different terminal lug on the screw.
- (o) If spacers are necessary, put a spacer on the screw.
- (p) Engage the threads of the screw and the threads of the nut.
- (11) Tighten the cable clamp screws.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF STRAIN RELIEF BACKSHELLS AND SHIELD TERMINATION WITH TERMINAL LUGS

Make sure that:

- The cable clamp does not crush or pinch the wire harness
- If the saddle bar and the backshell leg do not touch, the distance between the saddle bar and the backshell leg is approximately equal on each side of the cable clamp
- The layers of tape are not pinched between the saddle bars and the backshell leg
- The screws do not cause an interference with a wire harness or a component.

**NOTE:** It is not necessary for the saddle bars to touch the legs of the backshell.

(12) If the wire harness is not held tightly:

- (a) Remove the cable clamp screws.
- (b) Wind two layers of tape on the wire harness on the existing layers of tape.
- (c) Do Step 4.H.(8), Step 4.H.(9), or Step 4.H.(10) again.
- (d) Do Step 4.H.(11) again.

(13) Torque the screws to the specified value in Table 12.

Make sure that:

- The saddle bars are tight against the shield ground wire terminal lug
- The shield ground wire terminal lug is tight against the backshell leg
- The clamp does not crush or pinch the wire harness
- The layers of tape are not pinched between the saddle bars and the backshell leg
- The screws do not cause an interference with a wire harness or a component.

(14) If screws are too long and screws with a shorter length are not available, cut off the unwanted length.

Make sure that the end of the screw is smooth and has no rough edges.

**CAUTION:** DO NOT LET METAL SAWDUST OR THE UNWANTED LENGTH OF THE SCREW FALL ON OR INTO THE WIRE HARNESS OR ON THE REAR GROMMET OF THE CONNECTOR. SHARP METAL PIECES CAN CAUSE DAMAGE TO THE WIRES AND THE CONNECTOR.

(15) If safety wire is necessary, install safety wire on each screw.

Refer to Subject 20-60-07 for:

- The applicable conditions that make the installation of the safety wire on the cable clamp screw necessary
- The procedures to install the safety wire.

**20-25-12**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

#### TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
<b>1. <u>PART NUMBERS AND DESCRIPTION</u></b>	<b>2</b>
A. Connector Backshell Part Numbers	2
B. Connector Backshell Description	2
<b>2. <u>BACKSHELL DISASSEMBLY</u></b>	<b>4</b>
A. Disassembly of a Peripheral Backshell with 1 Ground Ring	4
B. Disassembly of a Peripheral Backshell with 2 Ground Rings	5
<b>3. <u>TORQUE VALUES FOR BACKSHELL ASSEMBLY</u></b>	<b>7</b>
A. Backshell to Connector Torque	7
B. Strain Relief Adapter to Backshell Torque	7
<b>4. <u>ASSEMBLY OF THE GLENAIR G387() AND G4993 PERIPHERAL BACKSHELLS</u></b>	<b>8</b>
A. Cable Preparation	8
B. Backshell Installation	9
C. Strain Relief Adapter Installation	9
<b>5. <u>ASSEMBLY OF THE GLENAIR 380()003, 387(), G9034(), AND G9166() PERIPHERAL BACKSHELLS</u></b>	<b>9</b>
A. Cable Preparation	9
B. Backshell Installation	10
C. Strain Relief Adapter Installation	11
<b>6. <u>ASSEMBLY OF THE GLENAIR 380()001() PERIPHERAL BACKSHELL</u></b>	<b>11</b>
A. Cable Preparation	11
B. Backshell Installation	12
C. Strain Relief Adapter Installation	13
<b>7. <u>ASSEMBLY OF THE S280W605-() PERIPHERAL BACKSHELL</u></b>	<b>14</b>
A. Cable Preparation	14
B. Backshell Installation	19
C. Strain Relief Adapter Installation	21

**20-25-13**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

This Subject gives the procedures to assemble strain relief backshells that have inner and outer ground rings. For the procedures to assemble other strain relief backshells, refer to:

- Subject 20-60-09 for the assembly of backshells that do not terminate a shield
- Subject 20-25-12 for the assembly of backshells that terminate shields with shield ground wires and terminal lugs
- Subject 20-25-14 for the assembly of backshells that terminate shields with a shield terminator band
- Subject 20-25-15 for the assembly of backshells that have a braided shield sock.

#### 1. PART NUMBERS AND DESCRIPTION

##### A. Connector Backshell Part Numbers

Table 1  
PERIPHERAL BACKSHELL PART NUMBERS

Boeing Specification	Configuration	Part Number	Supplier
-	-	380()001()	Glenair
-	-	380()003	Glenair
-	-	387()	Glenair
S280W605()-1	Straight Cable	467AS009LF10FR	Glenair
S280W605()-2	45 Degree Cable	467AH009LF10FR	Glenair
S280W605()-3	90 Degree Cable	467AJ009LF10FR	Glenair
-	-	G387()	Glenair
-	-	G4993	Glenair
-	-	G9034()	Glenair
-	-	G9166()	Glenair

##### B. Connector Backshell Description

The peripheral backshell has these technical features:

- It is conductive
- It gives a low impedance connection from the connector to the cable shield
- It can be repaired.

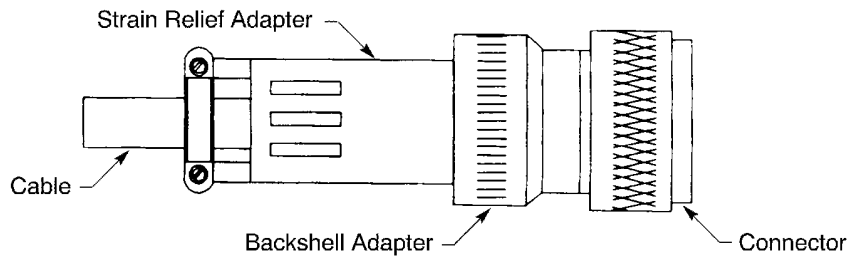
**NOTE:** Many components of the different peripheral backshells have the same configuration. The primary difference between the backshells are the design and configuration of the ground rings.

**20-25-13**



## STANDARD WIRING PRACTICES MANUAL

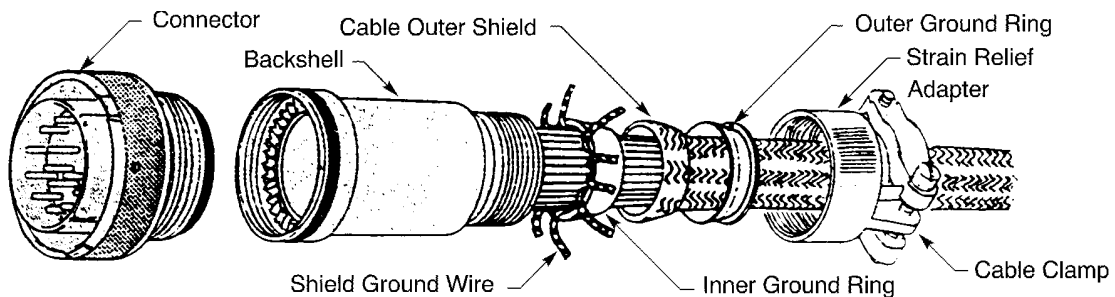
### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2445714 S00061545050\_V1

#### S280W605() PERIPHERAL BACKSHELL ASSEMBLY

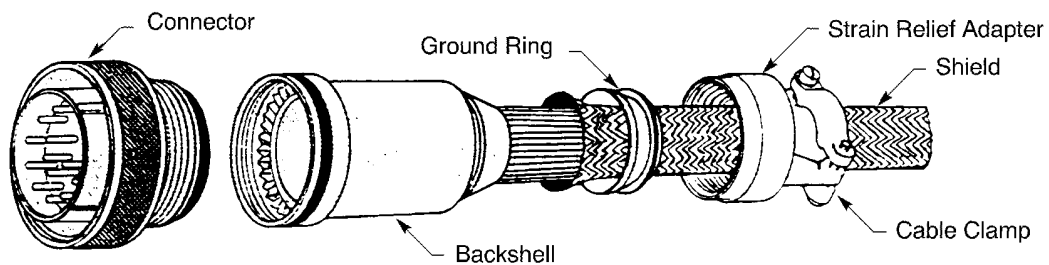
Figure 1



2445715 S00061545051\_V1

#### CONFIGURATION OF THE GLENAIR 380()001() PERIPHERAL BACKSHELL

Figure 2



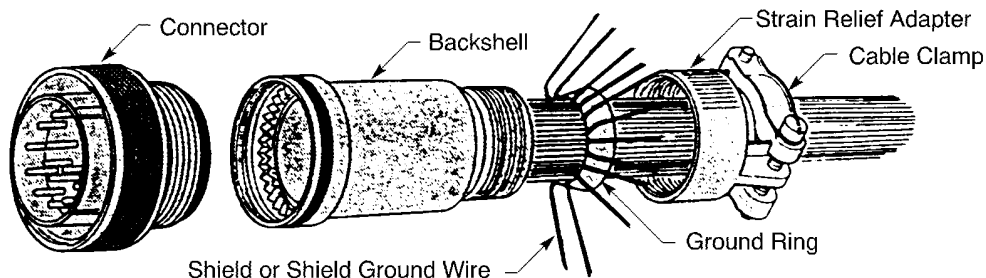
2445716 S00061545052\_V1

#### CONFIGURATION OF THE GLENAIR G387() AND G4993 PERIPHERAL BACKSHELLS

Figure 3

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2452934 S00061545053\_V1

### CONFIGURATION OF THE GLENAIR 380()003, 387(), G9034(), AND G9166() PERIPHERAL BACKSHELLS

Figure 4

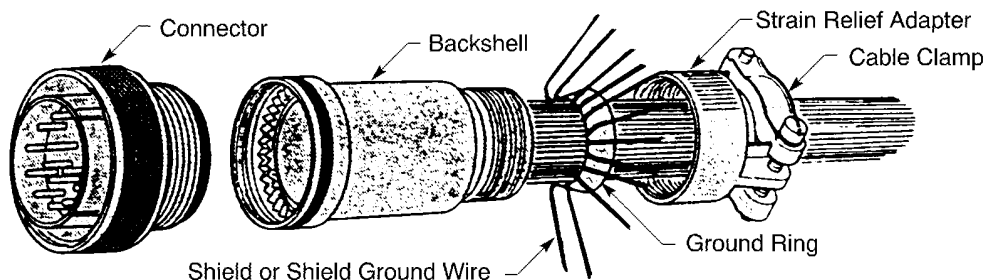
## 2. BACKSHELL DISASSEMBLY

### A. Disassembly of a Peripheral Backshell with 1 Ground Ring

This paragraph gives the procedure to disassemble these Glenair peripheral backshells:

- 380()003
- 387()
- G387()
- G4993
- G9034()
- G9166().

**NOTE:** Figure 6 and Figure 5 show straight backshells. The procedure to disassemble the 45 degree configuration and 90 degree configuration is the same as the procedure for the straight configuration.



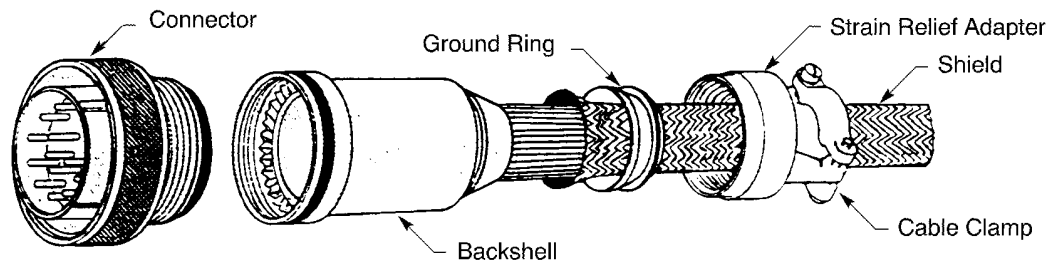
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### DISASSEMBLY OF THE GLENAIR 380()003, 387(), G9034(), AND G9166() BACKSHELLS

Figure 5

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2445716 S00061545052\_V1

#### DISASSEMBLY OF THE GLENAIR G387() AND G4993 BACKSHELLS

Figure 6

- (1) Loosen the cable clamp screws of the strain relief adapter.
  - (2) Remove any insulation tape on the cable that was the saddle bars of the clamp.
  - (3) Loosen the strain relief adapter until it is free from the body of the backshell.
  - (4) Push the adapter away from the body of the backshell.
  - (5) Push the ground ring away from the body of the backshell.
  - (6) Push the strands of the outer shield of the primary cable against the surface of the cable so that the end of the shield is flat against the wires in the cable.
  - (7) Loosen the body of the backshell from the connector.
  - (8) Carefully push the body of the backshell away from the connector.
- Make sure that:
- The end of the shield goes into the cable exit at the rear of the backshell
  - The backshell moves smoothly on the surface of the shield
  - The shield stays symmetrical around the wires in the cable.
- (9) Disassemble the connector. Refer to the applicable Subject.
  - (10) Remove these components from the cable:
    - The body of the backshell
    - The ground ring
    - The strain relief adapter.

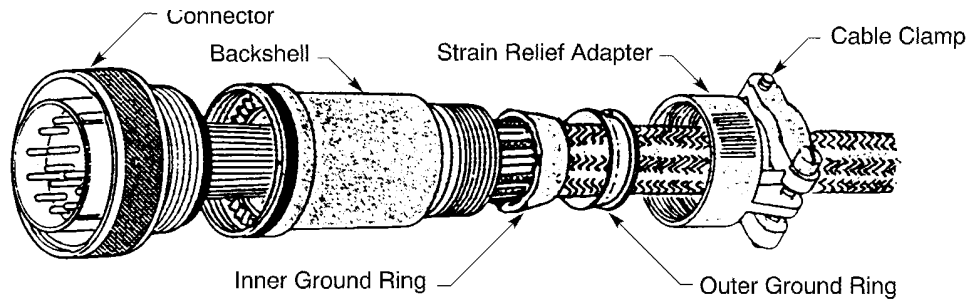
#### B. Disassembly of a Peripheral Backshell with 2 Ground Rings

This paragraph gives the procedure to disassemble the Glenair 380()001() peripheral backshell.

**NOTE:** Figure 7 shows a straight backshell. The procedure to disassemble the 45 degree configuration and 90 degree configuration is the same as the procedure for the straight configuration.

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2445718 S00061545054\_V1

#### DISASSEMBLY OF THE GLENAIR 380()001() BACKSHELL

Figure 7

- (1) Loosen the cable clamp screws of the strain relief adapter.
- (2) Remove any insulation tape on the cable that was the saddle bars of the clamp.
- (3) Loosen the strain relief adapter until it is free from the body of the backshell.
- (4) Push the adapter away from the body of the backshell.
- (5) Push the outer ground ring away from the body of the backshell.
- (6) Push the strands of the outer shield of the primary cable under the end of the inner ground ring with a plastic awl or an equivalent tool.  
Make sure that the end of the shield is flat against the wires in the cable.
- (7) Move the inner ground ring away from the body of the backshell.  
Make sure that:
  - The ground ring moves smoothly on the surface of the shield
  - The shield stays symmetrical around the wires in the cable.
- (8) Loosen the body of the backshell from the connector.
- (9) Carefully push the body of the backshell away from the connector.  
Make sure that:
  - The end of the shield goes into the cable exit at the rear of the backshell
  - The backshell moves smoothly on the surface of the shield
  - The shield stays symmetrical around the wires in the cable.
- (10) Disassemble the connector. Refer to the applicable Subject.
- (11) Remove these components from the cable:
  - The body of the backshell
  - The inner ground ring
  - The outer ground ring
  - The strain relief adapter.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

#### 3. TORQUE VALUES FOR BACKSHELL ASSEMBLY

##### A. Backshell to Connector Torque

Table 2  
BACKSHELL TO CONNECTOR TORQUE VALUES

Connector Shell Size	Coupling Ring Torque (inch-pound)		Torque Wrench Setting (inch-pound)	
	Minimum	Maximum	Minimum	Maximum
10	45	50	39	44
12	65	70	56	61
14	85	90	73	78
16	105	110	91	96
18	135	140	117	122
20	145	150	125	130
22	145	150	125	130
24	145	150	125	130
28	155	160	134	139

##### B. Strain Relief Adapter to Backshell Torque

Table 3  
STRAIN RELIEF ADAPTER TO BACKSHELL TORQUE VALUES

Connector Shell Size	Strain Relief Torque (inch-pound)		Torque Wrench Setting (inch-pound)	
	Minimum	Maximum	Minimum	Maximum
10	45	50	39	44
12	45	50	39	44
14	45	50	39	44
16	45	50	39	44
18	55	60	48	53
20	75	80	65	70
22	85	90	73	78
24	95	100	81	86
28	105	110	91	96

20-25-13

**STANDARD WIRING PRACTICES MANUAL****ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS****4. ASSEMBLY OF THE GLENAIR G387() AND G4993 PERIPHERAL BACKSHELLS**

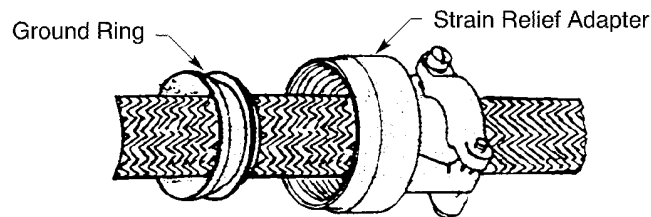
This paragraph gives the procedures to attach the end of the one shield of the primary cable to a backshell.

**A. Cable Preparation**

- (1) In order, put these components on the end of the cable:

- The strain relief adapter
- The ground ring.

Refer to Figure 8.



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**POSITION OF THE GROUND RING AND THE STRAIN RELIEF ADAPTER ON THE CABLE****Figure 8**

- (2) Temporarily attach the backshell to the connector.
- (3) Push the end of the cable into the backshell until the end of the cable touches the rear grommet of the connector.
- (4) If the cable has an outer jacket:
- (a) Make a mark on the jacket 0.5 inches away from the rear end of the backshell.
  - (b) Remove the length of jacket between the mark and the end of the cable. Refer to Subject 20-00-15.
- (5) If the cable does not have a jacket, make a mark on the shield of the cable at the rear end of the backshell.
- (6) Remove the backshell from the connector.
- (7) Put the backshell on the end of the cable so that the front end of the backshell is beyond the end of the cable.
- (8) If the cable does not have a jacket, remove the length of shield between the end of the cable and the mark from Step 4.A.(5). Refer to Subject 20-00-15.
- (9) If the cable has a jacket remove the necessary length of the shield so that the distance from the end of the shield to the end of the jacket is 0.5 inch. Refer to Subject 20-00-15.
- (10) Assemble the connector. Refer to the applicable Subject for the connector.

**20-25-13**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

#### B. Backshell Installation

- (1) Push the backshell along the cable until the front of the backshell touches the back of the connector.
- (2) Engage the threads of the backshell and the connector.
- (3) Torque the backshell to the value specified in Table 2 with a strap wrench that has a 0.375 inch drive.

#### C. Strain Relief Adapter Installation

- (1) Move the strands at the end of the shield apart with a plastic awl or an equivalent tool.
- (2) Put the strands of the shield in sequence on the outer surface of the slope at the rear end of the backshell body.  
Make sure that the strands of the shield do not make an overlap with each other.
- (3) Push the ground ring against the rear surface of the backshell so that the strands of the shield are between the ring and the slope of the backshell.
- (4) If the strands of the shield extend beyond the outer edge of the ground ring, cut the strands so that the end of the strands is aligned with the edge of the ground ring.
- (5) If it is necessary, put the sufficient layers of Scotch 70 insulation tape on the cable so that:
  - The layers of tape will be under the cable clamp
  - The quantity of the tape is sufficient for the cable clamp to hold the cable firmly in position.
- (6) Push the strain relief adapter against the rear of the backshell.
- (7) Engage the threads of the adapter and the backshell.
- (8) Torque the adapter to the value specified in Table 3 with a strap wrench that has a 0.375 inch drive.
- (9) Tighten the screws of the cable clamp.

#### 5. ASSEMBLY OF THE GLENAIR 380()003, 387(), G9034(), AND G9166() PERIPHERAL BACKSHELLS

This paragraph gives the procedures to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of the primary cable
- The adjacent shields of a primary cable
- The shield of each wire or cable in the primary cable.
- The adjacent shields of each wire or cable in the primary cable.

#### A. Cable Preparation

- (1) In order, put these components on the end of the cable:
  - The strain relief adapter
  - The ground ring

Refer to Figure 9.

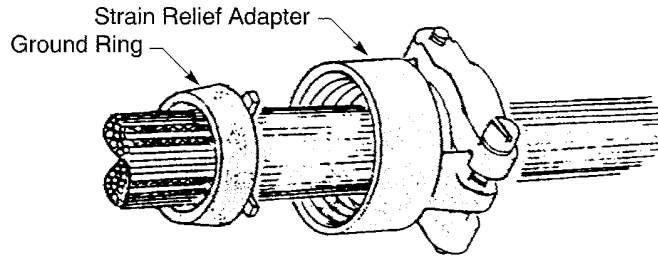
**20-25-13**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2445720 S00061545056\_V1

#### POSITION OF THE GROUND RING AND THE STRAIN RELIEF ADAPTER ON THE CABLE

Figure 9

- (2) Temporarily attach the backshell to the connector.
- (3) Push the end of the cable into the backshell until the end of the cable touches the rear grommet of the connector.
- (4) If the cable has an outer jacket:
  - (a) Make a mark on the jacket at the rear end of the backshell.
  - (b) Remove the length of jacket between the mark and the end of the cable. Refer to Subject 20-00-15.
- (5) If the cable does not have a jacket, make a mark on the shield of the cable at the rear end of the backshell.
- (6) Remove the backshell from the connector.
- (7) Put the backshell on the cable.
- (8) Assemble an uninsulated shield ground wire on the end of the shield of the primary cable. Refer to Subject 20-10-15.

Make sure that the shield ground wire configuration is applicable for the shielded cable.
- (9) Assemble an uninsulated shield ground wire on the shield of each shielded wire or shielded cable in the primary cable. Refer to Subject 20-10-15.

Make sure that the shield ground wire configuration is applicable for each shielded cable or shielded wire.
- (10) Assemble the connector. Refer to the applicable Subject for the connector.

#### B. Backshell Installation

- (1) Push the backshell along the cable until the front of the backshell touches the back of the connector.
- (2) Engage the threads of the backshell and the connector.
- (3) Torque the backshell to the value specified in Table 2 with a strap wrench that has a 0.375 inch drive.

**20-25-13**





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

#### C. Strain Relief Adapter Installation

- (1) Put the shield ground wire or wires in sequence around the body of the backshell.  
Make sure that each shield ground wire does not make an overlap with another shield ground wire.
- (2) Push the ground ring against the rear surface of the backshell so that the shield ground wires are between the ring and the rear end of the backshell.
- (3) If it is necessary, put the sufficient layers of Scotch 70 insulation tape on the cable so that:
  - The layers of tape will be under the cable clamp
  - The quantity of the tape is sufficient for the cable clamp to hold the cable firmly in position.
- (4) Make a selection of the location of the end of the shield ground wires for the completed assembly.
- (5) If the ends of the shield ground wires are at the rear end of the backshell:
  - (a) Cut each shield ground wire so that the end of each wire is aligned with the forward edge of the ground ring.
  - (b) Push the strain relief adapter against the rear of the backshell.
- (6) If the ends of the shield ground wires are at the rear end of the strain relief:
  - (a) Fold each shield ground wire back over the ground ring the wires are flat against the outer surface of the primary cable.
  - (b) Push the strain relief adapter over the shield ground wires until the adapter is against the rear of the backshell.  
Make sure that each shield ground wire is inside the adapter.
- (7) Engage the threads of the adapter and the backshell.
- (8) Torque the adapter to the value specified in Table 3 with a strap wrench that has a 0.375 inch drive.
- (9) Tighten the screws of the cable clamp.

#### 6. ASSEMBLY OF THE GLENAIR 380()001() PERIPHERAL BACKSHELL

This paragraph gives the procedures to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of each wire or cable in the primary cable.
- The adjacent shields of each wire or cable in the primary cable.

#### A. Cable Preparation

- (1) In order, put these components on the end of the cable:
  - The strain relief adapter
  - The outer ground ring
  - The inner ground ring.
- (2) Temporarily attach the backshell to the connector.
- (3) Push the end of the cable into the backshell until the end of the cable touches the rear grommet of the connector.

**20-25-13**

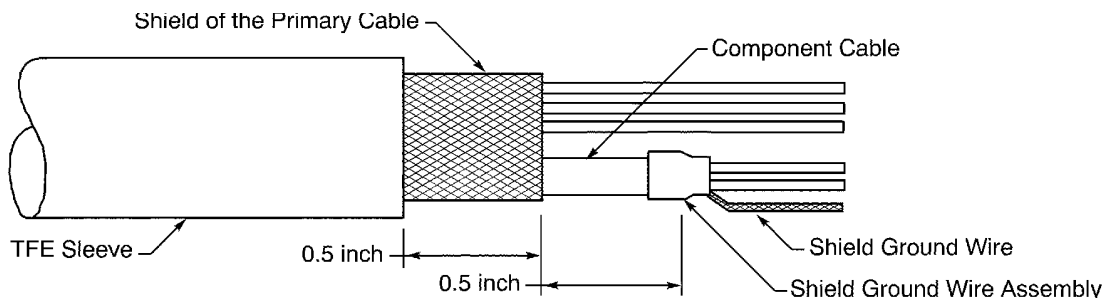
## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

- (4) If the cable has an outer jacket:
  - (a) Make a mark on the jacket 0.5 inches away from the rear end of the backshell.
  - (b) Remove the length of jacket between the mark and the end of the cable. Refer to Subject 20-00-15.
- (5) If the cable does not have a jacket, make a mark on the shield at the rear end of the backshell.
- (6) Remove the backshell from the connector.
- (7) Put the backshell on the cable.
- (8) If the cable has a jacket remove the necessary length of the shield so that the distance from the end of the shield to the end of the jacket is 0.5 inch. Refer to Subject 20-00-15.
- (9) If the cable does not have a jacket, remove the length of shield between the end of the cable and the mark from Step 6.A.(5). Refer to Subject 20-00-15.
- (10) Assemble an uninsulated shield ground wire on the shield of each shielded wire or shielded cable. Refer to Subject 20-10-15.

Make sure that:

- The shield ground wire configuration is applicable for each shielded cable or shielded wire
- The start of each shield ground wire is approximately 0.5 inch from the end of the shield of the primary cable; refer to Figure 10.



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### CONFIGURATION OF A COMPONENT SHIELD GROUND WIRE AND THE SHIELD OF THE PRIMARY CABLE

Figure 10

- (11) Assemble the connector. Refer to the applicable Subject for the connector.

#### B. Backshell Installation

- (1) Push the backshell along the cable until the front of the backshell touches the back of the connector.
- (2) Engage the threads of the backshell and the connector.
- (3) Torque the backshell to the value specified in Table 2 with a strap wrench that has a 0.375 inch drive.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

#### C. Strain Relief Adapter Installation

- (1) Put each shield ground wire of the cable or wires of the primary cable in sequence against the rear end of the backshell.  
Make sure that each shield ground wire does not make an overlap with another shield ground wire.
- (2) Push the inner ground ring against the rear surface of the backshell so that the shield ground wires are between the ring and the rear end of the backshell.
- (3) At the end of the shield of the primary cable, move the strands of the shield apart with a plastic awl or an equivalent tool.
- (4) Put the strands of the shield of the primary cable in sequence on the outer surface of the inner ground ring.  
Make sure that the strands of the shield do not make an overlap with each other.
- (5) Fold each shield ground wire back over the outer surface of the inner ground ring so that each shield ground wire:
  - Does not make an overlap with another shield ground wire
  - Makes an overlap with the strands of the shield of the primary cable
  - Is flat against the outer surface of the primary cable.
- (6) Make a selection of the location of the end of the shield ground wires for the completed assembly.
- (7) If the ends of the shield ground wires are at the rear end of the backshell:
  - (a) Cut each shield ground wire so that the end of each wire is aligned with the rear edge of the inner ground ring.
  - (b) Push the outer ground ring over each shield ground wire until it is against the inner ground ring.
  - (c) Push the strain relief adapter against the rear of the backshell.
- (8) If the ends of the shield ground wires are at the rear end of the strain relief:
  - (a) Push the outer ground ring over the shield ground wires until it is against the inner ground ring.
  - (b) Push the strain relief adapter over the shield ground wires until the adapter is against the inner ground ring.  
Make sure that each shield ground wire is inside the adapter.
- (9) Engage the threads of the adapter and the backshell.
- (10) Torque the adapter to the value specified in Table 3 with a strap wrench that has a 0.375 inch drive.
- (11) Tighten the screws of the cable clamp.

**20-25-13**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

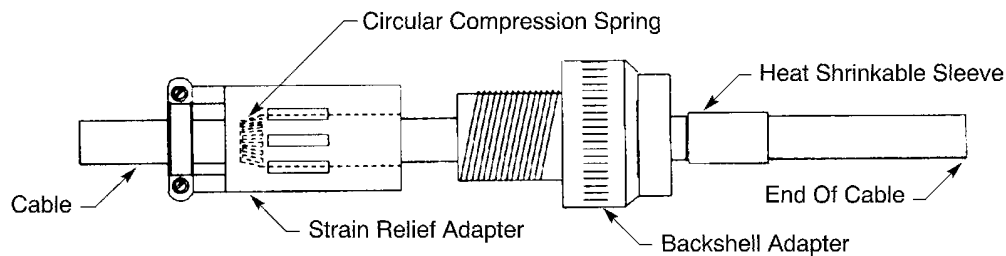
#### 7. ASSEMBLY OF THE S280W605-() PERIPHERAL BACKSHELL

**NOTE:** The assembly procedures for the 45 degree backshell and the 90 degree backshell are the same the procedures for the straight backshell.

##### A. Cable Preparation

Table 4  
OUTER JACKET REMOVAL LENGTH

Cable Exit Configuration	Removal Length L (inch)		
	Minimum	Target	Maximum
Straight	1.55	1.60	1.60
45 Degrees	2.35	2.40	2.40
90 Degrees	2.55	2.60	2.60



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#### POSITION OF THE STRAIN RELIEF ADAPTER AND THE BACKSHELL ADAPTER

Figure 11

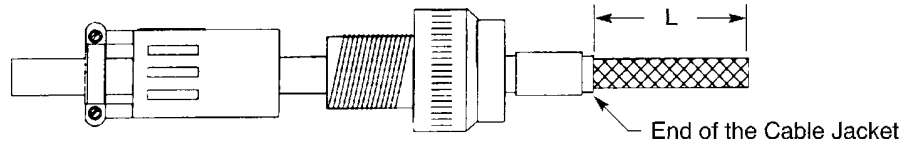
- (1) Look at the circular compression spring inside the strain relief adapter.  
Make sure that the spring is in the correct position.
- (2) Make a selection of a Grade B, Class 1 heat shrinkable sleeve from Subject 20-00-11.
- (3) In order, put these components on the cable:
  - The strain relief adapter
  - The backshell adapter
  - A 0.45 inch  $\pm$ 0.03 inch length of the heat shrinkable sleeve.
 Refer to Figure 11.
- (4) Remove the length L of the outer jacket from the end of the cable.  
Refer to Table 4 and Figure 12.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



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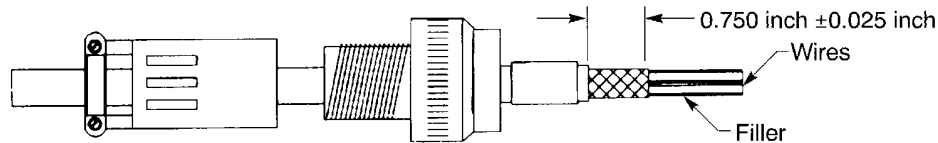
#### OUTER JACKET REMOVAL

Figure 12

- (5) Remove the necessary length of the shields so that the distance from the end of the cable jacket to the end of the shields is 0.75 inch  $\pm$  0.03 inch.

Refer to:

- Figure 13 for the straight configuration
- Figure 14 for the 45 degree configuration
- Figure 15 for the 90 degree configuration.



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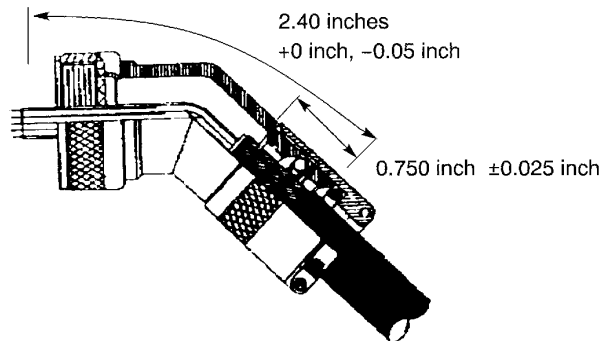
#### SHIELD REMOVAL LENGTH FOR A STRAIGHT CONFIGURATION BACKSHELL

Figure 13

20-25-13



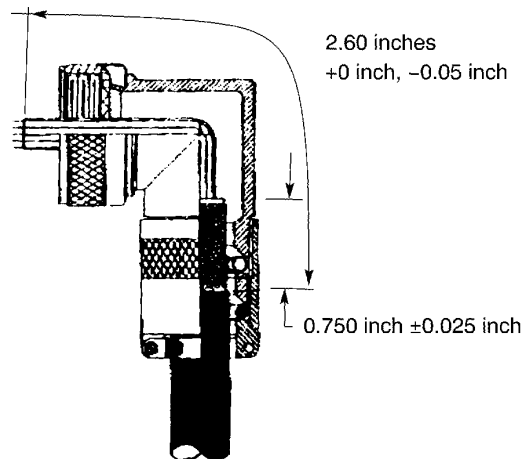
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**ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER**  
**AND OUTER GROUND RINGS**



2445724 S00061545061\_V1

**SHIELD REMOVAL LENGTH FOR A 45 DEGREE CONFIGURATION BACKSHELL**

**Figure 14**



2445725 S00061545062\_V1

**SHIELD REMOVAL LENGTH FOR A 90 DEGREE CONFIGURATION BACKSHELL**

**Figure 15**

- (6) Put the ferrule on the cable. Refer to Figure 16.

**20-25-13**

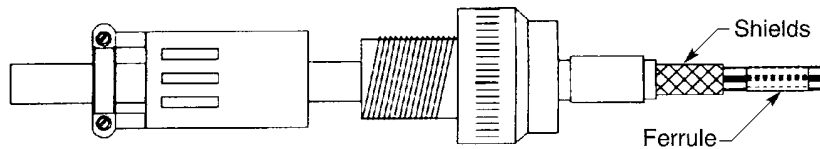


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

Make sure that all the wires and the fillers are in the ferrule.



2445726 S00061545063\_V1

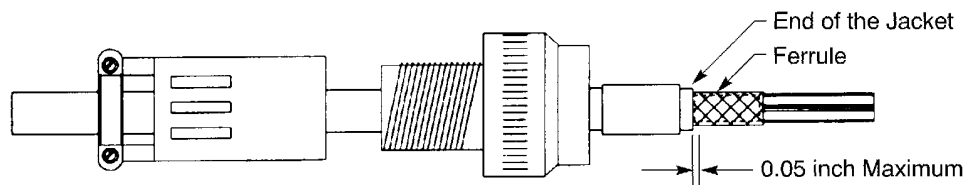
#### POSITION OF THE FERRULE OVER THE WIRES AND FILLERS OF THE CABLE

Figure 16

- (7) Carefully push the shields back away from the end the cable so that the shields become loose.
- (8) Push the ferrule under both shields. Refer to Figure 17.

Make sure that:

- The end of the ferrule is against the end of the cable jacket
- The distance from the end of the cable jacket to the rear end of the ferrule is not greater than 0.05 inch.



2445727 S00061545064\_V1

#### POSITION OF THE FERRULE UNDER THE SHIELDS

Figure 17

- (9) Cut the cable fillers so that the ends of the fillers are aligned with the forward end of the ferrule.
- (10) To make the shields smooth, carefully push the shields toward end of the cable.

Make sure that:

- The ferrule does not move
- The distance from the end of the cable jacket to the rear end of the ferrule is not greater than 0.05 inch.

- (11) Cut the shields so that the distance from the ends of the shields to the end of the cable jacket 0.70 inch +0 inch, -0.03 inch. Refer to Figure 18.

Make sure that the ends round conductors of the outer shield are aligned with the ends of the flat conductors of the inner shield.

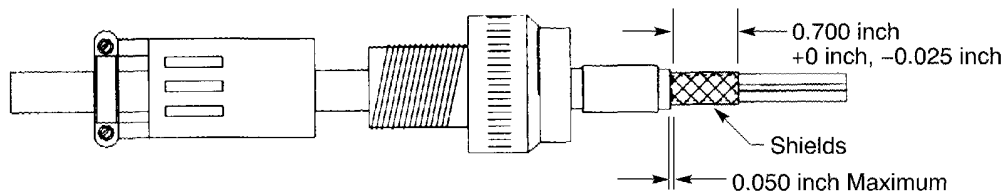
**20-25-13**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



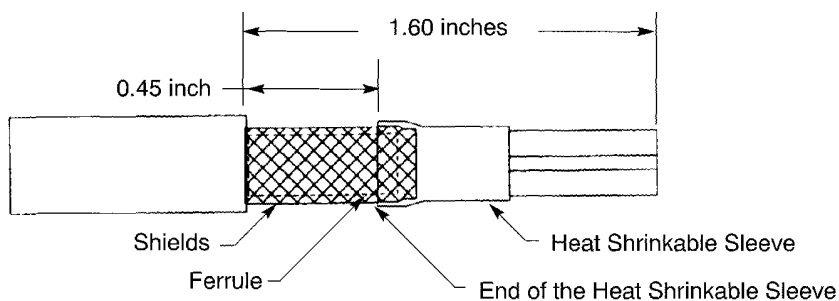
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#### DISTANCE FROM THE END OF THE CABLE JACKET TO THE END OF THE SHIELDS

Figure 18

- (12) Put the wires in a sequence that agrees with the contact configuration of the connector.
- (13) Push the heat shrinkable sleeve over the shields and the ferrule until the distance from the end of the cable jacket to the rear end of the sleeve is 0.45 inch  $\pm 0.03$  inch

Refer to Figure 19.



2445729 S00061545066\_V1

#### POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE SHIELD

Figure 19

- (14) Shrink the sleeve into position. Refer to Subject 20-10-14.
- (15) Examine the cable to make sure that the distance from the end of the cable jacket to the end of the wires agrees with the specified distance in Table 4.
- (16) If distance from the end of the jacket to the end of any wire is longer than the specified distance, cut the necessary length from the end of the wire.
- (17) Assemble the connector. Refer to the applicable Subject for the connector.

**20-25-13**





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS

#### B. Backshell Installation

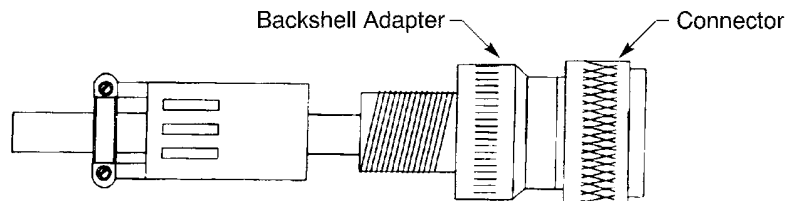
- (1) To hold the connector in position, attach the connector to a plug board.

**NOTE:** A satisfactory alternative is to use some other tool that:

- Can hold the connector stable
- Does not cause damage to the connector.

- (2) Push the backshell adapter toward the connector until the teeth in the adapter are against the teeth at the rear of the connector.
- (3) Carefully turn the coupling nut of the adapter until the teeth are fully engaged with the teeth in the back of the connector.

Refer to Figure 20.



2445730 S00061545067\_V1

#### POSITION OF THE BACKSHELL ADAPTER ON THE CONNECTOR

Figure 20

- (4) Torque the adapter to 75 inch-pounds  $\pm$  5 inch-pounds.
- (5) Examine the position of the heat shrinkable sleeve in relation to the chamfer of the backshell adapter.

Make sure that the rear edge of the heat shrinkable sleeve is aligned with or inside the forward edge of the chamfer.

Refer to:

- Figure 21 for the incorrect position of the sleeve
- Figure 22 for the correct position of the sleeve.

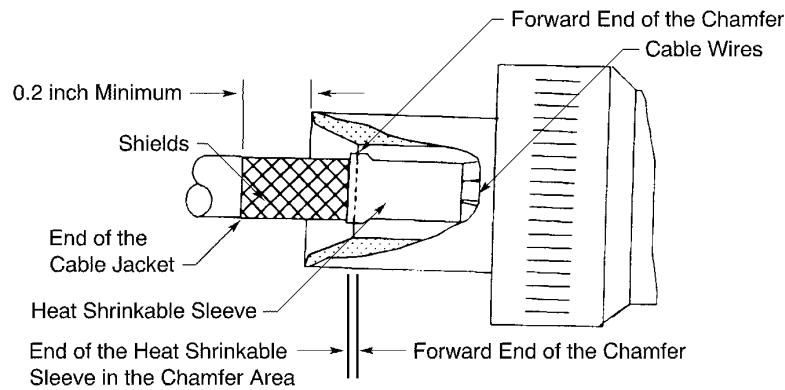
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707, 727-787

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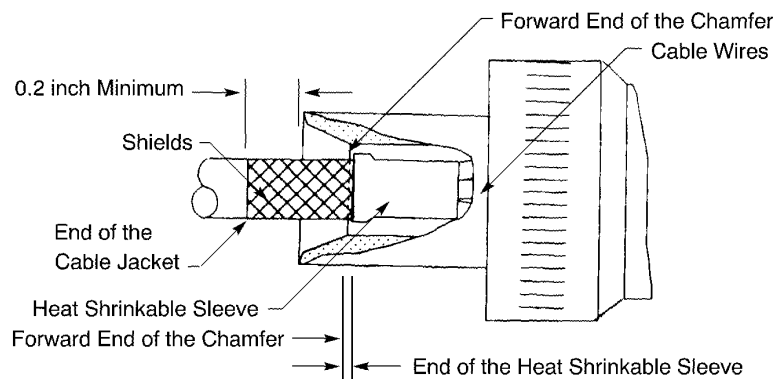
### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2445731 S00061545068\_V1

#### INCORRECT POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 21



2445732 S00061545069\_V1

#### CORRECT POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 22

- (6) If the position of the sleeve is not correct:

**20-25-13**

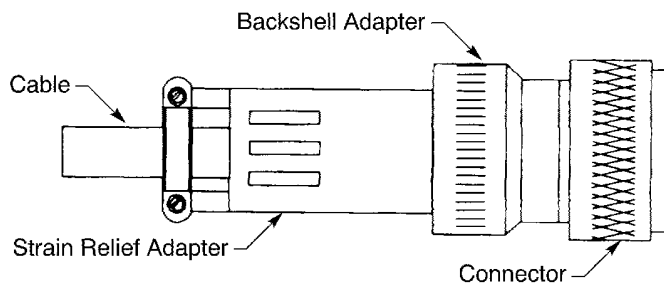
**STANDARD WIRING PRACTICES MANUAL****ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS**

- (a) Disconnect the backshell adapter from the connector.
- (b) Disassemble the connector. Refer to the applicable Subject for the connector.
- (c) Remove the heat shrinkable sleeve sleeve.
- (d) Do the cable preparation and the backshell installation again.

Refer to Paragraph 7.A. and Paragraph 7.B.

**C. Strain Relief Adapter Installation**

- (1) Push the strain relief adapter until it is against the backshell adapter. Refer to Figure 23.



2445733 S00061545070\_V1

**POSITION OF THE STRAIN RELIEF ADAPTER****Figure 23**

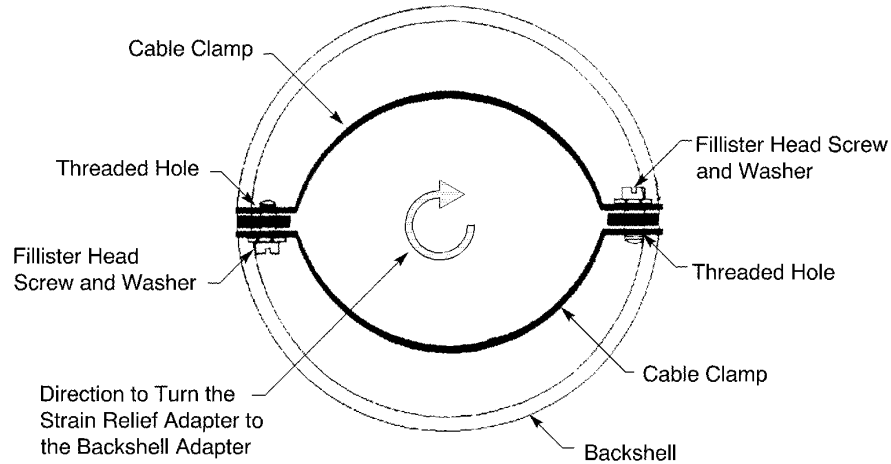
- (2) Engage the threads of the strain relief adapter and the backshell adapter.
- (3) Torque the strain relief adapter to 25 inch-pound  $\pm$  5 inch-pounds.
- (4) Install the saddle clamps. Refer to Figure 24.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND BACKSHELLS THAT HAVE INNER AND OUTER GROUND RINGS



2445734 S00061545071\_V1

#### INSTALLATION OF THE SADDLE CLAMPS

Figure 24

- (5) Tighten the cable clamp screws so that the clamp holds the cable tightly.  
Make sure that the surfaces of the saddle clamps are against the surfaces of the strain relief adapter.

**NOTE:** It is not necessary to put tape on the cable for protection.

**20-25-13**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
<b>1. <u>PART NUMBERS AND DESCRIPTION</u></b>	<b>4</b>
A. Applicable Backshells	4
B. Glenair Shield Terminator Bands	11
C. BACB42F() Shield Terminator Bands	12
D. Necessary Materials for Backshell Assembly	14
<b>2. <u>SHIELD TERMINATOR BAND REMOVAL</u></b>	<b>14</b>
A. Removal of the Glenair 687-062-0() Shield Terminator Band	14
B. Removal of the BACB42F() Shield Terminator Band	14
<b>3. <u>ASSEMBLY OF THE GLENAIR 387()020 BACKSHELL</u></b>	<b>15</b>
A. Backshell Part Numbers	15
B. Preparation of Cable with a Tin Plated or a Silver Plated Shield	15
C. Preparation of a Cable with a Nickel Plated Shield	15
D. Connector Assembly	16
E. Backshell Installation	16
F. Installation of the Glenair 687-062-0() Shield Terminator Band	18
<b>4. <u>ASSEMBLY OF THE GLENAIR 440()069 BACKSHELL</u></b>	<b>20</b>
A. Preparation of Cable with a Shield	20
B. Connector Assembly	21
C. Backshell Installation	23
D. Installation of the BACB42F() Shield Terminator Band	25
E. Insulation of the Shield Terminator Band	27
F. Assembly of Glenair 440( )069( ) RFI Peripheral Backshells	27
<b>5. <u>ASSEMBLY OF THE S280W603 BACKSHELL</u></b>	<b>29</b>
A. Cable Preparation	29
B. Connector Assembly	30
C. Backshell Installation	30
D. Installation of the BACB42F() Shield Terminator Band	32
E. Insulation of the Shield Terminator Band	33
<b>6. <u>ASSEMBLY OF THE S280W604 BACKSHELL</u></b>	<b>35</b>
A. Cable Preparation	35
B. Connector Assembly	37
C. Backshell Installation	37
D. Installation of the BACB42F() Shield Terminator Band	39
E. Insulation of the Shield Terminator Band	40
F. Installation of the Strain Relief Adapter	41
<b>7. <u>ASSEMBLY OF THE S280W604 BACKSHELL WITH POTTING COMPOUND</u></b>	<b>42</b>
A. Necessary Materials	42
B. Assembly of the First Connector	43

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

<u>PARAGRAPH</u>		<u>PAGE</u>
7.	<b><u>ASSEMBLY OF THE S280W604 BACKSHELL WITH POTTING COMPOUND (continued)</u></b>	<b>42</b>
	C. Assembly of the First Backshell	43
	D. Installation of the Wire Harness Protection	44
	E. Assembly of the Second Connector	46
	F. Assembly of the Second Backshell	46
	G. Installation of the Shield Terminator Bands	47
	H. Seal of the Connector Assembly with Potting Compound	47
	I. Installation of the Strain Relief Adapter	51
8.	<b><u>ASSEMBLY OF THE GLENAIR 527-187() BACKSHELL ON A SHELL SIZE 1 ARINC 600 PLUG CONNECTOR</u></b>	<b>51</b>
	A. Preparation of Shielded Cables	51
	B. Backshell Assembly	52
9.	<b><u>ASSEMBLY OF THE GLENAIR 527-212() BACKSHELL ON A SHELL SIZE 2 ARINC 600 PLUG CONNECTOR WITH SHIELD TAPE</u></b>	<b>57</b>
	A. Preparation of Wires and Cables	57
	B. Backshell Assembly	60
10.	<b><u>ASSEMBLY OF THE GLENAIR 527-212() BACKSHELL ON A SHELL SIZE 2 ARINC 600 PLUG CONNECTOR WITH SHIELD GROUND WIRES</u></b>	<b>70</b>
	A. Glenair 527-212 Backshell - Cable Preparation for a Solder Sleeve Shield Termination	70
	B. Glenair 527-212 Backshell - Cable Preparation for a Shield Pull Through Shield Termination	72
	C. Glenair 527-212 Backshell Installation	73
	D. Glenair 527-212MA9B9C4S Backshell - Shield Ground Wire Termination	76
	E. Glenair 527-212MA9B9C6S Backshell - Shield Ground Wire Termination	80
	F. Disassembly of the 527-212MA9B9C4S Backshell	85
	G. Disassembly of the 527-212MA9B9C6S Backshell	86
	H. Replacement of the Overall Heat Shrinkable Sleeve	86
11.	<b><u>ASSEMBLY OF THE GLENAIR 527-530MP29 OR 527-108() BACKSHELL ON A SHELL SIZE 3 ARINC 600 PLUG CONNECTOR WITH SHIELD GROUND WIRES</u></b>	<b>88</b>
	A. Assembly of the Glenair 527-530MP29 or 527-108() Backshell - Cable Preparation for a Solder Sleeve Shield Termination	88
	B. Assembly of the Glenair 527-530MP29 or 527-108() Backshell - Cable Preparation for a Shield Pull Through Shield Termination	90
	C. Backshell Assembly	91
12.	<b><u>ASSEMBLY OF THE GLENAIR 557-() BACKSHELL</u></b>	<b>103</b>
	A. Connector Part Numbers	103
	B. Wire Harness Preparation	103
	C. Connector Assembly	105
	D. Backshell Installation	105
	E. Installation of the BACB42F() Shield Terminator Band	107

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

<u>PARAGRAPH</u>	<u>PAGE</u>
12. <b><u>ASSEMBLY OF THE GLENAIR 557-() BACKSHELL (continued)</u></b>	<b>103</b>
F. Insulation of the Shield Terminator Band	109
13. <b><u>ASSEMBLY OF THE GLENAIR 637-221 BACKSHELL AND A SHIELD TERMINATION RING</u></b>	<b>112</b>
A. Backshell Part Numbers	112
B. Wiring Assembly Components	112
C. Backshell Assembly Preparation	112
D. Assembly of the Shield Termination Ring	113
E. Shield Sleeve Termination on a Shield Termination Ring	117
F. Shield Sleeve Termination on a Shield Termination Platform	121
G. Cable Preparation - Shield Pull Through Shield Termination	122
H. Cable Preparation - Solder Sleeve Shield Termination, End Strip Configuration	123
14. <b><u>ASSEMBLY OF THE FLIGHT DYNAMICS 6720-0389 BACKSHELL</u></b>	<b>124</b>
A. Backshell Part Numbers	124
B. Assembly of the Flight Dynamics 6720-0389 Backshell and Ground Block Contacts	125
15. <b><u>INSTALLATION OF THE SHIELD TERMINATOR BAND</u></b>	<b>126</b>
A. Installation of the Shield Terminator Band	126
B. Installation of the Shield Terminator Band - Pneumatic Tool	132

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

This Subject gives the procedures to assemble strain relief backshells that terminate a shield with a shield terminator band. For the procedures to assemble other strain relief backshells, refer to:

- Subject 20-60-09 for the assembly of backshells that do not terminate a shield
- Subject 20-25-12 for the assembly of backshells that terminate shields with shield ground wires and terminal lugs
- Subject 20-25-13 for the assembly of backshells that terminate shields with inner and outer ground rings
- Subject 20-25-15 for the assembly of backshells that have a composite hex coupling nut. These backshells can possibly have a braided shield sock.

#### 1. PART NUMBERS AND DESCRIPTION

##### A. Applicable Backshells

Table 1 gives the part numbers of the connector backshells that can be assembled with the BACB42F() and the Glenair 687-062-0() shield terminator bands.

**NOTE:** When the shield or the shield ground wire must make a specified electrical bond with the outer surface of the backshell, either the BACB42F() shield terminator band assembly or the Glenair 687-062-0() shield terminator band assembly gives a satisfactory performance.

**NOTE:** When only a small area to make the bond is available, the backshell assembly with a BACB42F() shield terminator band gives a better result.

Refer to:

- Figure 1 for the Glenair 387( )020 backshell
- Figure 2 for the Glenair 440( )069 backshell
- Figure 3 for the S280W603-( ) backshell
- Figure 4 and Figure 5 and for the Glenair 527-212 backshell
- Figure 6 for the Flight Dynamics 6720-0389 backshell
- Figure 7 for the Glenair 527-530MP29 or 527-108() backshell
- Figure 8, Figure 9 and Figure 10 for the Glenair 557-() backshell
- Figure 11 for the Glenair 637-221 backshell.

**Table 1**  
**BACKSHELL PART NUMBERS**

Boeing Specification	Backshell			
	Part Number	Supplier	Configuration	Assembly Procedure
-	387()A020	Glenair	Circular Strain Relief Backshell 90 Degree, Stainless Steel	Paragraph 3.
	387()B020	Glenair	Circular Strain Relief Backshell 45 Degree, Stainless Steel	Paragraph 3.
	387()S020	Glenair	Circular Strain Relief Backshell Straight, Stainless Steel	Paragraph 3.

**20-25-14**





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

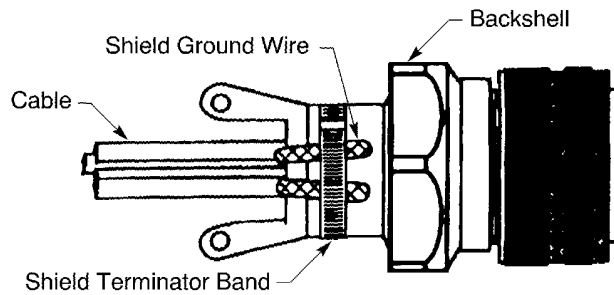
Table 1 BACKSHELL PART NUMBERS (Continued)

Boeing Specification	Backshell			
	Part Number	Supplier	Configuration	Assembly Procedure
-	440()H069	Glenair	EMI/RFI Circular Backshell 45 Degree, Stainless Steel	Paragraph 4.
	440()J069	Glenair	EMI/RFI Circular Backshell 90 Degree, Stainless Steel	Paragraph 4.
	440()S069	Glenair	EMI/RFI Circular Backshell Straight, Stainless Steel	Paragraph 4.
-	527-187()	Glenair	EMI/RFI Rectangular, Aluminum for Size 1 ARINC 600 Plugs	Paragraph 8.
-	527-212()	Glenair	EMI/RFI Rectangular, Aluminum for Size 2 ARINC 600 Plugs - Assembly with Shield Tape	Paragraph 9.
			EMI/RFI Rectangular, Aluminum for Size 2 ARINC 600 Plugs - Assembly with Shield Ground Wires	Paragraph 10.
-	527-530MP29 or 527-108()	Glenair	EMI/RFI Rectangular, Aluminum for Size 3 ARINC 600 Plugs - Assembly with Shield Ground Wires	Paragraph 11.
-	557-()	Glenair	EMI/RFI Rectangular, Aluminum for D-Subminiature Connectors	Paragraph 12.
-	637-221()	Glenair	EMI/RFI Circular Backshell, Aluminum, Straight	Paragraph 13.
-	6720-0389	Flight Dynamics	EMI/RFI Rectangular, Aluminum Backshell with Ground Block for Size 2 ARINC 600 Plug Connectors	Paragraph 14.
S280W603-1()	S3929()-34	Sunbank	Circular Strain Relief Backshell Straight, Cadmium Plated, Aluminum	Paragraph 5.
S280W603-2()	S3929A()-34	Sunbank	Circular Strain Relief Backshell, 45 Degree, Cadmium Plated, Aluminum	Paragraph 5.
S280W603-3()	S3929R()-34	Sunbank	Circular Strain Relief Backshell, 90 Degree, Cadmium Plated, Aluminum	Paragraph 5.
S280W604-1()	S3930()-34	Sunbank	EMI/RFI Circular Strain Relief Backshell, Straight, Cadmium Plated, Aluminum	Paragraph 6.
				Paragraph 7.
S280W604-2()	S3930A()-34	Sunbank	EMI/RFI Circular Strain Relief Backshell, 45 Degree, Cadmium Plated, Aluminum	Paragraph 6.
				Paragraph 7.
S280W604-3()	S3930R()-34	Sunbank	EMI/RFI Circular Strain Relief Backshell, 90 Degree, Cadmium Plated, Aluminum	Paragraph 6.
				Paragraph 7.

20-25-14

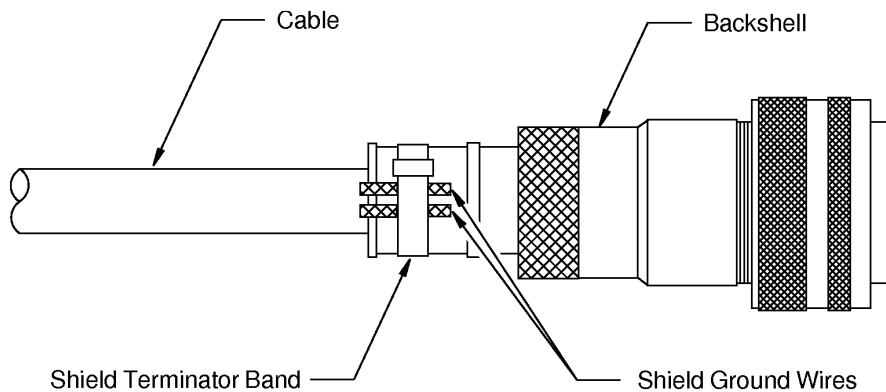


**707, 727-787**  
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**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



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**THE GLENAIR 387( )020 BACKSHELL**  
**Figure 1**



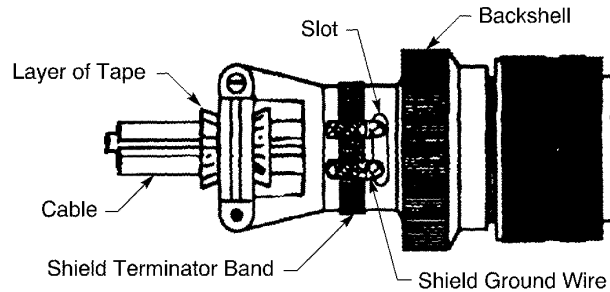
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**THE GLENAIR 440( )069 BACKSHELL**  
**Figure 2**

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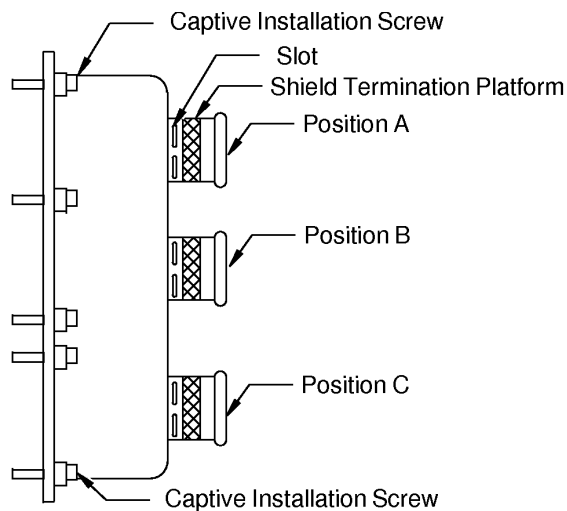


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**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445736 S00061545075\_V1

**THE S280W603 BACKSHELL**  
**Figure 3**



2448995 S00061545076\_V1

**THE GLENAIR 527-212 BACKSHELL**  
**Figure 4**

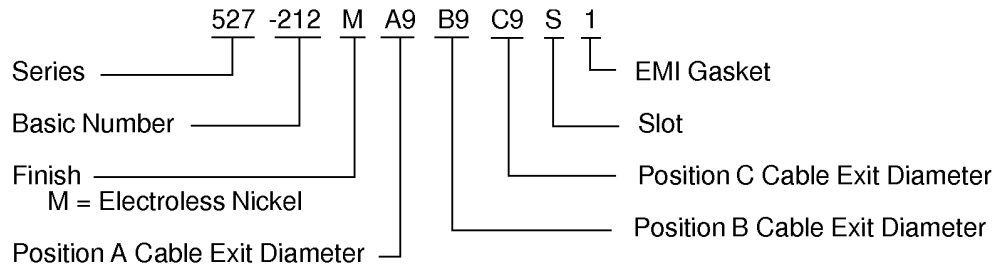
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707, 727-787

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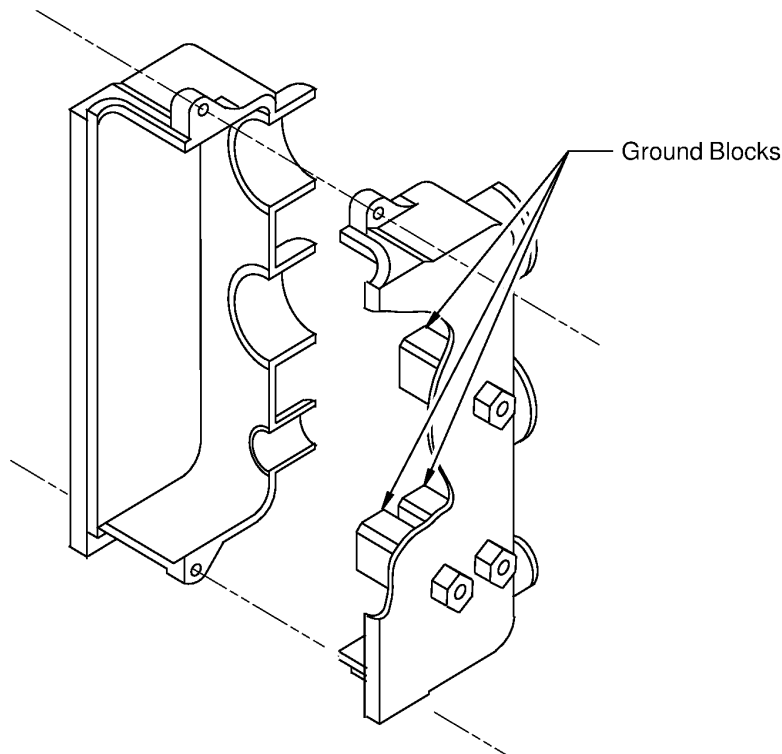
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2448994 S00061545077\_V1

#### GLENAIR 527-212 PART NUMBER STRUCTURE

Figure 5



2449912 S00061545078\_V1

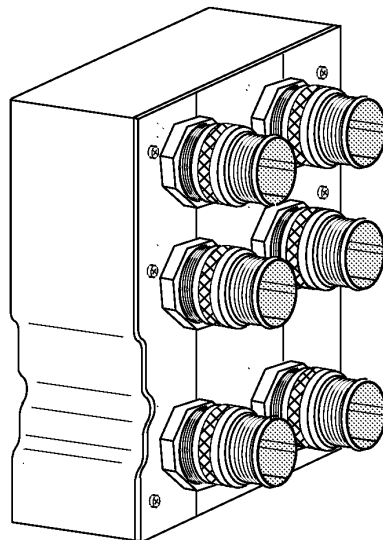
#### FLIGHT DYNAMICS 6720-0389 EMI BACKSHELL

Figure 6

20-25-14

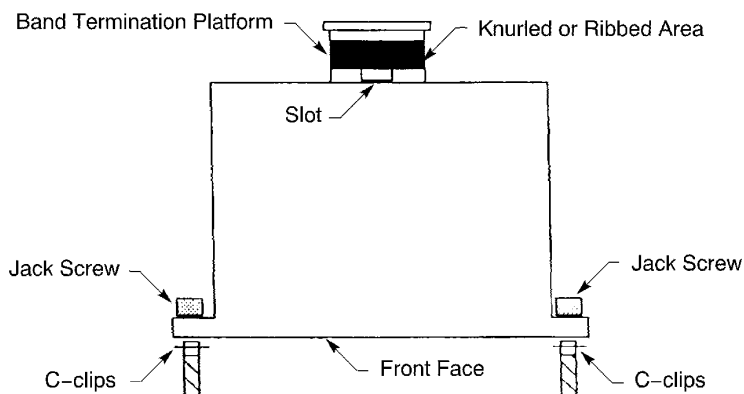


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**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH  
SHIELD TERMINATOR BANDS**



2449885 S00061545079\_V1

**THE GLENAIR 527-530MP29 OR 527-108() BACKSHELL**  
**Figure 7**



2445737 S00061545080\_V1

**THE GLENAIR 557-( ) BACKSHELL**  
**Figure 8**

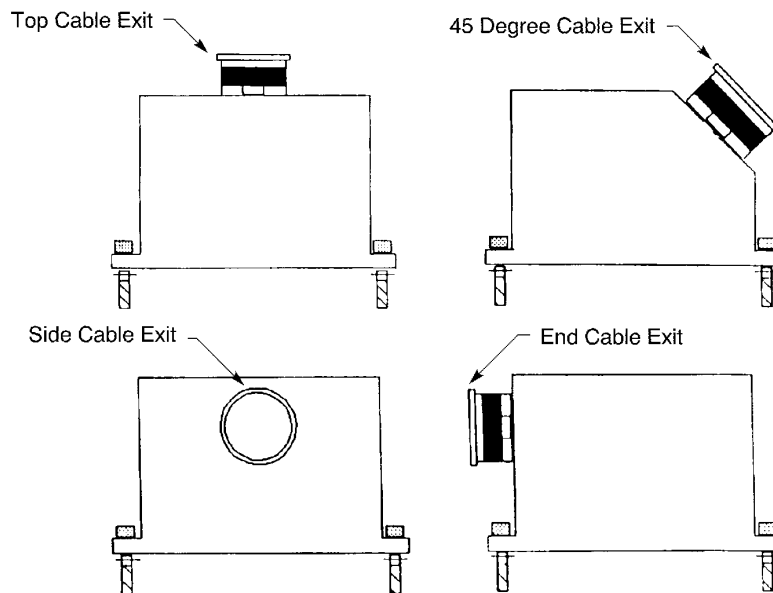
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707, 727-787

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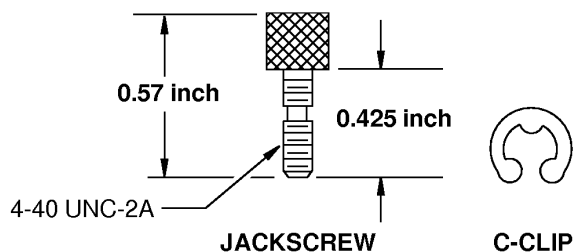
### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445738 S00061545081\_V1

#### CONFIGURATIONS OF THE GLENAIR 557-( ) BACKSHELL

Figure 9



#### JACK SCREWS SUPPLIED WITH GLENAIR 557-( ) BACKSHELLS

Two Socket Head Jackscrews and  
Two C-clips ( MS16633-4011 )

Supplied unassembled:  
Glenair part number 687-172

2449309 S00061545082\_V1

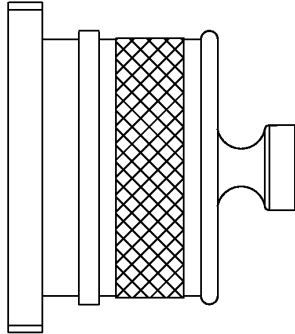
#### JACKSCREWS FOR GLENAIR 557-( ) BACKSHELLS

Figure 10

20-25-14



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
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**SHIELD TERMINATOR BANDS**



2449887 S00061545083\_V1

**THE GLENAIR 637-221 BACKSHELL**

**Figure 11**

**B. Glenair Shield Terminator Bands**

**Table 2**  
**GLENAIR SHIELD TERMINATOR BAND PART NUMBERS**

Backshell	Part Number	Diameter (inch)		Shell Size	Supplier
		Minimum	Maximum		
387()020	687-062-01	0.44	0.78	08	Glenair
				10	
	687-062-02	0.50	0.90	12	Glenair
				14	
	687-062-03	0.69	1.25	16	Glenair
				18	
	687-062-04	0.82	1.50	20	Glenair
	687-062-05	0.82	1.75	22	Glenair
				24	
	687-062-06	1.06	2.00	-	Glenair

Refer to Figure 12.

The Glenair 687-062-() shield terminator band has these technical properties:

**20-25-14**

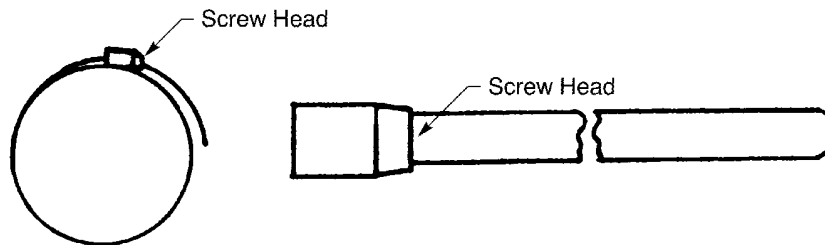


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- It is easy to assemble and disassemble
- It is reusable
- It accepts many shield ground leads
- It is applicable for Zero Length grounds
- It gives a low impedance electrical bond.



2445739 S00061545084\_V1

#### CONFIGURATION OF THE GLENAIR 687-062-() SHIELD TERMINATOR BAND

Figure 12

#### C. BACB42F() Shield Terminator Bands

The BACB42F() shield terminator band can be installed on these backshells:

- Boeing S280W603, and S280W604 backshells for circular connectors
- Glenair 387()020, 440( )031 and 440( )069 backshells for circular connectors
- Glenair 527-187() backshell for ARINC 600 shell size 1 plug connectors
- Glenair 527-212() backshell for ARINC 600 shell size 2 plug connectors
- Glenair 557-() backshell for M24308/() D-subminiature connectors.

Table 3  
BACB42F() SHIELD TERMINATOR BAND PART NUMBERS

Boeing Standard	Width (inch)	Nominal Diameter (inch)	Supplier
BACB42F3	0.24	1.8	Refer to Subject 20-00-11
BACB42F4	0.12	0.9	Refer to Subject 20-00-11
BACB42F6	0.12	1.8	Refer to Subject 20-00-11

20-25-14





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Basic Series Number	BACB42F	-()	Size
			1 = 2 inch nominal diameter 14 inch nominal length 0.37 inch nominal thickness
			2 = 2 inch nominal diameter 13 inch nominal length 0.25 inch nominal thickness
			3 = 1.8 inch nominal diameter 14 inch nominal length 0.25 inch nominal thickness
			4 = 0.9 inch nominal diameter 8 inch nominal length 0.12 inch nominal thickness

2445740 S00061545085\_V1

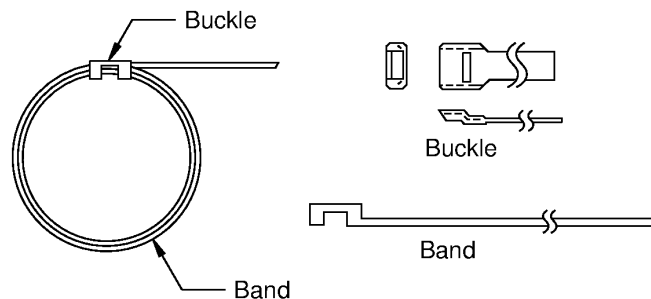
#### BACB42F SHIELD TERMINATOR BAND PART NUMBER STRUCTURE

Figure 13

Refer to Figure 14.

The BACB42F() shield terminator band has these technical properties:

- It is easy to assemble and disassemble
- It is not reusable
- It accepts many shield ground leads
- It is applicable for Zero Length grounds
- It gives a low impedance electrical bond.



2445741 S00061543063\_V1

#### CONFIGURATION OF THE BACB42F() SHIELD TERMINATOR BAND

Figure 14

20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### D. Necessary Materials for Backshell Assembly

Table 4  
NECESSARY MATERIALS

Part or Material	Part Number	Supplier
Adhesive Sealant, Gray	3145 RTV	Dow Corning
Insulation Tape, Gray	Scotch 70	3M
Sleeve, Heat Shrinkable	AMS-DTL-23053/5 Class 1	Available source
	MIL-LT	Raychem

#### 2. SHIELD TERMINATOR BAND REMOVAL

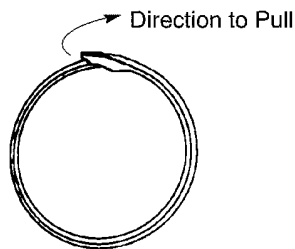
##### A. Removal of the Glenair 687-062-0() Shield Terminator Band

- (1) Loosen the screw until:
  - The end of the band goes through the screw head
  - The band disengages from the screw head.
- (2) Remove the band from the assembly.

##### B. Removal of the BACB42F() Shield Terminator Band

- (1) Hold the free end of the buckle on the band with a pair of needle nose pliers.
- (2) To release the buckle, pull the free end of the buckle:
  - In a direction that is up and away from the band
  - Until the end of the band is free from the buckle.

Refer to Figure 15.



2445742 S00061544057\_V1

#### BUCKLE RELEASE OF THE SHIELD TERMINATOR BAND

Figure 15

- (3) Remove the band from the assembly.
- (4) Discard the BACB42F() shield terminator band.

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### 3. ASSEMBLY OF THE GLENAIR 387()020 BACKSHELL

This paragraph gives the procedure to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of a wire or cable
- The adjacent shields of a wire or cable.

##### A. Backshell Part Numbers

Table 5  
BACKSHELL PART NUMBERS

Part Number	Supplier
387AA020	Glenair
387AB020	Glenair
387AS020	Glenair
387HA020	Glenair
387HB020	Glenair
387HS020	Glenair

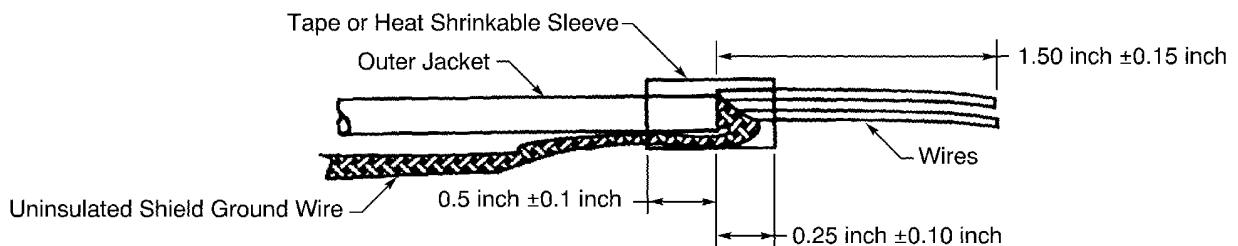
##### B. Preparation of Cable with a Tin Plated or a Silver Plated Shield

**NOTE:** If the cable has one round conductor shield or two adjacent round conductor shields, the procedure to prepare a cable that has a nickel plated shield is a satisfactory alternative. Refer to Paragraph 3.C.

- (1) Remove 1.5 inches  $\pm 0.1$  inch of the outer jacket from the end of the cable.
- (2) Remove 1.25 inches  $\pm 0.01$  inch of the shield from the end of the cable.
- (3) Assemble a shield ground wire with a solder sleeve that has an uninsulated integral wire. Refer to Subject 20-10-15.

Make sure that the shield ground wire is pointed back away from the end of the cable.

##### C. Preparation of a Cable with a Nickel Plated Shield



2445743 S00061545086\_V1

CABLE PREPARATION  
Figure 16

Refer to Figure 16.

- (1) Remove approximately 1.75 inches of the outer jacket from the end of the cable.

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (2) Cut the wires of the cable to make the distance from the end of the wires to the end of the cable jacket equal to 1.50 inches  $\pm 0.15$  inch.
- (3) Assemble a shield ground wire with a shield pull through. Refer to Subject 20-10-15.

Make sure that:

- The shield ground wire is pointed back away from the end of the cable
- The forward end of the tape or heat shrinkable sleeve extends 0.25 inch  $\pm 0.10$  inch farther than the end of the outer jacket
- The rear end of the tape or heat shrinkable sleeve extends 0.5 inch  $\pm 0.1$  inch farther than the end of the outer jacket.

#### D. Connector Assembly

- (1) Put the all the applicable cables through backshell.
- (2) Assemble the connector. Refer to the applicable Subject for the connector.

#### E. Backshell Installation

- (1) Push the backshell over the wires of the cables until the backshell is against the rear of the connector.

Make sure that the shield ground wires of all the cables come out of the rear end of the backshell.

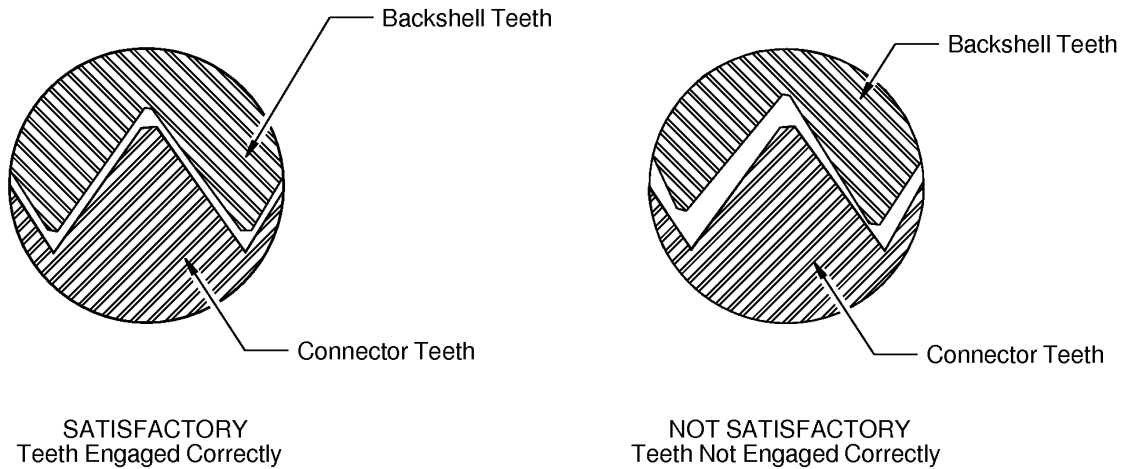
- (2) Carefully, push and turn the backshell until the teeth of the backshell are fully engaged with the teeth of the connector.
- (3) Look in the inspection hole of the backshell adapter. Refer to Figure 17.

Make sure that the teeth of the backshell adapter are fully engaged with the teeth of the MIL-C-26500 connector.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445710 S00061544292\_V1

**POSITION OF THE MIL-C-26500 TEETH AND THE BACKSHELL TEETH**

**Figure 17**

- (4) Torque the backshell to the specified value in Table 6 with a torque wrench.

**Table 6**  
**BACKSHELL INSTALLATION TORQUE VALUES**

Shell Size	Torque (inch-pound)	
	Minimum	Maximum
28	180	200
24	180	200
22	180	200
20	180	200
18	150	170
16	150	170
14	150	170
12	90	110
10	90	110
8	90	110

**20-25-14**

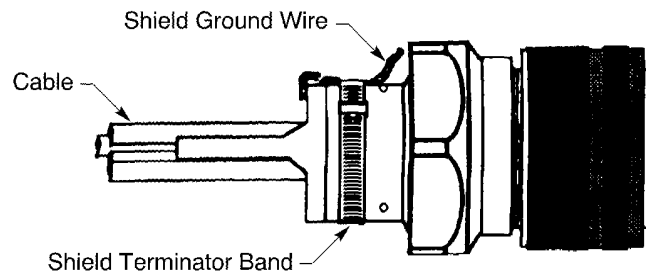
## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### F. Installation of the Glenair 687-062-0() Shield Terminator Band

- (1) Make a selection of a shield terminator band from Table 2.
- (2) Put the band on the cable.
- (3) Put each shield ground wire on the outer surface of the backshell so that the shield ground wires:
  - Are parallel to the longitudinal axis of the connector backshell
  - Are even and symmetrical around the circumference of the backshell
  - Do not make an overlap with another shield ground wire.
- (4) Push the shield terminator band toward the connector until:
  - The band is on the ribbed area on the rear of the backshell
  - There are no shield ground wires under the clamp components.

Refer to Figure 18.



2445744 S00061545087\_V1

#### POSITION OF THE SHIELD TERMINATOR BAND ON THE BACKSHELL

Figure 18

- (5) Torque the shield terminator band to the applicable torque in Table 7.

**Table 7**  
**SHIELD TERMINATOR BAND INSTALLATION TORQUE VALUES**

Shell Size	Torque (inch-pound)	
	Minimum	Maximum
28	45	55
24	45	55
22	45	55
20	45	55
18	45	55
16	45	55
14	15	25
12	15	25
10	15	25

**20-25-14**

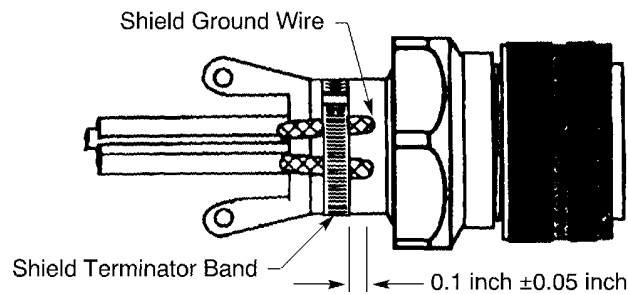
## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Table 7 SHIELD TERMINATOR BAND INSTALLATION TORQUE VALUES (Continued)

Shell Size	Torque (inch-pound)	
	Minimum	Maximum
08	15	25

- (6) If the free end of the shield terminator band is more than 0.4 inch from the end of the screw head, bend the free end of the band so that the distance from the end of the band to the body of the clamp is 0.02 inch or less.
- (7) Cut each shield ground wire so that the end of each wire is 0.1 inch  $\pm$  0.05 inch from the edge of the band. Refer to Figure 19.



2445745 S00061545088\_V1

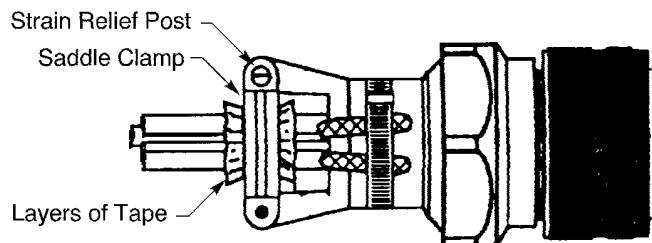
#### POSITION OF THE END OF THE SHIELD GROUND WIRES

Figure 19

- (8) Put the necessary layers of insulation tape on the cable so that the outer diameter of the cable is increased. Refer to Figure 20.

Make sure that:

- The tape is in the location where the saddle clamp holds the cable
- The outer diameter of the cable is equal to the inner diameter of the cable clamps
- The clamp will hold the cable satisfactorily.



2445746 S00061545089\_V1

#### POSITION OF THE INSULATION TAPE ON THE CABLE

Figure 20

- (9) Tighten the cable clamps.

Make sure that:

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- The inner surface of the cable clamps is against the outer surface of the strain relief posts on the backshell
- The cable clamps hold the cable tightly, but does not cut into the cable jacket.

#### 4. ASSEMBLY OF THE GLENAIR 440()069 BACKSHELL

This paragraph gives the procedure to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of a wire or cable
- The adjacent shields of a wire or cable.

##### A. Preparation of Cable with a Shield

This paragraph gives the procedure to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of a wire or cable
- The adjacent shields of a wire or cable.

Table 8  
CABLE JACKET REMOVAL LENGTH

Backshell Part Number	Special Instructions	Cable Jacket Removal Length (Dimension A)
440( )069( )	-	2.0 ±0.1 inches
440( )069( )-6	-	3.5 ±0.1 inches
440( )069( )T	Assembled with supplied potting boot	2.75 ±0.1 inches
440( )069( )T	Assembled without supplied potting boot	2.0 ±0.1 inches

- (1) For shielded cables that do not have isolated shields, remove a length of the jacket in accordance with Table 8.
- (2) For cables with isolated shields, prepare the cable in accordance with Figure 21.

**NOTE:** Get the inner cable jacket removal length A from Table 8.

20-25-14

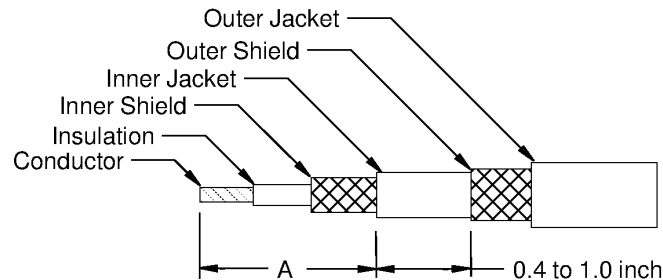




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449876 S00061545090\_V1

#### CABLE PREPARATION FOR CABLES WITH ISOLATED SHIELDS

Figure 21

- (3) Assemble a shield ground wire with a solder sleeve that has an uninsulated integral wire. Refer to Subject 20-10-15.

Make sure that the shield ground wire is pointed back away from the end of the cable.

- (4) Assemble a shield ground wire with a shield pull through. Refer to Subject 20-10-15.

Make sure that:

- The shield ground wire is pointed back away from the end of the cable
- The forward end of the tape or heat shrinkable sleeve extends 0.25 inch  $\pm$  0.10 inch farther than the end of the outer jacket
- The rear end of the tape or heat shrinkable sleeve extends 0.5 inch  $\pm$  0.1 inch farther than the end of the outer jacket
- Do not cover or insulate the shield pull out ground wire.

#### B. Connector Assembly

Table 9  
NECESSARY TOOLS

Tool	Diameter (inch)	Supplier
Drill or punch	0.12	An available source

20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

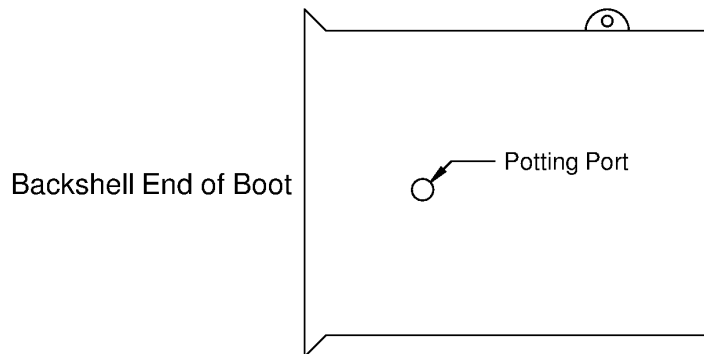
### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Table 10  
NECESSARY MATERIALS

Material	Part Number	Supplier
Sleeve	M23053/5(1)	An available source
	M23053/5(3)	An available source

- (1) Make a selection of a tool from Table 9.
- (2) For backshells that have a potting boot, use the tool to make 0.12 inch O.D. hole into the potting boot. Refer to Figure 22

**NOTE:** This hole is the potting port.



2449877 S00061545091\_V1

#### POTTING PORT AND ORIENTATION OF THE POTTING BOOT ON THE WIRES

Figure 22

- (3) For backshells that have a potting boot prepare the wires, potting boot, backshell and connector. Refer to Subject 20-10-16.
  - (a) If it is specified put the all the applicable cables through potting boot, the outer expandable sleeve, the shield braid, the inner expandable sleeve and the backshell.
- (4) For backshells that do not have a potting boot make a selection of a  $2.25 \pm 0.50$  inch length sleeve from Table 10  
Make sure that the sleeve has the smallest diameter size that fits on the installed band.
  - (a) Put the all the applicable cables through the sleeve and the backshell.
- (5) Assemble the connector. Refer to the applicable Subject for the connector.
- (6) If the installation of a shield braid is specified, attach the end of the inner expandable sleeve:
  - If there are shielded cables, attach the end of the inner expandable sleeve behind the solder

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

sleeves with a lacing tape wire harness tie. Refer to Subject 20-10-11 for the procedure to assemble a lacing tape wire harness tie.

- If there are no shielded cables, attach the end of the inner expandable sleeve with lacing tape wire harness tie, within 2.0 inches of the connector grommet. Refer to Subject 20-10-11 for the procedure to assemble a lacing tape wire harness tie.

#### C. Backshell Installation

Table 11  
NECESSARY TOOLS

Tool	Supplier
Torque Wrench	An available source

Table 12  
440( )069ZM( ) or 440( )069Z1( ) BACKSHELL INSTALLATION TORQUE VALUES

Shell Size	Torque (inch pound)	
	Minimum	Maximum
28	180	200
24	180	200
22	180	200
20	180	200
18	150	170
16	150	170
14	150	170
12	90	110
10	90	110
8	90	110

Table 13  
440( )069( ) or 440( )144( ) BACKSHELL INSTALLATION TORQUE VALUES

Shell Size	Torque (inch pound)	
	Minimum	Maximum
28	125	130
24	120	125
22	120	125
20	120	125
18	110	115
16	85	90
14	75	80

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Table 13 440( )069( ) or 440( )144( ) BACKSHELL INSTALLATION TORQUE VALUES (Continued)

Shell Size	Torque (inch pound)	
	Minimum	Maximum
12	60	65
10	45	50
8	37	42

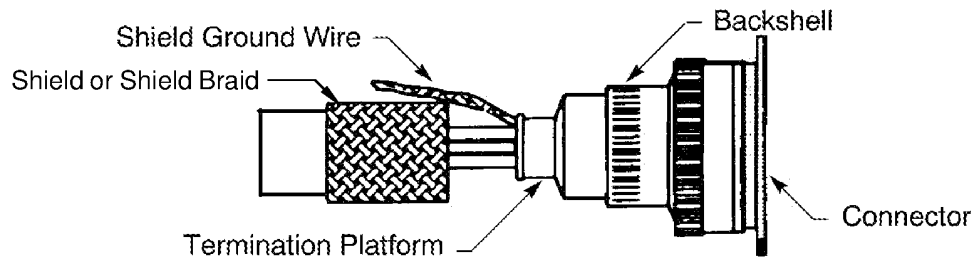
- (1) Put the shield ground wires against each cable.

Make sure the wires are:

- Flat and symmetrical around the circumference of each cable
- Aligned with the longitudinal axis of each cable.

- (2) Push the backshell forward on the wires of the cables until the backshell touches the rear of the connector.. Refer to Figure 23.

Make sure that the shield ground wires of all the cables come out of the rear end of the backshell.



2449878 S00061545092\_V1

#### BACKSHELL AND SHIELD GROUND WIRES

Figure 23

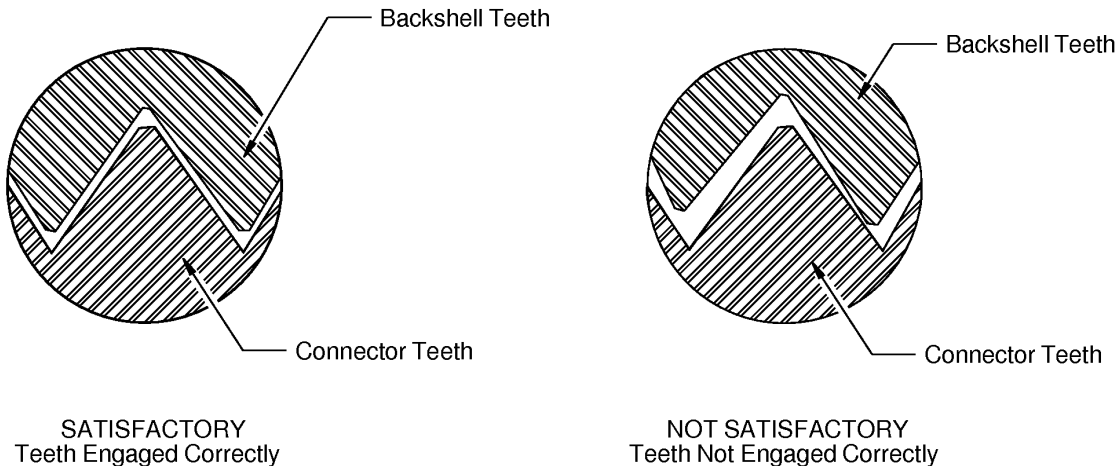
- (3) Carefully, push and turn the backshell until the teeth of the backshell are fully engaged with the teeth of the connector.

- (4) Look in the inspection hole of the backshell. Refer to Figure 24

Make sure that the teeth of the backshell are fully engaged with the teeth of the connector.

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445710 S00061544292\_V1

#### POSITION OF THE TEETH AND THE BACKSHELL TEETH

Figure 24

- (5) Make a selection of a torque wrench. Refer to Table 11
- (6) Torque the 440( )069ZM( ) or 440( )069Z1( ) backshell with a torque wrench.. Refer to Table 12 for the installation torque value.
- (7) Torque the 440( )069( ) or 440( )144( ) backshells with a torque wrench. Refer to Table 13 for the installation torque value.

#### D. Installation of the BACB42F() Shield Terminator Band

- (1) Fold each shield ground wire back over the termination platform of the backshell.  
Make sure that the shield ground wires:
  - Are even and symmetrical around the platform
  - Do not make an overlap with another shield ground wire.
- (2) Push the end of the shield or shields of the primary cable onto the termination platform.  
Make sure that the end of the shield is:
  - Aligned with the forward edge of the termination platform
  - On the shield ground wire
  - Smooth.
- (3) Make a selection of a shield terminator band from Paragraph 1.C..
- (4) Attach the shield terminator band to the backshell.  
Refer to:
  - Figure 25 for the location of the installation

**20-25-14**



707, 727-787

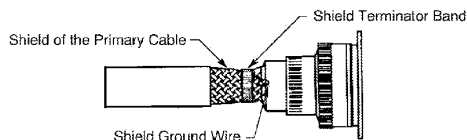
## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- Paragraph 15.. for the installation procedure.

Make sure that

- The band is on the knurled or ribbed area of the termination platform
- The buckle of the band is not on a shield ground wire on the backshell.



2449879 S00061545093\_V1

#### POSITION OF THE TERMINATOR BAND ON THE BACKSHELL

Figure 25

- (5) Cut the unwanted length of:

- The shield
- The shields of the primary cable
- The shield ground wires.

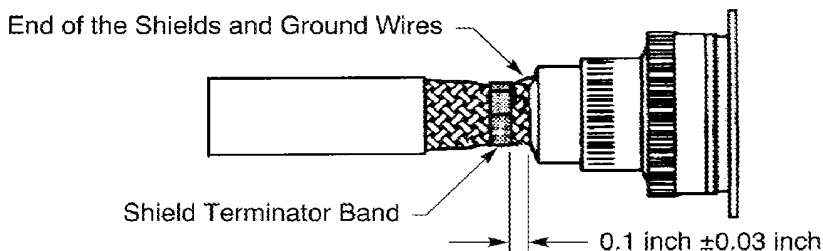
Make sure that the distance from the forward edge of the band and the end of the shield and wires equal to 0.10 inch  $\pm$ 0.03 inch

Refer to Figure 26.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2449880 S00061545094\_V1

**POSITION OF THE SHIELD AND THE SHIELD GROUND WIRES**

**Figure 26**

**E. Insulation of the Shield Terminator Band**

- (1) Wind two to three layers of 0.50 inch wide A-A-59474 teflon tape on the band.

Make sure that:

- The band is below the center of the tape
- The band can not be seen
- The tape has approximately 100 percent overlap.

**F. Assembly of Glenair 440( )069( ) RFI Peripheral Backshells**

**Table 14**  
**NECESSARY MATERIALS**

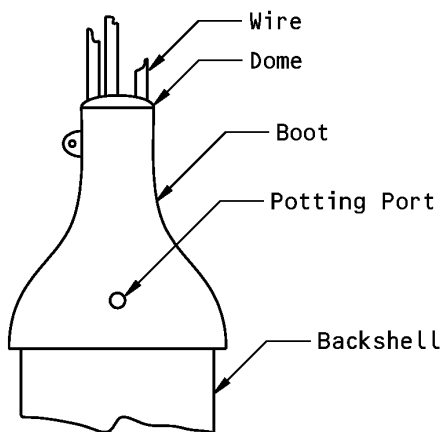
Material	Part Number	Width (inch)	Supplier
Tape	Scotch 70	0.50	3M
	A-A-59163 Type I	0.50	An available source
	A-A-59163 Type I	1.0	An available source

- (1) If a potting boot is specified:
- (a) If there is an outer expandable sleeve, put the end of the sleeve between the band and the connector.
  - (b) Assemble a lacing tape wire harness tie on the sleeve between the band and the connector. Refer to Subject 20-10-11.
  - (c) Install the potting boot.
- Refer to:
- Figure 27 for configuration on the boot
  - Subject 20-10-16 for the procedure to install the potting boot.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2449881 S00061545095\_V1

**INSTALLED POTTING BOOT**

**Figure 27**

- (d) Make a selection of a 0.50 inch width tape from Table 14.
- (e) Wind two wraps of tape around the potting boot.  
Make sure that:
  - The center of the tape is on the potting port
  - Each tape wrap makes a 100% overlap.
- (f) After the potting compound is tack-free, remove the tape.
- (2) If a potting boot is not specified:
  - (a) If there is an outer expandable sleeve, put the end of the sleeve between the band and the connector
  - (b) Assemble a lacing tape wire harness tie on the sleeve between the band and the connector. Refer to Subject 20-10-11.
  - (c) Make a selection of a 1.0 inch width tape from Table 14.
  - (d) Wind the necessary number of layers of 1.0 inch wide on the wire harness adjacent to the band area of the backshell.  
Make sure that:
    - The O.D. of the harnesses approximately equal to the O.D. of the band area of the backshell.
    - The tape has approximately 100% overlap
    - The shield ground wires are not under the tape.

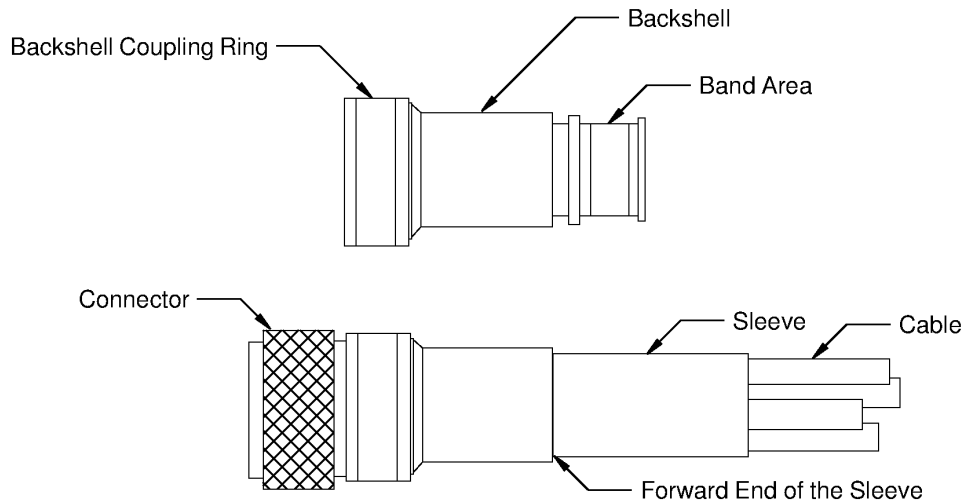
**20-25-14**



## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (3) Put the M23053/5( ) heat shrinkable sleeve on to the band area of the backshell. Refer to Figure 28



2449882 S00061545096\_V1

#### INSTALLED SLEEVE

Figure 28

- (4) Shrink the sleeve in its position.

Refer to:

- Figure 28 for the position of the sleeve
- Subject 20-10-14 for the procedure to install a heat shrinkable sleeve.

## 5. ASSEMBLY OF THE S280W603 BACKSHELL

This paragraph gives the procedure to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of a wire or a cable
- The adjacent shields of a wire or a cable.

### A. Cable Preparation

- (1) For the assembly of a shield ground wire, make a selection of:
  - A shield ground wire with a Shield Pull Through
  - A shield ground wire with a Solder Sleeve if the shield is not nickel or nickel plated.
- (2) For the assembly of the shield ground wire with a Shield Pull Through:
  - (a) Remove a 4.0 inch  $\pm$  0.2 inch length of the outer jacket from the end of the cable.
  - (b) Assemble a shield ground wire with a Shield Pull Through. Refer to Subject 20-10-15.  
Make sure that the shield ground wire is pointed back away from the end of the cable.

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (3) For the assembly of the shield ground wire with a Solder Sleeve:
  - (a) Remove a 1.5 inch  $\pm$  0.1 inch length of the outer jacket from the end of the cable.
  - (b) Remove 1.25 inches  $\pm$  0.10 inch from the end of the shield.
  - (c) Assemble a shield ground wire with a solder sleeve that has an uninsulated integral wire. Refer to Subject 20-10-15.

Make sure that the shield ground wire is pointed back away from the end of the cable.

#### B. Connector Assembly

- (1) Put the all the applicable cables through backshell.
- (2) Assemble the connector. Refer to the applicable Subject for the connector.

#### C. Backshell Installation

- (1) Put the shield ground wires against each cable so that the wires are:
  - Flat and symmetrical around the circumference of each cable
  - Aligned with the longitudinal axis of each cable.
- (2) Push the backshell over the wires of the cables and the shield ground wires until the backshell is against the rear of the connector.

Make sure that each shield ground wire comes out of the end of the backshell that has the cable retention clamps.

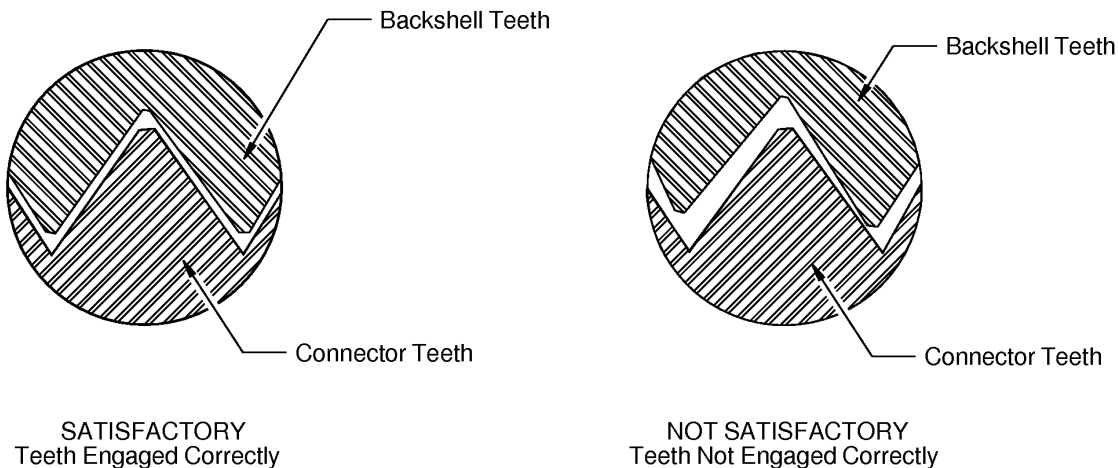
- (3) Carefully, push and turn the backshell until the teeth of the backshell are fully engaged with the teeth of the connector.
- (4) Look in the inspection hole of the backshell adapter. Refer to Figure 29.

Make sure that the teeth of the backshell adapter are fully engaged with the teeth of the MIL-C-26500 connector.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445710 S00061544292\_V1

**POSITION OF THE MIL-C-26500 TEETH AND THE BACKSHELL TEETH**  
**Figure 29**

- (5) Torque the backshell to the specified value in Table 15 with a torque wrench.

**Table 15**  
**BACKSHELL INSTALLATION TORQUE VALUES**

Shell Size	Torque (inch-pound)	
	Minimum	Maximum
28	180	200
24	180	200
22	180	200
20	180	200
18	150	170
16	150	170
14	150	170
12	90	110
10	90	110
8	90	110

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### D. Installation of the BACB42F() Shield Terminator Band

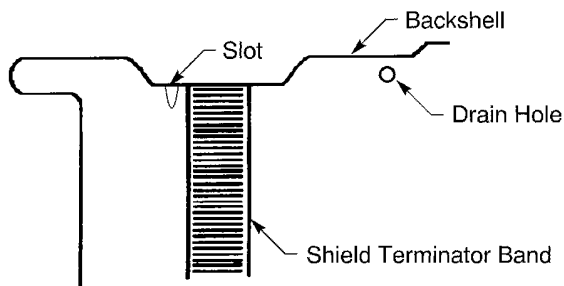
- (1) Pull the shield ground wires through the slots in the backshell with a plastic awl or an equivalent tool.
- (2) Carefully, pull the free ends of the shield ground wires tightly so that the wires are not loose inside the backshell.
- (3) Put the shield ground wires around on the outer surface of the backshell so that the wires:
  - Are even and symmetrical around the outer surface of the backshell
  - Do not make an overlap with another shield ground wire.
- (4) Make a selection of a shield terminator band from Table 3.
- (5) Attach the shield terminator band to the backshell.

Refer to:

- Figure 30 for the location of the installation
- Paragraph 15. for the installation procedure.

Make sure that:

- The band does not move the position of the shield ground wires
- The buckle of the band is not over a shield ground wire on the backshell
- The buckle of the band is not over a slot in the backshell.



2445747 S00061545097\_V1

#### POSITION OF THE SHIELD TERMINATOR BAND ON THE BACKSHELL

Figure 30

- (6) Fold the shield ground wires back across the shield terminator band.
- (7) Cut the ends of the shield ground wires so that end of each wire is aligned with the edge of the band that is adjacent to the connector.
- (8) To prevent the abrasive movement of the cable under the clamp, install either of these types of protection at the location of the clamp on the cable or cables:
  - A BACI12Z insert
  - The sufficient layers of insulation tape.

If the protection is insulation tape, make sure that the outer diameter of the cable and the insulation tape is sufficient for the clamp to hold the cable tightly.

Refer to Figure 31.

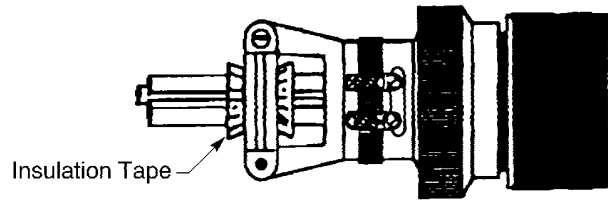
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445748 S00061545098\_V1

#### POSITION OF THE INSULATION TAPE OR INSERT UNDER THE CABLE CLAMP

Figure 31

- (9) Tighten the cable clamps.

Make sure that the inner surface of the clamp is against the outer surface of the strain relief posts on the backshell.

#### E. Insulation of the Shield Terminator Band

- (1) Clean the area of the electrical connection of the shield terminator band and the backshell with isopropyl alcohol. Refer to Figure 30.
- (2) Cut the sufficient length Scotch 70 insulation tape to put two layers of tape around the circumference of the backshell and shield terminator band.
- (3) Cut the length of tape again so that the width is 0.4 inch  $\pm$  0.1 inch.
- (4) Put the two layers of tape around the circumference of the shield terminator band and the backshell so that:
  - Each layer of tape makes a small overlap
  - The tape is on the band termination area
  - The tape is on the body of the backshell on the both sides of the shield terminator band termination.

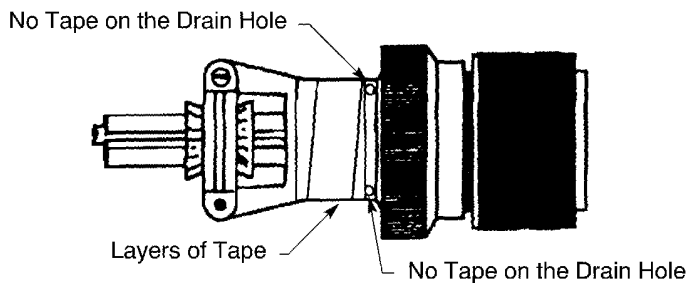
Refer to Figure 32.

**CAUTION:** DO NOT PUT THE TAPE OVER THE DRAIN HOLES IN THE BACKSHELL.  
DAMAGE TO THE CONNECTOR CAN OCCUR.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445749 S00061545100\_V1

**POSITION OF THE INSULATION TAPE ON THE BACKSHELL**

**Figure 32**

- (5) Apply a 0.02 inch thick, continuous layer of 3145 RTV adhesive sealant on the electrical connection with a clean spatula.

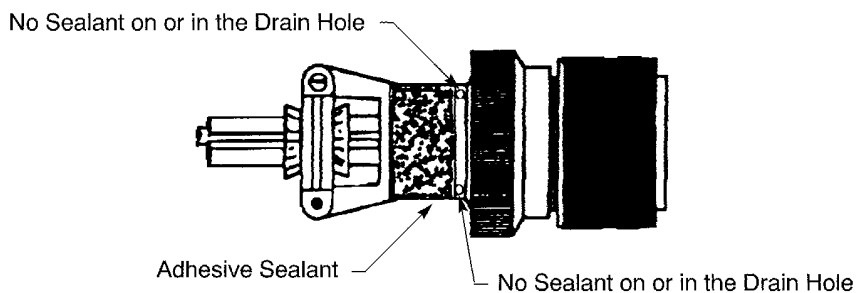
Refer to Figure 33.

Make sure that the layer of adhesive sealant:

- Is over the surface and the edges of the tape
- Is over the surface of the backshell from the edge of the tape that is adjacent to the connector to the forward edge of the strain relief of the backshell
- Has no cracks or openings to the surface of the insulation tape or the surface of the backshell.

**CAUTION:** DO NOT PUT THE ADHESIVE SEALANT IN OR ON THE DRAIN HOLES IN THE BACKSHELL. DAMAGE TO THE CONNECTOR CAN OCCUR.

**NOTE:** It is acceptable if the layer of sealant is not smooth or symmetrical.



2445750 S00061545102\_V1

**LOCATION OF THE ADHESIVE SEALANT**

**Figure 33**

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### 6. ASSEMBLY OF THE S280W604 BACKSHELL

**NOTE:** This procedure is not applicable for assembly of S280W604 backshells on S280W501 cable. Refer to Subject 20-14-11 for the assembly procedure for S280W604 backshells on S280W501 cable.

This paragraph gives the procedure to:

- Attach the shield of a primary cable to a backshell
- Attach the adjacent shields of a primary cable to a backshell
- Assemble the shield ground wires of each shielded wire or cable in the primary cable and attach them to a backshell
- Assemble the shield ground wires of each shielded wire or cable with adjacent shields in the primary cable and attach them to a backshell.

#### A. Cable Preparation

**Table 16**  
**PRIMARY CABLE JACKET REMOVAL LENGTH**

Shell Size	Backshell Configuration	Removal Length (inch)	
		Target	Tolerance
22	Straight	2.0	±0.05
	45 Degrees	2.3	
	90 Degrees	3.2	
20	Straight	2.0	±0.05
	45 Degrees	2.3	
	90 Degrees	3.2	
18	Straight	2.0	±0.05
	45 Degrees	2.3	
	90 Degrees	3.2	
16	Straight	2.0	±0.05
	45 Degrees	2.3	
	90 Degrees	3.0	
14	Straight	2.0	±0.05
	45 Degrees	2.3	
	90 Degrees	3.0	
12	Straight	2.0	±0.05
	45 Degrees	2.3	
	90 Degrees	3.0	

- (1) Put the strain relief adapter on the cable.
- (2) Remove the necessary length of the outer jacket from the end of the primary cable. Refer to Table 16.
- (3) Fold the shield or shields of the primary cable back on the outer jacket. Refer to Figure 34.

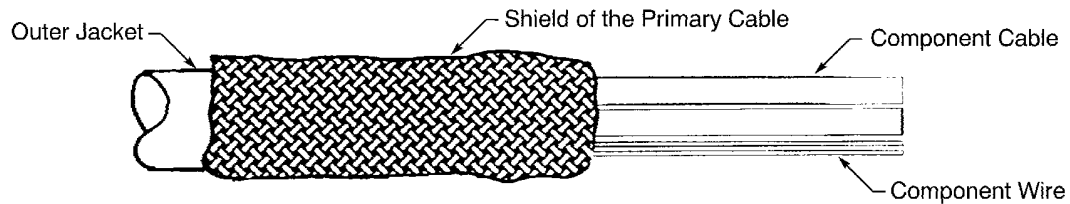
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

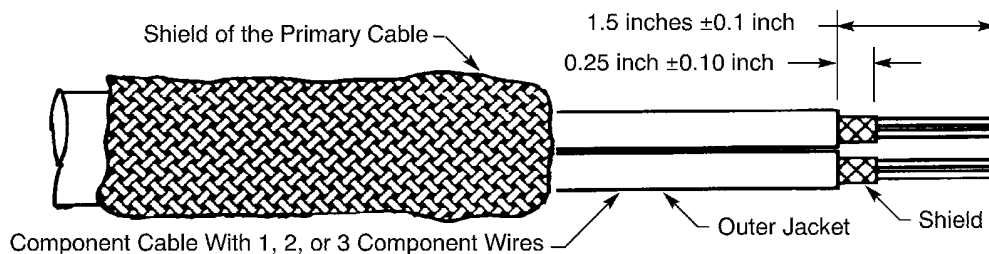


2445751 S00061545103\_V1

#### POSITION OF THE SHIELD

Figure 34

- (4) If inner shielded cables exist, remove 1.5 inches  $\pm$  0.1 inch of the outer jacket of each inner cable.
- (5) Remove the necessary length of the shield from each inner cable to make the distance from the end of the outer jacket to the end of the shield equal to 0.25 inch  $\pm$  0.10 inch. Refer to Figure 35.



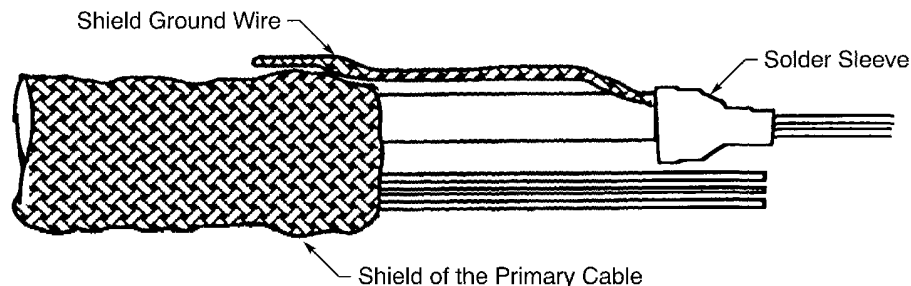
2445752 S00061545104\_V1

#### PREPARATION OF THE INNER CABLES

Figure 35

- (6) Assemble a shield ground wire with a solder sleeve that has an uninsulated integral wire on each inner cable. Refer to Figure 36 and Subject 20-10-15.

Make sure the shield ground wire is pointed back away from the end of the cable.



2445753 S00061545105\_V1

#### POSITION OF THE SOLDER SLEEVE AND SHIELD GROUND WIRE

Figure 36

- (7) Put the backshell adapter on the cable. Refer to Figure 37.

**20-25-14**



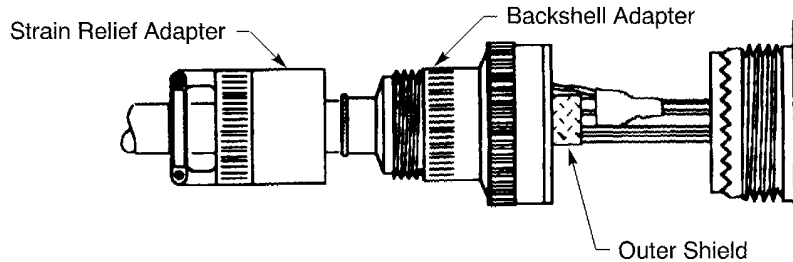


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Make sure that the forward end of the adapter is against the shield of the primary cable.



2445754 S00061545106\_V1

#### POSITION OF THE BACKSHELL ADAPTER

Figure 37

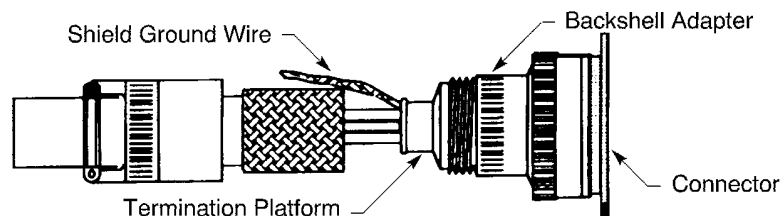
#### B. Connector Assembly

- (1) Assemble the connector. Refer to the applicable Subject for the connector.

#### C. Backshell Installation

- (1) Push the backshell adapter over the wires of the cables and the shield ground wires until the adapter is against the rear of the connector. Refer to Figure 38.

Make sure that the end of each shield ground wire is through the backshell adapter.



2445755 S00061545107\_V1

#### BACKSHELL ADAPTER AND SHIELD GROUND WIRES

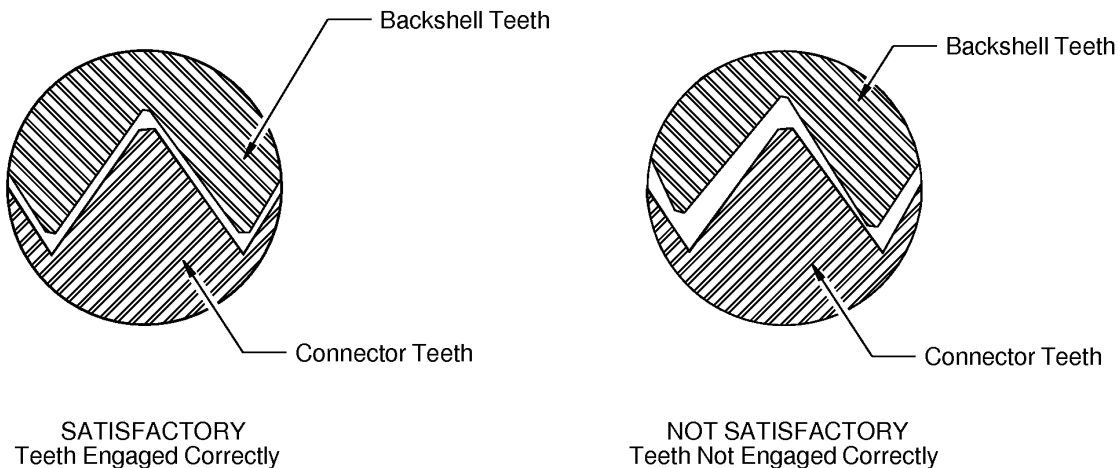
Figure 38

- (2) Carefully, push and turn the backshell adapter until the teeth of the adapter are fully engaged with the teeth of the connector.
- (3) Look in the inspection hole of the backshell adapter. Refer to Figure 39.  
Make sure that the teeth of the backshell adapter are fully engaged with the teeth of the MIL-C-26500 connector.

20-25-14



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445710 S00061544292\_V1

**POSITION OF THE MIL-C-26500 TEETH AND THE BACKSHELL TEETH**

**Figure 39**

- (4) Torque the backshell to the specified value in Table 17 with a torque wrench.

**NOTE:** Do not install lockwire to hold the backshell adapter in position on the connector.

**Table 17**  
**BACKSHELL INSTALLATION TORQUE VALUES**

Shell Size	Torque (inch-pound)	
	Minimum	Maximum
28	120	130
24	115	125
22	115	125
20	115	125
18	105	115
16	80	90
14	70	80
12	55	65
10	40	50
8	32	42

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### D. Installation of the BACB42F() Shield Terminator Band

- (1) Fold each shield ground wire back over the termination platform of the backshell adapter.

Make sure that the shield ground wires:

- Are even and symmetrical around the platform
- Do not make an overlap with another shield ground wire.

- (2) Push the end of the shield or shields of the primary cable onto the termination platform.

Make sure that the end of the shield is:

- Aligned with the forward edge of the termination platform
- Over the shield ground wires
- Smooth.

- (3) Make a selection of a shield terminator band from Table 3.

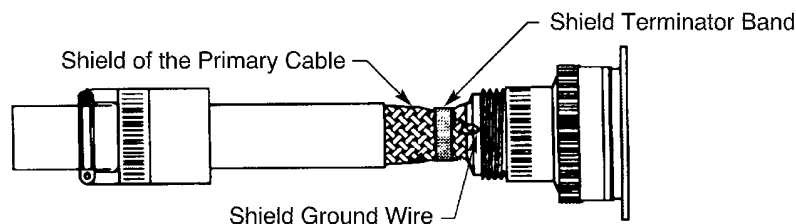
- (4) Attach the shield terminator band to the backshell.

Refer to:

- Figure 40 for the location of the installation
- Paragraph 15. for the installation procedure.

Make sure that:

- The band is on the knurled or ribbed area of the termination platform
- The buckle of the band is not over a shield ground wire on the backshell.



2445756 S00061545108\_V1

#### POSITION OF THE TERMINATOR BAND ON THE BACKSHELL ADAPTER

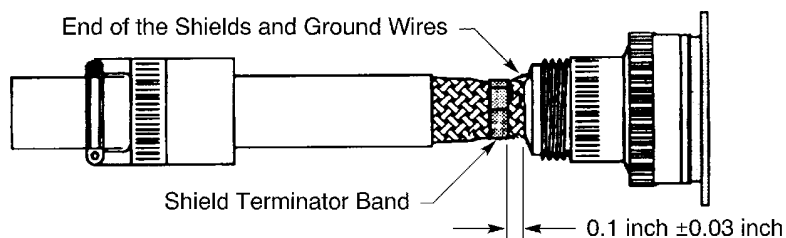
Figure 40

- (5) Cut the unwanted length of the shield or shields of the primary cable and the shield ground wires to make the distance from the forward edge of the band and the end of the shield and wires equal to 0.10 inch  $\pm$  0.03 inch.

Refer to Figure 41.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445757 S00061545109\_V1

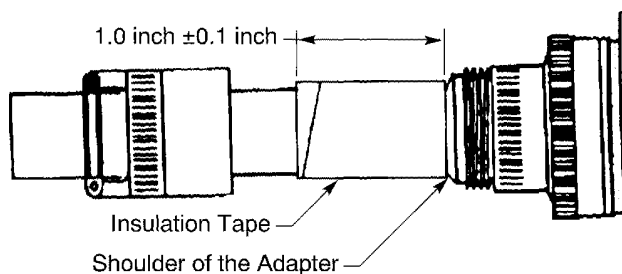
**POSITION OF THE SHIELD AND THE SHIELD GROUND WIRES**

**Figure 41**

**E. Insulation of the Shield Terminator Band**

- (1) Clean these areas of the electrical connection of the shield terminator band with isopropyl alcohol:
  - The shoulder of the backshell adapter
  - The shield terminator band
  - The shield of the primary cable
  - The outer jacket of the primary cable.
- (2) Cut the sufficient length of Scotch 70 insulation tape to put a layer of the tape around the circumference of the area of the electrical connection.
- (3) Cut the length of tape again so that the width is 0.75 inch  $\pm$ 0.10 inch.
- (4) Put the layer of tape on the backshell so that the tape:
  - Makes a small overlap
  - Is on the band termination area
  - Extends 1.0 inch  $\pm$ 0.1 inch from the shoulder of the backshell adapter to the outer jacket of the primary cable.

Refer to Figure 42.



2445758 S00061545110\_V1

**POSITION OF THE INSULATION TAPE ON THE BACKSHELL**

**Figure 42**

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

## ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (5) Apply a 0.02 inch thick, continuous layer of 3145 RTV adhesive sealant on the electrical connection with a clean spatula.

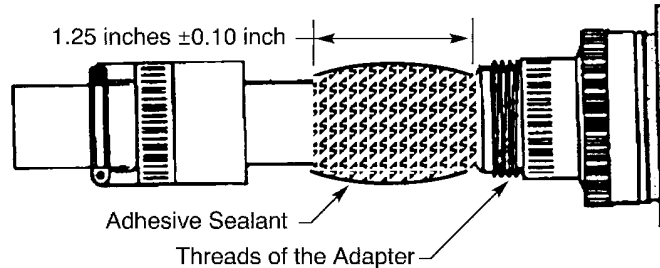
Refer to Figure 43.

Make sure that layer of adhesive sealant:

- Is on the surface and the edges of the insulation tape
- Increases the outside diameter of the cable to a size that is less than the inside diameter of the backshell
- Has no cracks or openings to the surface of the insulation tape or the surface of the backshell.

**CAUTION:** ADHESIVE SEALANT MUST NOT BE APPLIED ON THE THREADS OF THE BACKSHELL ADAPTER. THE THREADS OF STRAIN RELIEF ADAPTER WILL NOT ENGAGE THE THREADS OF THE BACKSHELL ADAPTER.

**NOTE:** It is acceptable if the layer of sealant is not smooth or symmetrical.



2445759 S00061545112\_V1

## LOCATION OF THE ADHESIVE SEALANT

Figure 43

- (6) Cure the sealant at room temperature for 3 hours minimum.

**NOTE:** If the relative humidity is lower than 30 percent, the time for the sealant to fully cure will be longer than normal.

Until the sealant is fully cured, do not:

- Do any other work on the assembly
- Put the assembly in a package.

**F. Installation of the Strain Relief Adapter**

- (1) Push the strain relief adapter until it is against the backshell adapter.
- (2) Engage the threads of the strain relief adapter and the threads of the backshell adapter.
- (3) Turn the strain relief adapter until it stops.
- (4) To prevent the abrasive movement of the cable under the clamp, install either of these types of protection at the location of the clamp on the cable or cables:
  - A BACI12Z insert
  - The sufficient layers of insulation tape.



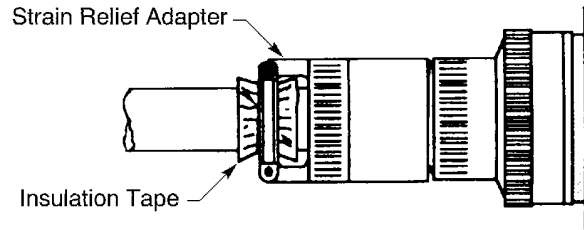
707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

If the protection is insulation tape, make sure that the outer diameter of the cable and the insulation tape is sufficient for the clamp to hold the cable tightly.

Refer to Figure 44.



2445760 S00061545113\_V1

#### POSITION OF THE INSULATION TAPE OR INSERT UNDER THE CABLE CLAMP

Figure 44

- (5) Tighten the cable clamps.

Make sure that the inner surface of the clamp is against the outer surface of the strain relief posts on the backshell.

#### 7. ASSEMBLY OF THE S280W604 BACKSHELL WITH POTTING COMPOUND

**NOTE:** This procedure is not applicable for assembly of S280W604 backshells on S280W501 cable. Refer to Subject 20-14-11 for the assembly procedure for S280W604 backshells on S280W501 cable.

This paragraph gives the procedure to assemble and seal each connector and backshell on both ends of the wire harness.

##### A. Necessary Materials

Table 18  
NECESSARY MATERIALS

Material	Part Number or Specification
Potting Compound	MIL-PRF-8516 Type II Class 2
Shield Sleeve Material	BAC3108
Sleeve, Insulation	DWP-125
Sleeve, Protection	TFE 4X
Sleeve, Fuel Resistant	DR-25

**NOTE:** For sizes and suppliers of sleeves and shield sleeve materials, refer to Subject 20-00-11.

20-25-14

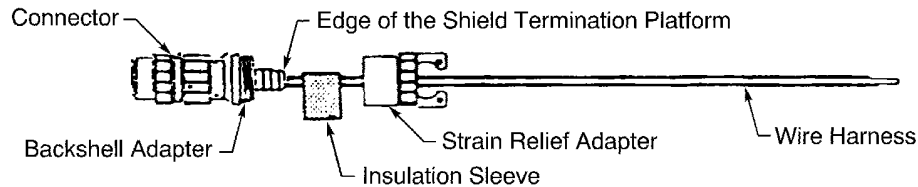


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### B. Assembly of the First Connector



2445761 S00061545114\_V1

#### CONNECTOR ASSEMBLY

Figure 45

- (1) Prepare the cable. Refer to Paragraph 6.A..
- (2) Make a selection of an insulation sleeve from Table 18.  
**NOTE:** For alternative insulation sleeves, refer to Subject 20-00-11.
- (3) Put the backshell on the cable.
- (4) Put a 1.25 inch  $\pm 0.06$  inch length of 1 inch diameter insulation sleeve on the cable. Refer to Figure 45.
- (5) Assemble the connector. Refer to the applicable Subject for the connector.

#### C. Assembly of the First Backshell

- (1) Push the backshell adapter over the wires of the cable and each shield ground wire until the adapter is against the rear of the connector. Refer to Figure 38.  
Make sure that the end of each shield ground wire is through the backshell adapter.
- (2) Carefully, push and turn the backshell adapter until the teeth of the adapter are fully engaged with the teeth of the connector.
- (3) Look in the inspection hole of the backshell adapter. Refer to Figure 39.  
Make sure that the teeth of the backshell adapter are fully engaged with the teeth of the connector.
- (4) Torque the backshell to the specified value in Table 17 with a torque wrench.  
**NOTE:** Do not install lockwire to hold the backshell adapter in position on the connector.

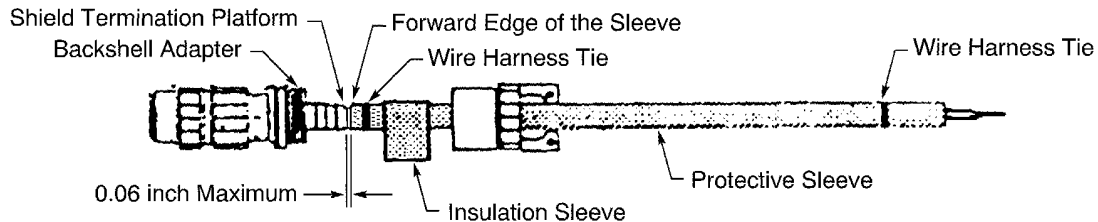
20-25-14

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### D. Installation of the Wire Harness Protection

- (1) Install a protective sleeve on the cable. Refer to Figure 46.



2445762 S00061545115\_V1

#### POSITION OF THE PROTECTIVE SLEEVE ON THE WIRE HARNESS

Figure 46

- (a) Make a selection of a protective sleeve from Table 18.

Make sure that the protective sleeve has a diameter that is sufficiently large to move over the wire harness.

**NOTE:** For alternative protective sleeves, refer to Subject 20-00-11.

- (b) Cut the necessary length of the protective sleeve. Refer to Figure 50.

Make sure that the length of the protective sleeve is equal to the distance:

- From the edge of the shield termination platform of the backshell adapter at one end of the wire harness
- To the edge of the shield termination platform of the backshell adapter at the other end of the wire harness.

- (c) Put the protective sleeve on the wire harness through the strain relief adapter and the insulation sleeve.

Make sure that the distance between the edge of the shield termination platform and the protective sleeve is 0.06 inch maximum.

- (d) Assemble a temporary wire harness tie on each end of the protective sleeve.

- (2) Install a shield on the wire harness. Refer to Figure 47.

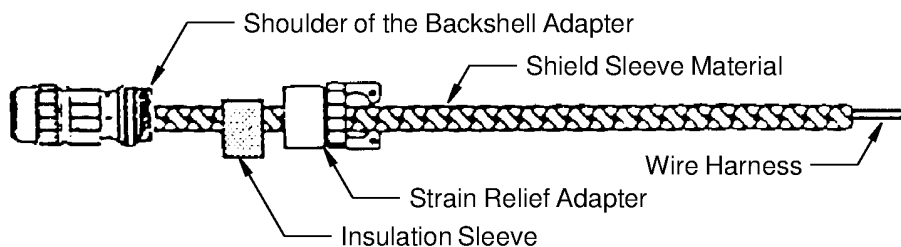




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445763 S00061545116\_V1

#### POSITION OF THE SHIELD SLEEVE MATERIAL ON THE WIRE HARNESS

Figure 47

- (a) Make a selection of a shield sleeve material from Table 18.

Make sure that the shield sleeve material has a diameter that is sufficiently large to move over the sleeve on the wire harness.

**NOTE:** For alternative shield sleeve materials, refer to Subject 20-00-11.

- (b) Cut the necessary length of the shield sleeve material. Refer to Figure 50.

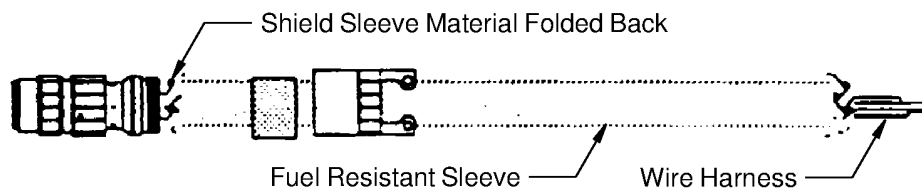
Make sure that the length of the shield sleeve material is 10 percent longer than the distance:

- From the shoulder of the backshell adapter on one end of the wire harness
- To the shoulder of the backshell adapter on the other end of the wire harness.

- (c) Put the shield sleeve material on the wire harness through the strain relief adapter and the adhesive sleeve.

Make sure that the shield termination platform is between the shield and the wire harness.

- (3) Install a fuel resistant sleeve on the wire harness. Refer to Figure 48.



2445764 S00061545117\_V1

#### POSITION OF THE FUEL RESISTANT SLEEVE ON THE WIRE HARNESS

Figure 48

- (a) Make a selection of a fuel resistant sleeve from Table 18. Make sure that the fuel resistant sleeve has a diameter that is sufficiently large to move over the shield.

- (b) Cut the necessary length of the fuel resistant sleeve. Refer to Figure 50.

Make sure that the length of the fuel resistant sleeve is 10 percent longer than the distance:

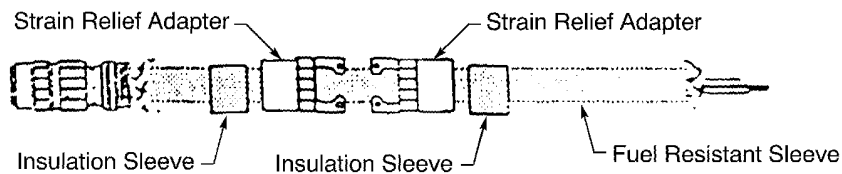
**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- From the shield termination platform of the backshell adapter at one end of the wire harness
  - To the shield termination platform of the backshell adapter at the other end of the wire harness.
- (c) Put the fuel resistant sleeve on the wire harness through the strain relief adapter and adhesive sleeve.
- (4) If the shield sleeve material is longer than the fuel resistant sleeve, fold the shield sleeve material back over the ends of the sleeve at both ends of the wire harness.

#### E. Assembly of the Second Connector



2445765 S00061545118\_V1

#### POSITION OF THE STRAIN RELIEF ADAPTERS ON THE WIRE HARNESS

Figure 49

- (1) Prepare the cable. Refer to Paragraph 6.A.
  - (2) Make a selection of an insulation sleeve from Table 18.
- NOTE:** For alternative insulation sleeves, refer to Subject 20-00-11.
- (3) Put the backshell on the cable.
  - (4) Put a 1.25 inch  $\pm 0.06$  inch length of 1 inch diameter insulation sleeve on the cable. Refer to Figure 49.
  - (5) Assemble the connector. Refer to the applicable Subject for the connector.

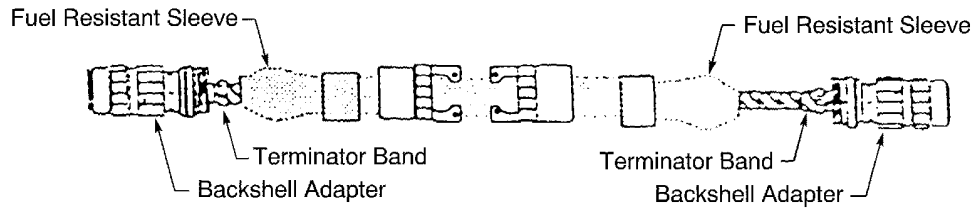
#### F. Assembly of the Second Backshell

- (1) Push both ends of the fuel resistant sleeve back approximately 2 inches from each end of the wire harness.
- (2) Remove the temporary wire harness ties at each end of the protective sleeve. Refer to Figure 46.
- (3) Assemble the backshell. Refer to Paragraph 7.C.

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### G. Installation of the Shield Terminator Bands

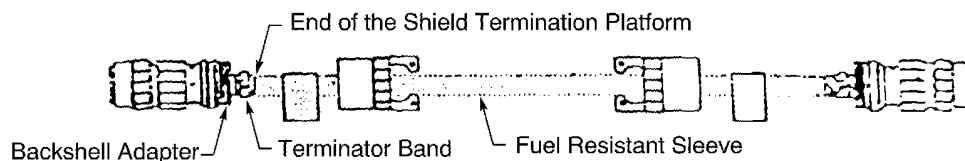


2445766 S00061545119\_V1

#### POSITION OF THE SHIELD TERMINATOR BANDS

Figure 50

- (1) Install the terminator band on the shield at each end of the wire harness.  
Refer to Figure 50 and Paragraph 6.D.
- (2) Shrink the fuel resistant sleeve into its position. Refer to Subject 20-10-14.  
Make sure that the heat is applied from the center of the wire harness toward the ends.
- (3) Remove the length of the fuel resistant sleeve that makes an overlap with the shield termination platform of the backshell adapters at each end of the wire harness.  
Refer to Figure 51.



2445767 S00061545120\_V1

#### REMOVAL OF THE UNWANTED LENGTH OF THE FUEL RESISTANT SLEEVE

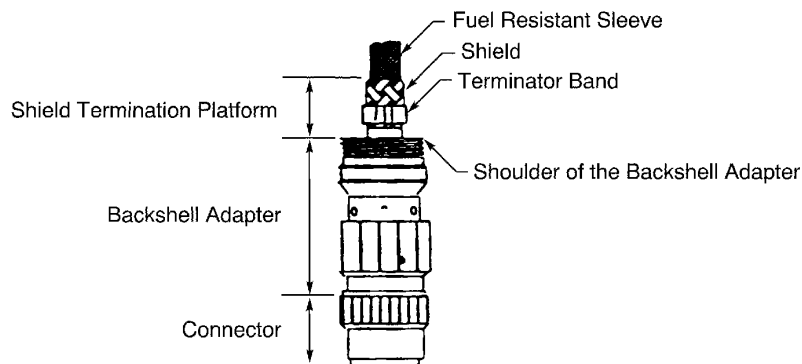
Figure 51

#### H. Seal of the Connector Assembly with Potting Compound

- (1) Put the connector and the wire harness in the vertical position with the forward end of the connector pointed down. Refer to Figure 52.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445768 S00061545121\_V1

**POSITION OF THE CONNECTOR AND THE WIRE HARNESS**

**Figure 52**

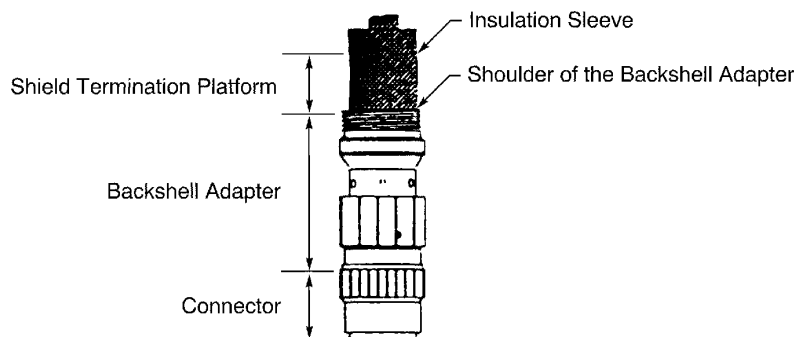
- (2) Push the insulation sleeve over the shield termination platform until the edge of the sleeve is against the shoulder of the backshell adapter.

Refer to Figure 53.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445769 S00061545122\_V1

**POSITION OF THE INSULATION SLEEVE BEFORE THE HEAT IS APPLIED**

**Figure 53**

- (3) Shrink the insulation sleeve into its position. Refer to Subject 20-10-14 and Figure 54.

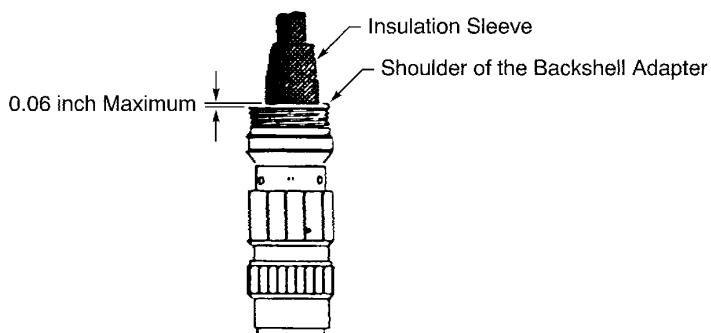
Make sure that:

- A downward force is lightly applied on the insulation sleeve as the heat is applied to keep the edge of the sleeve against the shoulder of the backshell adapter.
- The distance between the shoulder of the backshell adapter and the edge of the insulation sleeve is not greater than 0.06 inch.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**

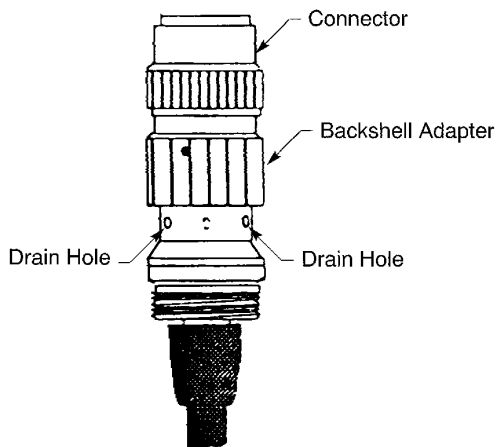


2445770 S00061545123\_V1

**POSITION OF THE INSULATION SLEEVE AFTER THE HEAT IS APPLIED**

**Figure 54**

- (4) Put the connector and the wire harness in the vertical position with the forward end of the connector pointed up. Refer to Figure 55.



2445771 S00061545124\_V1

**POSITION OF THE CONNECTOR AND THE WIRE HARNESS**

**Figure 55**

**20-25-14**

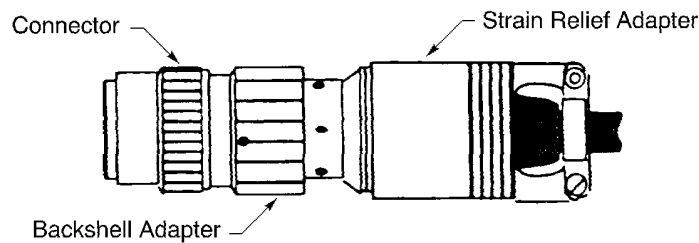
## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (5) Put a temporary layer of tape over one of the 3 drain holes in the side of the backshell adapter.
- (6) Make a selection of a potting compound from Table 18.
- (7) Put the potting compound into one of the remaining drain holes until the potting compound comes out the other remaining drain hole.
- (8) Remove the tape from the first drain hole.
- (9) Put more potting compound into the drain hole until the compound comes out all 3 drain holes.
- (10) Remove any unwanted potting compound from the assembly.
- (11) Let the potting compound cure for 24 hours.  
Make sure that the connector assembly stays in the vertical position.
- (12) Do Step 7.H.(1) through Step 7.H.(11) again for the connector assembly at the other end of the wire harness.

#### I. Installation of the Strain Relief Adapter

- (1) Install the strain relief adapter on the backshell adapter at each end of the wire harness. Refer to Figure 56 and Paragraph 6.F.



2445772 S00061545125\_V1

#### POTTED S280W604 BACKSHELL ASSEMBLY

Figure 56

### 8. ASSEMBLY OF THE GLENAIR 527-187() BACKSHELL ON A SHELL SIZE 1 ARINC 600 PLUG CONNECTOR

#### A. Preparation of Shielded Cables

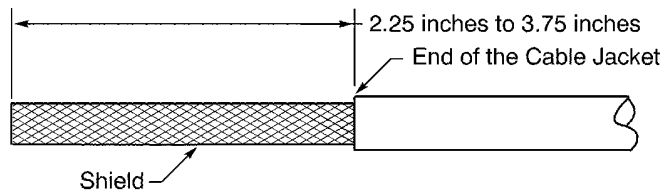
This procedure is applicable for cables with shields that must be attached to the backshell.

- (1) Remove 2.25 inches minimum, to 3.75 inches maximum, of the jacket from the end of a shielded cable. Refer to Figure 57.

Make sure that the jacket removal length is different for each cable in the group of cables that have routing to each connector insert. Refer to Figure 58.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2447991 S00061545126\_V1

**CABLE PREPARATION**

**Figure 57**

- (2) Assemble a solder sleeve with an integral uninsulated shield ground wire on the shielded cable. Make sure that the rear end of the solder sleeve is on the end of the cable jacket. Refer to Subject 20-10-15 for the procedure to assemble the solder sleeves.
- (3) Do Step 8.A.(1) and Step 8.A.(2) again for each shielded cable.

**B. Backshell Assembly**

**Table 19**  
**NECESSARY MATERIALS**

Material	Part Number	Supplier
Sleeve, Heat Shrinkable	AMS-DTL-23053/12 Class 5	An available source
	RT850	Raychem
	RW175	Raychem
	TFE 4X	Chemplast
		Zeus
Tape, Insulation	Scotch 70	3M

- (1) Make a selection of a shield terminator band from Table 3 for each backshell wire entrance that has shielded wires.  
Use the outside diameter of the wire entrance of the backshell to make the selection.

- (2) Make a selection of an insulation tape from Table 19.
- (3) Make a selection of a heat shrinkable sleeve from Table 19.

**NOTE:** A satisfactory alternative to a heat shrinkable sleeve is a layer of insulation tape.

- (4) Put a 2.0 inch  $\pm 0.25$  inch length of heat shrinkable sleeve on each group of wires at each backshell wire entrance.

Make sure that the sleeve has the smallest diameter that can easily move on the backshell wire entrance after the terminator band, and the insulation tape are installed.

**NOTE:** The diameter of the backshell entrance will be increased by the terminator band, and the layers of insulation tape.

- (5) Prepare the ends of the specified shielded cables. Refer to Paragraph 8.A.

**20-25-14**





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (6) Assemble the contacts on the ends of the wires. Refer to Subject 20-71-14.
- (7) Install the contacts in the connector. Refer to Subject 20-71-14.
- (8) Remove the ten screws on the rear of the connector shell that hold the insert retainer plates on the shell.

**NOTE:** Do not remove the insert retainer plates or the connector inserts.

- (9) Discard the screws.

**NOTE:** These screws do not have the sufficient length.

- (10) Install one half of the backshell on the rear of the connector with the screws and lockwashers supplied with the backshell.

Make sure that the retainer plate is between the connector shell and the backshell.

- (a) Align a screw and lockwasher with the applicable backshell installation hole in the backshell.
  - (b) Tighten the screw.
  - (c) Do Step (a) and Step (b) again for each remaining backshell installation screw.
- (11) Wind a sufficient number of layers of tape around the wire harness at each backshell wire entrance to increase the harness diameter to the diameter of the backshell wire entrance hole.
- (12) Install the other half of the backshell on the rear of the connector; Do Step 8.B.(10) again.
- (13) Put the shield ground wires against the backshell around the circumference of the band termination platform. Refer to Figure 58.

Make sure that:

- The distance between each of the shield ground wires is equal around the band termination platform
- The shield ground wires do not make an overlap with each other.

**NOTE:** Tape can be used on the connector shell to temporarily hold the shield ground wires in their positions until the band is installed.

**CAUTION:** DO NOT PUT TAPE ON THE BAND TERMINATION PLATFORMS OF THE BACKSHELL.

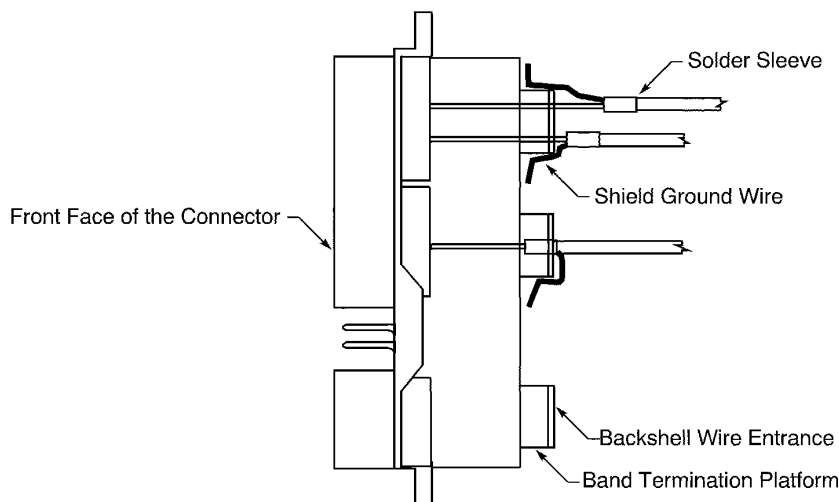
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2447990 S00061545128\_V1

#### CONFIGURATION OF THE SHIELD GROUND WIRES ON THE BAND TERMINATION PLATFORMS OF THE BACKSHELL

Figure 58

- (14) If the wire harness has an overall shield:
  - (a) If the wire harness has a protective sleeve below the overall shield, assemble a wire harness tie on the protective sleeve approximately 2 inches from the rear end of the shield terminations.
  - (b) Pull the end of the overall shield forward on the band termination platform.
  - (c) If the band termination platform has shield ground wires on it, put the end of the overall shield braid on the shield ground wires against the band termination platform.
- (15) Install a shield terminator band on the band termination platform. Refer to Paragraph 15.  
Make sure that no tape is under the shield terminator band.
- (16) Remove the tape used to hold the shield ground wires in their positions.
- (17) Remove the unwanted length of the overall shield. Refer to Figure 59.  
Make sure that the length of the remaining shield braid is 0.10 inch  $\pm$  0.05 inch.

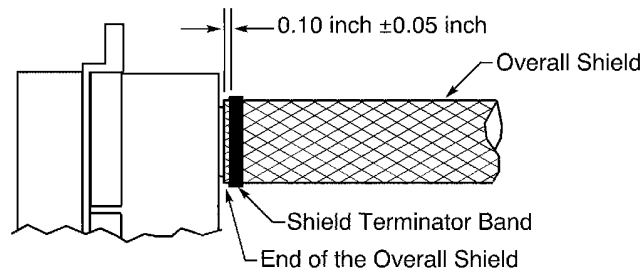
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



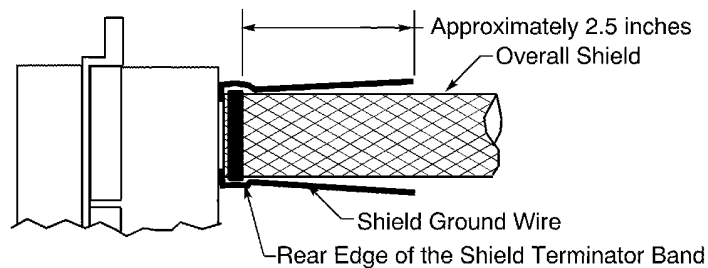
2448008 S00061545129\_V1

#### POSITION OF THE OVERALL SHIELD

Figure 59

- (18) If the band termination platform has shield ground wires installed, fold the shield ground wires back on the band and on the wire harness.
- (19) Cut the ends of the shield ground wires. Refer to Figure 60.

Make sure that the remaining length of the shield ground wires is approximately 2.5 inches from the rear edge of the band.



2448009 S00061545130\_V1

#### POSITION OF THE SHIELD GROUND WIRES

Figure 60

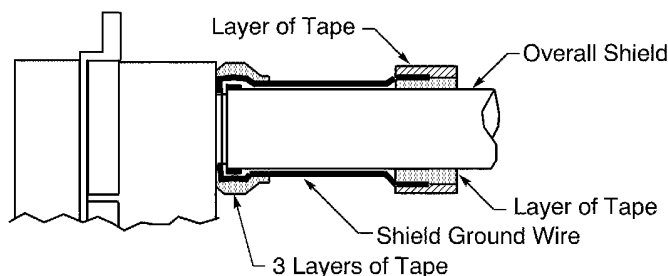
- (20) Wind a sufficient number of layers of insulation tape on the wire harness to hold the ends of the shield ground wires to the harness. Refer to Figure 61.

Make sure that the ends of the shield ground wires are between the layers of tape.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448010 S00061545131\_V1

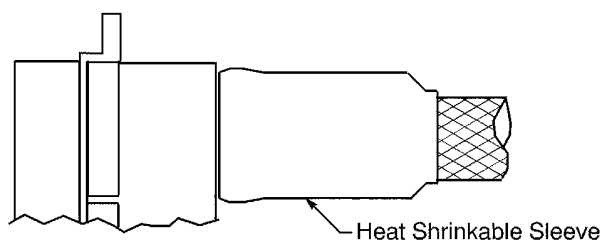
**POSITION OF THE INSULATION TAPE**

**Figure 61**

- (21) Wind a minimum of 3 layers of insulation tape on the shield terminator band. Refer to Figure 61.
- (22) If the wire harness has a protective sleeve on the overall shield:
  - (a) Pull the end of the protective sleeve forward on the band termination platform.
  - (b) Assemble a wire harness tie on the protective sleeve and the band termination platform. Refer to Subject 20-10-11.
- (23) If a length of heat shrinkable sleeve is on the harness:
  - (a) Push the length of heat shrinkable sleeve forward until it is against the rear of the backshell. Make sure that the forward edge of the sleeve is against the rear surface of the backshell.
  - (b) Shrink the sleeve into its position.

Refer to:

- Figure 62 for the location of the sleeve
- Subject 20-10-14 for the procedure to shrink a heat shrinkable sleeve.



2448011 S00061545132\_V1

**POSITION OF THE HEAT SHRINKABLE SLEEVE**

**Figure 62**

- (24) If a length of heat shrinkable sleeve is not on the harness, wind another layer of insulation tape on the harness.  
Make sure that:
  - The insulation tape wrap has a 50 percent overlap

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- The insulation tape layers extend a minimum of 0.5 inch farther rearward than the ends of the shield ground wires.

(25) Do Step 8.B.(13) through Step 8.B.(24) again for each backshell wire entrance.

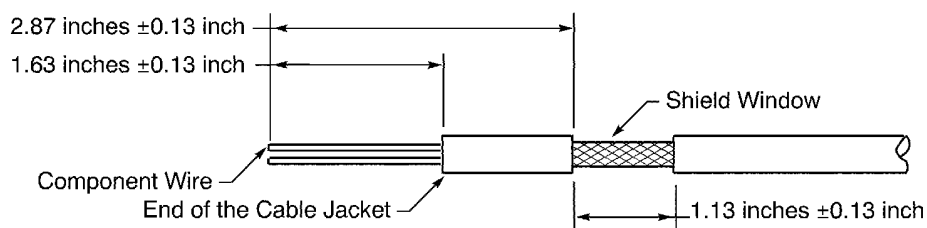
#### 9. ASSEMBLY OF THE GLENAIR 527-212() BACKSHELL ON A SHELL SIZE 2 ARINC 600 PLUG CONNECTOR WITH SHIELD TAPE

##### A. Preparation of Wires and Cables

This procedure is applicable for specified wires, and cables with shields that must be attached to the backshell.

- (1) Prepare the ends of the specified shielded cables:

Refer to Figure 63.



2447992 S00061545133\_V1

#### SHIELDED CABLE PREPARATION

Figure 63

- At a distance of 2.87 inches  $\pm 0.13$  inch from the end of the cable, remove a 1.13 inch  $\pm 0.13$  inch length of the jacket from the shielded cable.
- Remove a 1.63 inches  $\pm 0.13$  inch length of the jacket and the shield from the end of the cable.
- Put a 0.5 inch  $\pm 0.1$  inch length of heat shrinkable sleeve on the forward end of the jacket. Refer to Figure 64.

Make sure that:

- The sleeve has the smallest diameter that can easily move on the cable
- The distance from the end of the jacket to the rear end of the sleeve is not more than 0.25 inch.

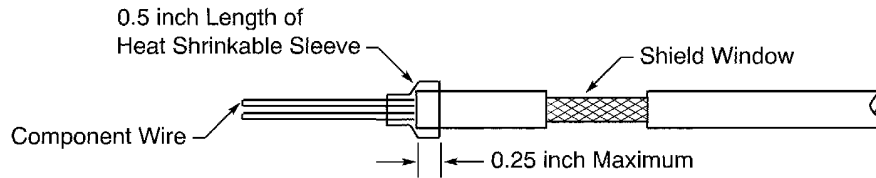
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

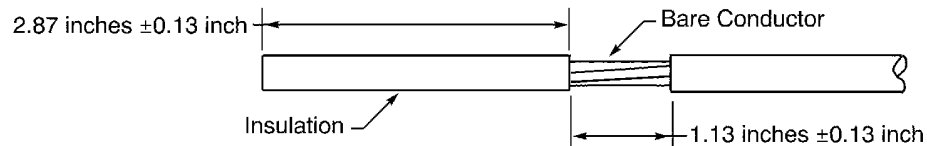


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#### POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE SHIELDED CABLE

Figure 64

- (d) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (2) Prepare the specified single conductor wires:
  - (a) At a distance of 2.87 inches  $\pm 0.13$  inch from the end of the wire, remove a 1.13 inch  $\pm 0.13$  inch length of the insulation from the wire. Refer to Figure 65.



2448005 S00061545135\_V1

#### SINGLE CONDUCTOR WIRE PREPARATION

Figure 65

- (3) Prepare the ends of the specified coax cables that have a protective sleeve, and an overall shield:
  - (a) Remove the necessary length of the overall shield to make the distance from the end of the cable to the end of the overall shield equal to 2.87 inches  $\pm 0.13$  inch. Refer to Figure 66.

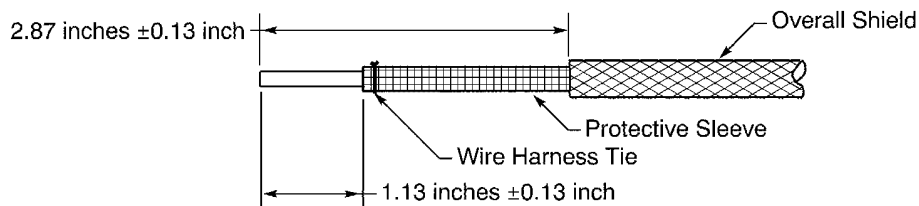
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2447994 S00061545136\_V1

#### PREPARATION OF COAX CABLE THAT HAS A PROTECTIVE SLEEVE AND AN OVERALL SHIELD

Figure 66

- (b) Remove the necessary length of the protective sleeve to make the distance from the end of the cable to the end of the protective sleeve equal to 1.13 inches  $\pm$ 0.13 inch. Refer to Figure 66.
- (c) Assemble a lacing tape wire harness tie near the end of the protective sleeve.

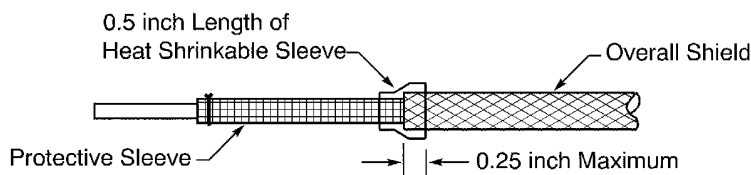
Refer to:

- Figure 66 for the location of the wire harness tie
- Refer to Subject 20-10-11 for the procedure to assemble a lacing tape wire harness tie.

- (d) Put a 0.5 inch  $\pm$ 0.1 inch length of heat shrinkable sleeve on the forward end of the shield. Refer to Figure 67.

Make sure that:

- The sleeve has the smallest diameter that can easily move on the cable
- The distance from the end of the shield to the forward end of the sleeve is not more than 0.25 inch.



2447995 S00061545137\_V1

#### POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE COAX CABLE

Figure 67

- (e) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (4) Prepare the ends of the specified coax cables that do not have a protective sleeve, or an overall shield:

**20-25-14**

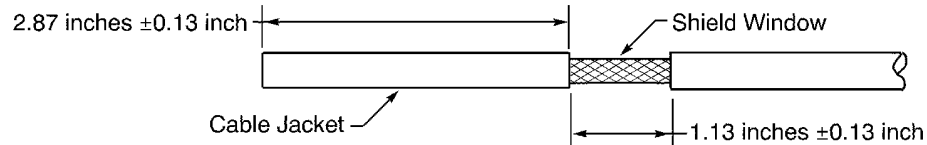


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (a) At a distance of 2.87 inches  $\pm 0.13$  inch from the end of the cable, remove a 1.13 inch  $\pm 0.13$  inch length of the jacket from the cable. Refer to Figure 68.



2447993 S00061545138\_V1

### COAX CABLE PREPARATION

Figure 68

#### B. Backshell Assembly

Table 20  
NECESSARY MATERIALS

Material	Part Number	Supplier
Sleeve, Heat Shrinkable	AMS-DTL-23053/12 Class 5	An available source
	RT850	Raychem
	RW175	Raychem
	TFE 4X	Chemplast
		Zeus
Tape, Insulation	P-440	Permacel
	Scotch 70	3M
	912-10	Arlon
Tape, Shield	Scotch 24	3M

Table 21  
ALTERNATIVE SCREWS AND LOCKWASHERS

Description	Part Number	Supplier
Lockwasher	BACW10EC-04-CD	Boeing
Screw	NAS1801-04-5	An available source

20-25-14

D6-54446

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Page 60  
Oct 15/2015





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Table 22

#### SUPPLIERS OF BOEING STANDARD LOCKWASHERS

Part Number	Supplier
BACW10EC()	Anillo
	Mellowes

- (1) Make a selection of a shield terminator band from Table 3 for each backshell wire entrance. Use the outside diameter of the wire entrance of the backshell to make the selection.

- (2) Make a selection of a insulation tape from Table 20.

- (3) Make a selection of a shield tape from Table 20.

- (4) Make a selection of a heat shrinkable sleeve from Table 20.

**NOTE:** A satisfactory alternative to a heat shrinkable sleeve is a layer of insulation tape.

- (5) Put a 3.00 inch  $\pm 0.25$  inch length of heat shrinkable sleeve on each group of wires at each backshell wire entrance.

Make sure that the sleeve has the smallest diameter that can easily move on the backshell wire entrance after the shield tape, the terminator band, and the insulation tape are installed.

**NOTE:** The diameter of the backshell entrance will be increased by the layers of shield tape, the terminator band, and the layers of insulation tape.

- (6) Prepare the ends of the specified wires and cables. Refer to Paragraph 9.A.

- (7) Assemble the contacts on the ends of the wires. Refer to Subject 20-71-14.

- (8) Install the contacts in the connector. Refer to Subject 20-71-14.

- (9) Wind a sufficient number of layers of insulation tape around the wire harness at each backshell wire entrance until the harness diameter is equal to the diameter of the backshell wire entrance hole. Refer to Figure 69.

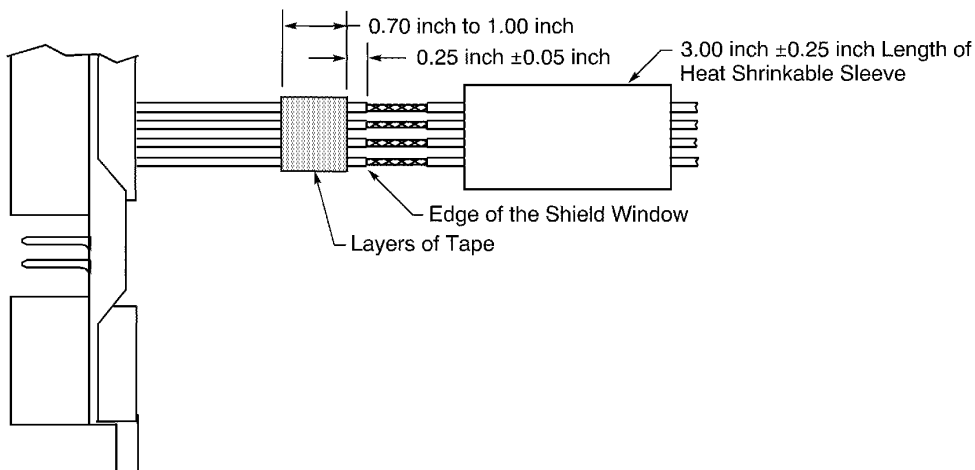
Make sure that:

- The distance from the rear edge of the layers of the insulation tape to the forward end of the shield windows is 0.25 inch  $\pm 0.05$  inch.
- The width of the layers of tape is 0.70 inch to 1.00 inch.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**

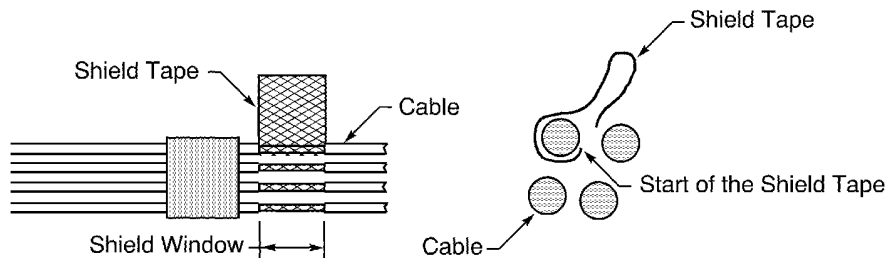


2447996 S00061545139\_V1

**POSITION OF THE LAYERS OF INSULATION TAPE**

**Figure 69**

- (10) Put the end of the shield tape on the shield window of one cable. Refer to Figure 70.  
Make sure that the center of the shield tape is aligned with the center of the shield window.



2447997 S00061545140\_V1

**POSITION OF THE SHIELD TAPE ON ONE CABLE**

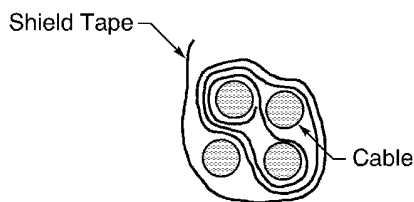
**Figure 70**

- (11) Wind a layer of shield tape on the shield window of one wire. Refer to Figure 70.  
(12) Continue to wind the shield tape on the shield window of each wire. Refer to Figure 71.  
Make sure that the surface of the shield tape is against the shield of each cable.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2447998 S00061545141\_V1

**POSITION OF THE SHIELD TAPE IN THE HARNESS**

**Figure 71**

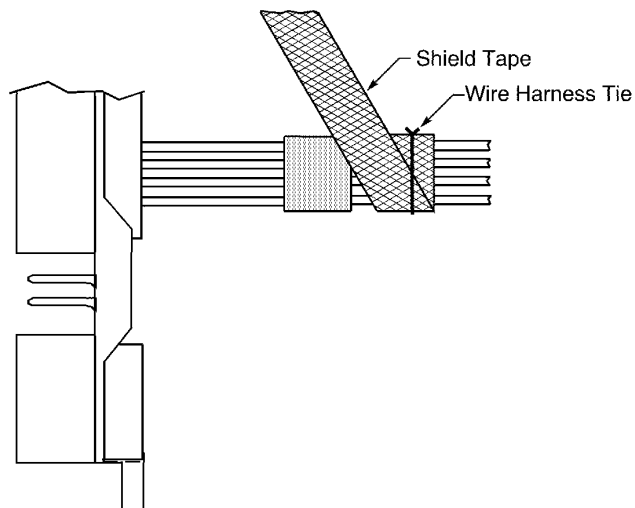
- (13) Wind two full layers of shield tape on all of the cables at the location of the shield windows.
- (14) Assemble a lacing tape wire harness tie on the shield tape.

Refer to:

- Figure 72 for the location of the wire harness tie
- Subject 20-10-11 for the procedure to assemble a wire harness tie.

Make sure that the shield tape that comes out from below the wire harness tie:

- Points to the connector.
- Has sufficient length to do Step 9.B.(22) through Step 9.B.(25).



2448006 S00061545142\_V1

**CONFIGURATION OF THE SHIELD TAPE ON THE SHIELD WINDOWS**

**Figure 72**

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (15) Do Step 9.B.(9) through Step 9.B.(14) again for the harnesses that have routing to each connector insert.
- (16) Remove the ten screws on the rear of the connector shell that hold the insert retainer plates on the shell.

**NOTE:** Do not remove the insert retainer plates or the connector inserts.

- (17) Discard the screws.

**NOTE:** These screws do not have the sufficient length.

- (18) Discard the backshell gaskets supplied with the backshell.
- (19) Install one half of the backshell on the rear of the connector with the screws and lockwashers supplied with the backshell.

**NOTE:** The screws and lockwashers in Table 21 are a satisfactory alternative to the screws supplied with the backshell.

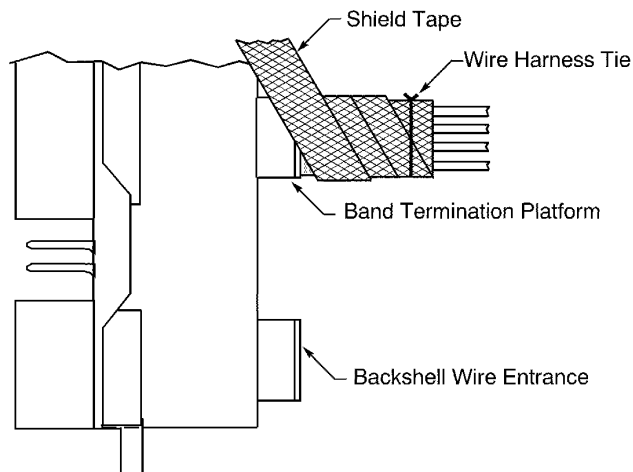
Make sure that the retainer plate is between the connector shell and the backshell.

- (a) Align a screw and lockwasher with the applicable backshell installation hole in the backshell.
  - (b) Tighten the screw.
  - (c) Do Step (a) and Step (b) again for each remaining backshell installation screw.
- (20) Install the other half of the backshell on the rear of the connector; Do Step 9.B.(19) again.
  - (21) Wind more layers of shield tape on the harness until the diameter of the shield tape layers is the same as the diameter of the insulation tape layers.
  - (22) Continue to wind the shield tape on the harness forward to the backshell. Refer to Figure 73.
- Make sure that:
- The shield tape wrap has a 50 percent overlap
  - The shield tape tension is kept moderate and constant.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2447999 S00061545143\_V1

**POSITION OF THE SHIELD TAPE LAYERS**

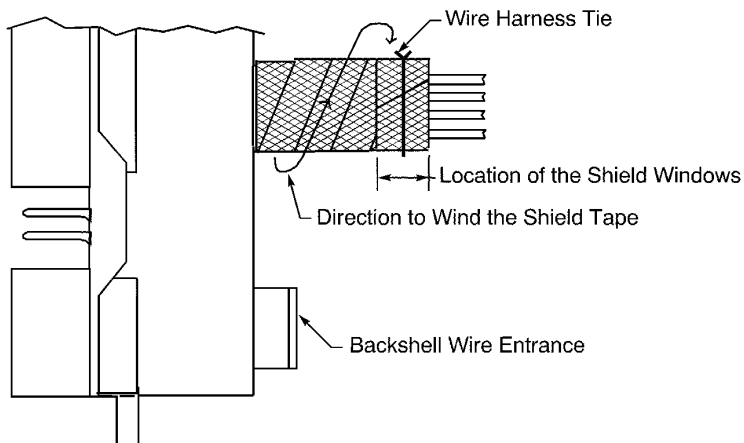
**Figure 73**

- (23) At the backshell, wind two layers of shield tape on the band termination platform. Make sure that the forward edge of the shield tape layers is aligned with the rear surface of the backshell.
- (24) Continue to wind the shield tape rearward to the location of the shield windows. Refer to Figure 74.
- Make sure that:
- The shield tape wrap has a 50 percent overlap
  - The shield tape tension is kept moderate and constant.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448000 S00061545144\_V1

**POSITION OF THE LAST LAYER OF SHIELD TAPE**

**Figure 74**

- (25) At the location of the shield windows, wind one full layer of shield tape on the harness.
- (26) Assemble a lacing tape wire harness tie on the shield tape at the center of the shield window area.

Refer to:

- Figure 74 for the location of the wire harness tie
- Refer to Subject 20-10-11 for the procedure to assemble a lacing tape wire harness tie.

- (27) Install a shield terminator band on the band termination platform.

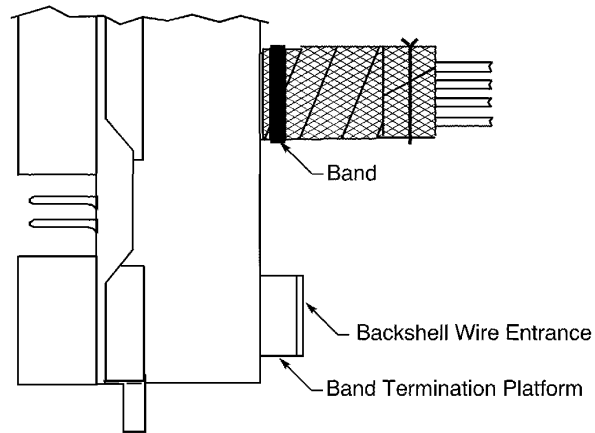
Refer to:

- Figure 75
- Paragraph 15. for the procedure to install the shield terminator band.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448001 S00061545145\_V1

**LOCATION OF THE WIRE HARNESS TIE AND THE SHIELD TERMINATOR BAND ON THE SHIELD TAPE**

**Figure 75**

(28) Wind layers of insulation tape on the shield tape. Refer to Figure 76.

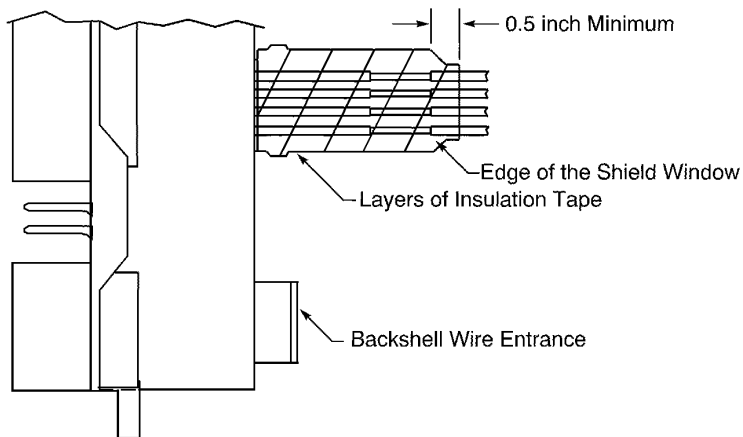
Make sure that:

- The insulation tape wrap has a 50 percent overlap
- The insulation tape layers extend a minimum of 0.5 inch farther rearward than the rear edge of the shield window.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448002 S00061545146\_V1

**CONFIGURATION OF THE INSULATION TAPE LAYERS**

**Figure 76**

- (29) Continue to wind layers of insulation tape until the diameter of the harness is approximately the same as the inside diameter of the heat shrinkable sleeve.
- (30) If a length of heat shrinkable sleeve is on the harness:
  - (a) Push the length of heat shrinkable sleeve forward until it is against the rear of the backshell. Make sure that the forward edge of the sleeve is against the rear surface of the backshell.
  - (b) Shrink the sleeve into its position.

Refer to:

- Figure 77 for the position of the sleeve
- Subject 20-10-14 for the procedure to shrink a heat shrinkable sleeve.

**20-25-14**

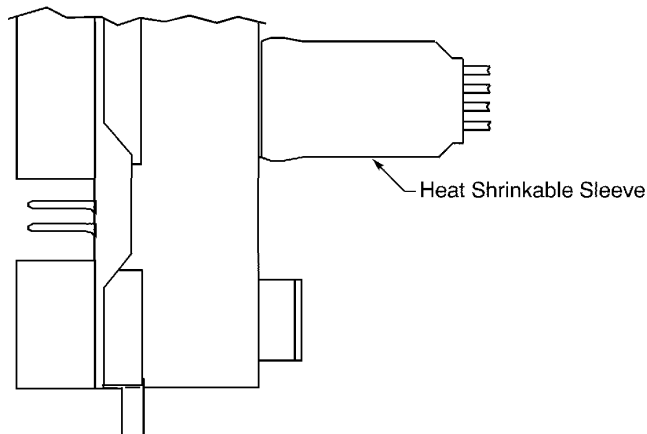




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448003 S00061545147\_V1

#### POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 77

- (31) If a length of heat shrinkable sleeve is not on the harness, wind another layer of insulation tape on the harness.

Make sure that:

- The insulation tape wrap has a 50 percent overlap
- The insulation tape layers extend a minimum of 0.5 inch farther rearward than the shield window area.

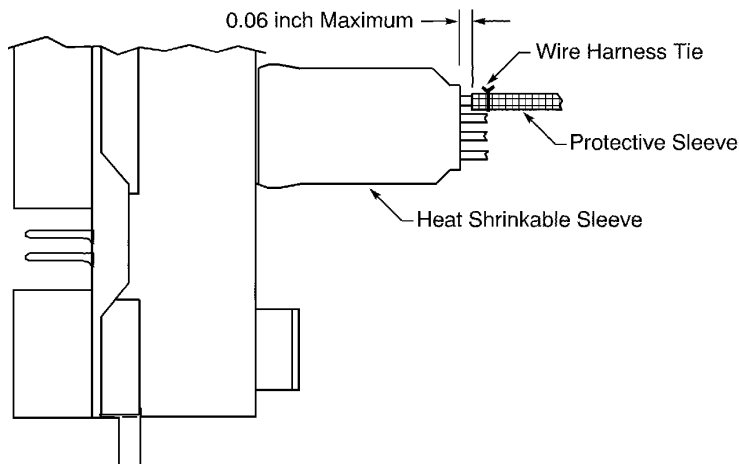
- (32) If a coax cable has a protective sleeve, push the protective sleeve forward to the rear edge of the heat shrinkable sleeve. Refer to Figure 78.

Make sure that the forward edge of the protective sleeve is not more than 0.06 inch from the rear edge of the heat shrinkable sleeve.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448004 S00061545148\_V1

**POSITION OF THE PROTECTIVE SLEEVE OF THE COAX CABLE**

**Figure 78**

- (33) Assemble a wire harness tie near on each protective sleeve near the end of the sleeve.

Refer to:

- Figure 78 for the location of the wire harness tie
- Subject 20-10-11 for the procedure to assemble the tie.

- (34) Do Step 9.B.(21) through Step 9.B.(33) again for each backshell wire entrance.

**10. ASSEMBLY OF THE GLENAIR 527-212() BACKSHELL ON A SHELL SIZE 2 ARINC 600 PLUG CONNECTOR WITH SHIELD GROUND WIRES**

**A. Glenair 527-212 Backshell - Cable Preparation for a Solder Sleeve Shield Termination**

**Table 23**  
**CABLE JACKET REMOVAL LENGTH**

Solder Sleeve	Removal Length L (inch)	
	Target	Tolerance
BACS13CT	2.00	±0.06
BACS13DG	2.00	±0.06
D-104	2.10	±0.06
D-108	2.17	±0.06

- (1) For a 527-212MA9B9C4S backshell:

**20-25-14**

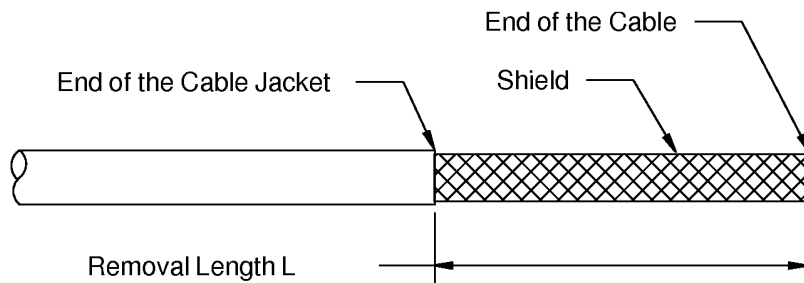
## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (a) Make a selection of a Grade B, Class 1 heat shrinkable sleeve from Subject 20-00-11.
- (b) Put a 4.0 inch length of the heat shrinkable sleeve on each wire harness.
- (2) Make a selection of a solder sleeve with an integral shield ground wire from Table 23.
- (3) Put the solder sleeve on the cable.  
Make sure that the shield ground wire is pointed rearward away from the end of the cable.
- (4) Remove the necessary length of jacket from the end of the cable.

Refer to:

- Figure 79 for the cable jacket removal length
- Subject 20-00-15 for the procedure to remove the cable jacket.

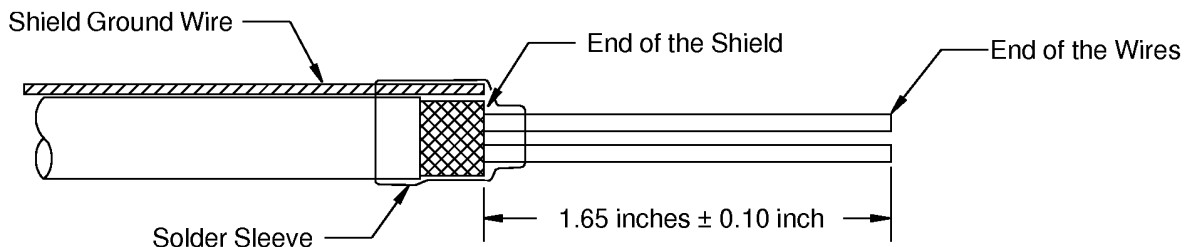


2448958 S00061545149\_V1

#### CABLE PREPARATION

Figure 79

- (5) Assemble an uninsulated shield ground wire at the end of the cable jacket. Refer to Subject 20-10-15.  
Make sure that the free end of the shield ground wire is pointed rearward, away from the end of the wires.
- (6) Remove the necessary length from the end of each component wire to make the distance from the end of the shield to the end of the wire equal to 1.65 inches  $\pm$  0.10 inch. Refer to Figure 80.



2448959 S00061545150\_V1

#### LENGTH OF THE COMPONENT WIRES

Figure 80

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

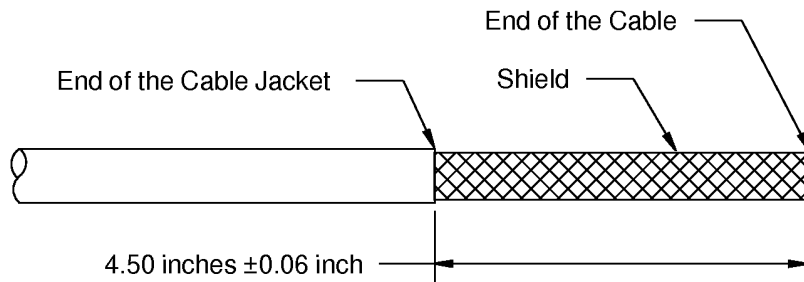
### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### B. Glenair 527-212 Backshell - Cable Preparation for a Shield Pull Through Shield Termination

- (1) For a 527-212MA9B9C4S backshell:
  - (a) Make a selection of a Grade B, Class 1 heat shrinkable sleeve from Subject 20-00-11.
  - (b) Put a 4.0 inch length of the heat shrinkable sleeve on each wire harness.
- (2) Remove 4.50 inches  $\pm 0.06$  inch of jacket from the end the cable.

Refer to:

- Figure 81
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448960 S00061545151\_V1

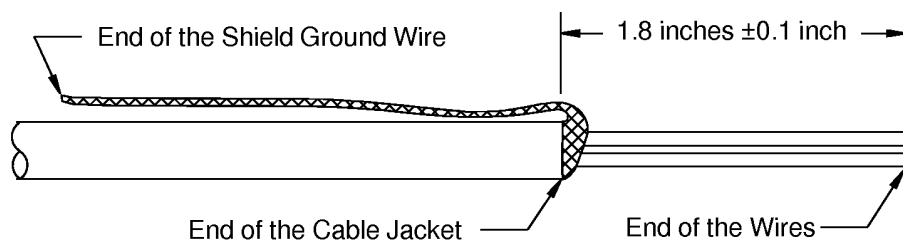
#### CABLE JACKET REMOVAL

Figure 81

- (3) Assemble the shield pull through shield ground wire.

Refer to:

- Figure 82
- Subject 20-10-15 for the procedure to assemble the shield ground wire.



2448961 S00061545152\_V1

#### LENGTH OF THE COMPONENT WIRES

Figure 82

- (4) Remove the necessary length from the end of each component wire to make the distance from the end of the shield to the end of the wire equal to 1.8 inches  $\pm 0.1$  inch. Refer to Figure 82.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### C. Glenair 527-212 Backshell Installation

Table 24  
NECESSARY TOOLS

Tool	Size	Supplier
Screw Bit, Phillips	#0	An available source
	#00	An available source
Screwdriver, Phillips	#0	An available source
	#00	An available source
Screwdriver, Torque	-	An available source

- (1) For the 527-212MA9B9C4S backshell, put a 4.0 inch length of a Class 1, Grade B heat shrinkable sleeve on each wire harness.
- (2) Make a selection of a screwdriver from Table 24.
- (3) At the rear of the connector, remove the ten screws that hold the insert retainer plates on the connector shell.  
Make sure that the insert retainer plates are not removed.
- (4) Discard the screws.  
**NOTE:** The screws do not have the sufficient length for the installation of the backshell.
- (5) Discard the backshell gaskets that are supplied with the backshell.
- (6) Put one of the backshell halves on the wire harness against the rear of the connector shell. Refer to Refer to Figure 83.  
Make sure that the insert retainer plates are between the connector shell and the backshell.

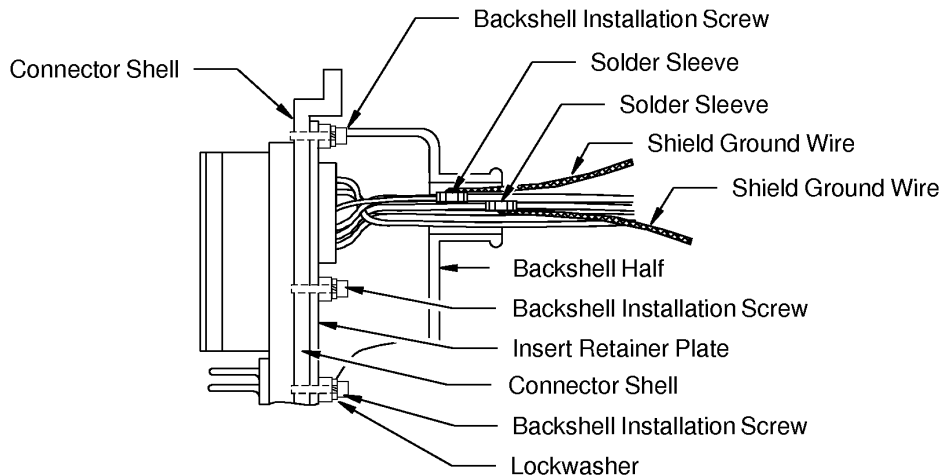
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448962 S00061545153\_V1

#### POSITION OF THE BACKSHELL ON THE CONNECTOR

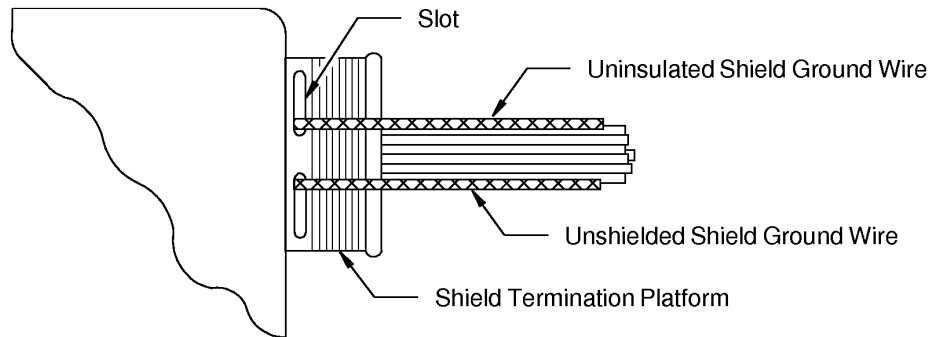
Figure 83

- (7) Put a lock washer that is supplied with the backshell on each backshell installation screw against the head of each screw.
- (8) Fully engage the threads of the each backshell installation screw and the threads of the applicable installation hole on the rear surface of the connector shell. Refer to Figure 83.
- (9) Put approximately half of the shield ground wires through the slots in the shield termination platform. Refer to Figure 84.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448708 S00061545154\_V1

**POSITION OF THE SHIELD GROUND WIRES IN THE SLOTS**

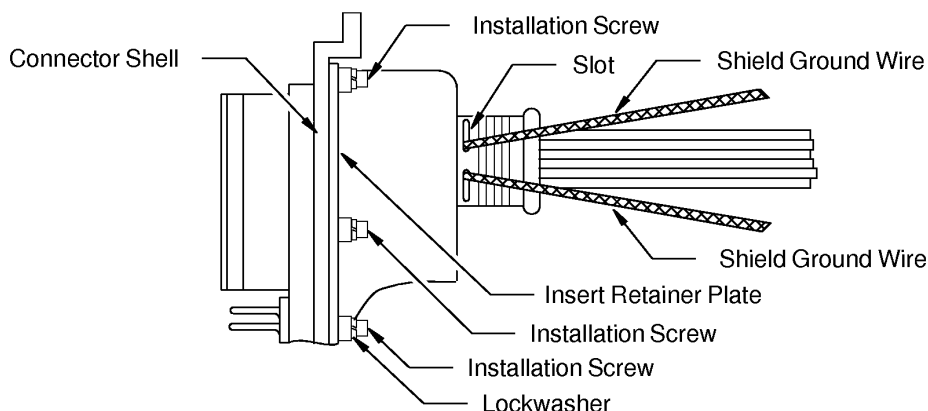
**Figure 84**

- (10) If the slots do not have sufficient space for the shield ground wires, fold the remaining shield ground wires forward on the wire harness. Refer to Figure 83.
- (11) Put the other half of the backshell on the wire harness against the rear of the connector shell.
- (12) Do Step 8 and Step 9 again for the other half of the backshell. Refer to Figure 85.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448964 S00061545155\_V1

**POSITION OF THE SHIELD GROUND WIRES IN THE SLOT**  
**Figure 85**

- (13) Put a lockwasher that is supplied with the backshell on each backshell installation screw against the head of the screw.
- (14) Fully engage the threads of the each backshell installation screw and the threads of the applicable installation hole on the rear surface of the connector shell. Refer to Figure 85.
- (15) Torque each backshell installation screw 6 inch-pounds to 8 inch-pounds.

**D. Glenair 527-212MA9B9C4S Backshell - Shield Ground Wire Termination**

**Table 25**  
**NECESSARY MATERIALS**

Component	Type	Specification
Tape	PTFE	A-A-59474
	Silicone, Type I	A-A-59163
	Silicone, Type II	A-A-59163

- (1) For the shield ground wires that are in the slots:
  - (a) Lightly pull the end of each shield ground wire.  
For a solder sleeve shield termination, make sure that the solder sleeve does not come out of the slot of the termination platform.
  - (b) Put the shield ground wires across the shield termination platform at approximately equal intervals around its circumference. Refer to Figure 86.

**20-25-14**

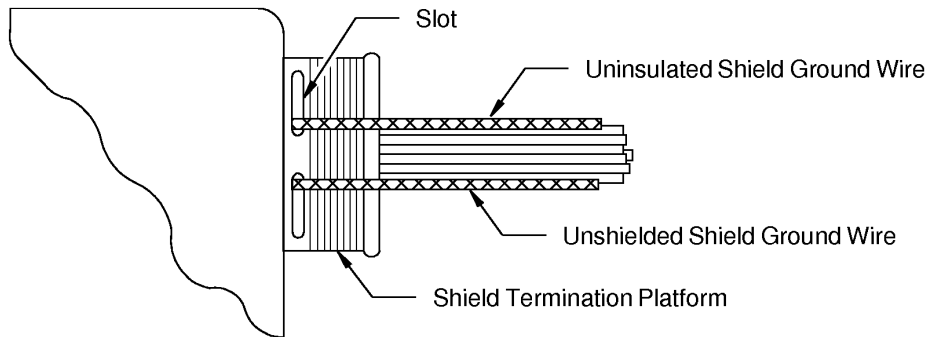




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448708 S00061545154\_V1

#### POSITION OF THE SHIELD GROUND WIRES ON THE SHIELD TERMINATION PLATFORM

Figure 86

- (2) For the shield ground wires that are folded forward on the wire harness:
  - (a) Lightly pull the end of each shield ground wire in cable exit of the backshell.
  - (b) Fold the shield ground wire forward across the shield termination platform between the shield ground wires that are in the slots.

Make sure that a shield ground wire does not make an overlap with a different shield ground wire on the platform.
- (3) Install the shield terminator band on the shield ground wires at the rear of the slot on the shield termination platform.

Refer to:

- Figure 87
- Paragraph 15.A. for the procedure to install the band.

Make sure that:

- The buckle of the band is flat against the platform
- The buckle of the band does not make an overlap with the shield ground wires
- The buckle of the band does not make an overlap with the slots on the platform
- The buckle of the band does not make an overlap with the collar of the platform
- The shield ground wires are tight against the platform
- The distance between the rear edge of the cable exit and each shield ground wire that is folded forward is between 0.3 inch and 0.5 inch.

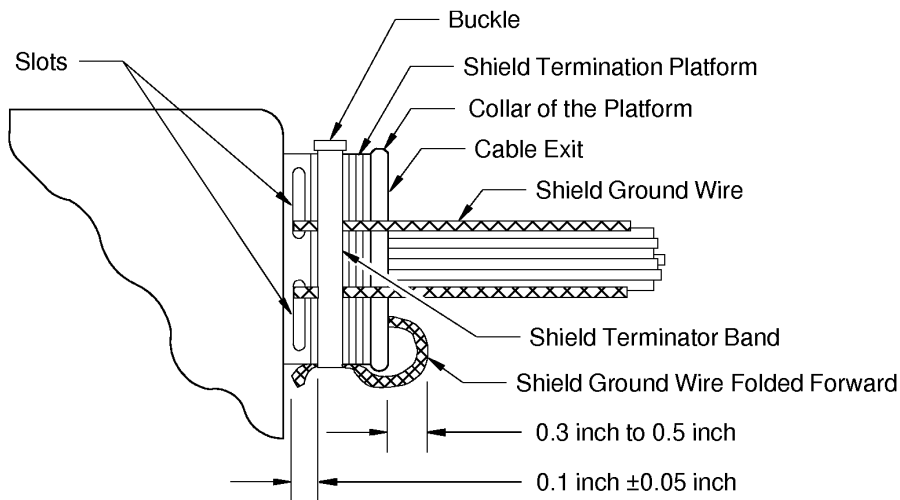
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448963 S00061545156\_V1

#### POSITION OF THE SHIELD TERMINATOR BAND ON THE SHIELD GROUND WIRES

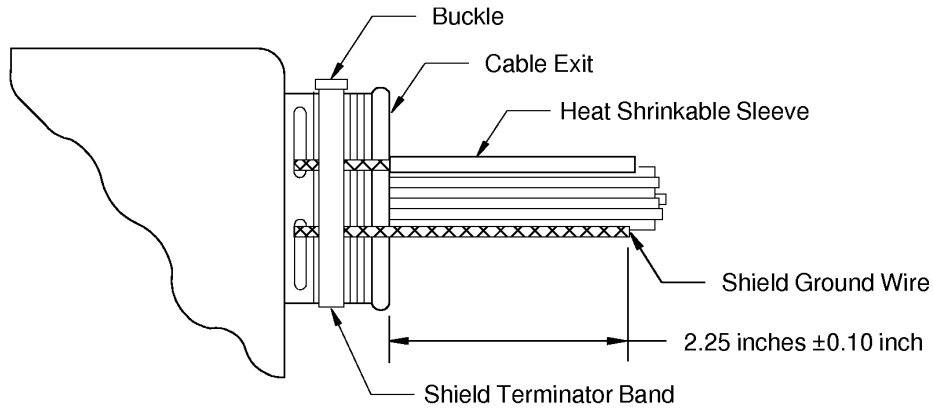
Figure 87

- (4) For the shield ground wires that are folded forward across the shield termination platform, cut each shield ground wire 0.10 inch  $\pm 0.05$  inch from the forward edge of the shield terminator band. Refer to Figure 87.
- (5) For the shield ground wires that are in the slots:
  - (a) Remove the necessary length of each shield ground wire to make the distance from the backshell to the end of the shield ground wire equal to 2.25 inches  $\pm 0.10$  inch. Refer to Figure 88.

20-25-14



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448965 S00061545157\_V1

**POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE SHIELDED GROUND WIRE**

**Figure 88**

- (b) Cut a 3.00 inch  $\pm 0.10$  inch length of the specified heat shrinkable sleeve for each shield ground wire.
- (c) Install a heat shrinkable sleeve on each shield ground wire.

Refer to:

- Figure 88
- Subject 20-10-14 for the procedure to shrink the sleeve.

Make sure that the heat shrinkable sleeve is installed as close as possible to the backshell.

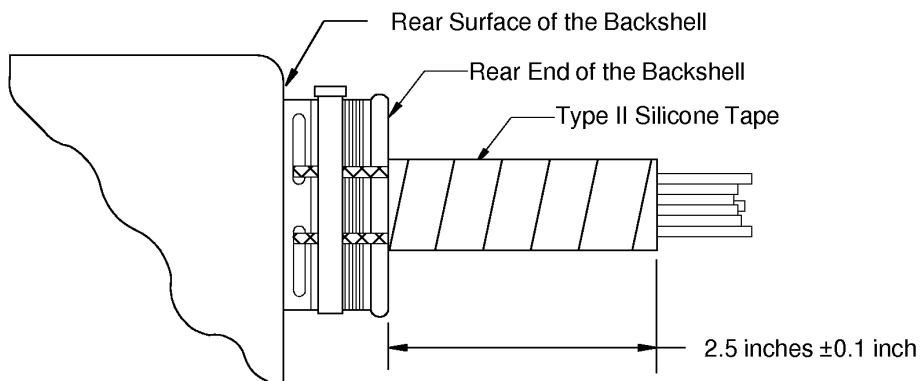
- (6) Put 2 to 3 layers of the PTFE tape on the shield terminator band.
- (7) Put 2 to 3 layers of the Type I silicone tape on the PTFE tape.
- (8) Put the necessary layers of the Type II silicone tape on the wire harness and the shield ground wires until the diameter of the wire harness is a small amount smaller than the outer diameter of the rear end of the backshell. Refer to Figure 89.

Make sure that the layers of tape:

- Start at the rear end of the backshell
- Extend 2.5 inches  $\pm 0.10$  inch from the rear end of the backshell
- Do not make an overlap with the backshell
- Have a 50 percent overlap.

**20-25-14**

**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448966 S00061545158\_V1

**POSITION OF THE TAPE ON THE WIRE HARNESS**

**Figure 89**

- (9) Push the 4.0 inch length of heat shrinkable sleeve forward until the forward edge of the sleeve is against the rear surface of the backshell. Refer to Figure 89.
- (10) Shrink the sleeve into its position. Refer to Subject 20-10-14.

**E. Glenair 527-212MA9B9C6S Backshell - Shield Ground Wire Termination**

**Table 26**  
**NECESSARY MATERIALS**

Component	Type	Specification
Tape	PTFE	A-A-59474
	Silicone, Type I	A-A-59163
	Silicone, Type II	A-A-59163

- (1) For the shield ground wires that are in the slots:
  - (a) Lightly pull the end of each shield ground wire.  
 For a solder sleeve shield termination, make sure that the solder sleeve does not come out of the slot of the termination platform.
  - (b) Put the shield ground wires across the shield termination platform at approximately equal intervals around its circumference. Refer to Figure 90.

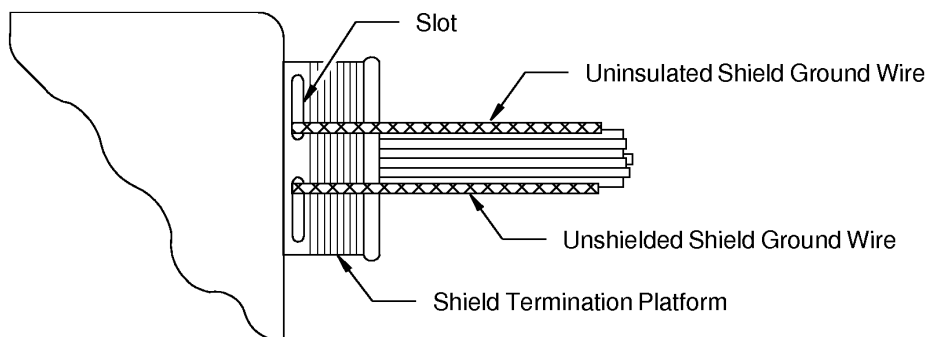
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448708 S00061545154\_V1

#### POSITION OF THE SHIELD GROUND WIRES ON THE SHIELD TERMINATION PLATFORM

Figure 90

- (2) For the shield ground wires that are folded back on the wire harness:
  - (a) Lightly pull the end of each shield ground wire in cable exit of the backshell.
  - (b) Fold the shield ground wire forward across the shield termination platform between the shield ground wires that are in the slots.

Make sure that a shield ground wire does not make an overlap with a different shield ground wire on the platform.
- (3) Install the shield terminator band on the shield ground wires at the rear of the slot on the shield termination platform.

Refer to:

- Figure 91
- Paragraph 15.A. for the procedure to install the band.

Make sure that:

- The buckle of the band is flat against the platform
- The buckle of the band does not make an overlap with the shield ground wires
- The buckle of the band does not make an overlap with the slots on the platform
- The buckle of the band does not make an overlap with the collar of the platform
- The shield ground wires are tight against the platform
- The distance between the rear edge of the cable exit and each shield ground wire that is folded forward is between 0.3 inch and 0.5 inch.

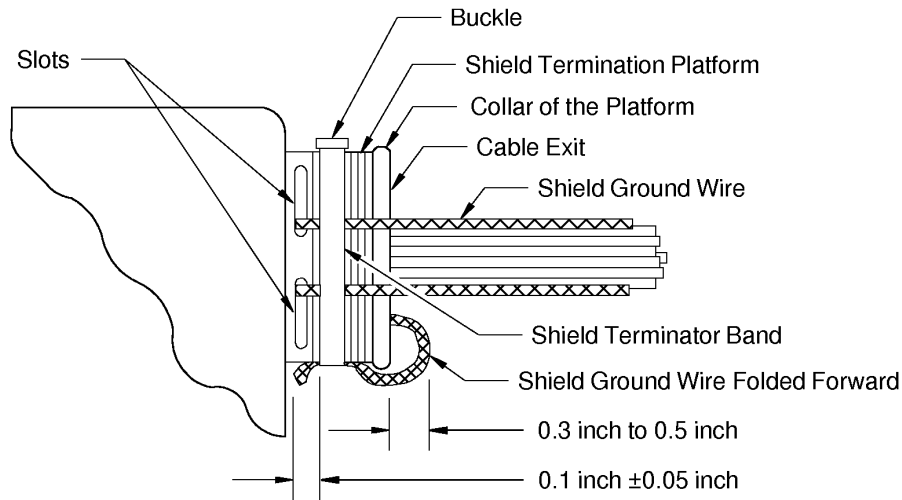
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448963 S00061545156\_V1

#### POSITION OF THE SHIELD TERMINATOR BAND ON THE SHIELD GROUND WIRES

Figure 91

- (4) For the shield ground wires that are in the slots, remove the necessary length of each shield ground wire to make the distance from the backshell to the end of the shield ground wire equal to 1.5 inches  $\pm$ 0.1 inch. Refer to Figure 92.

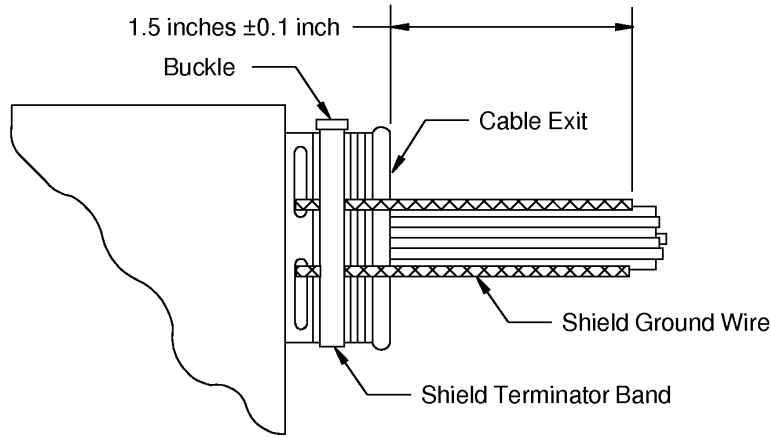
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448714 S00061545159\_V1

#### LENGTH OF THE SHIELD GROUND WIRES

Figure 92

- (5) For the shield ground wires that are folded forward across the shield termination platform, cut each shield ground wire 0.10 inch  $\pm$ 0.05 inch from the forward edge of the shield terminator band.
- (6) Put the necessary layers of Type I silicone tape on the wire harness and the shield ground wires at the rear of the cable exit. Refer to Figure 93.

Make sure that:

- The layers of tape make an approximately 100 percent overlap
- If the O.D. of the wire harness is equal to or larger than 75 percent of the O.D. of the cable exit, a minimum of two layers of tape are put on
- If the O.D. of the wire harness is smaller than 75 percent of the O.D. of the cable exit, the necessary layers of tape are put on to make the O.D. of the wire harness approximately equal to 75 percent of the O.D. of the cable exit.

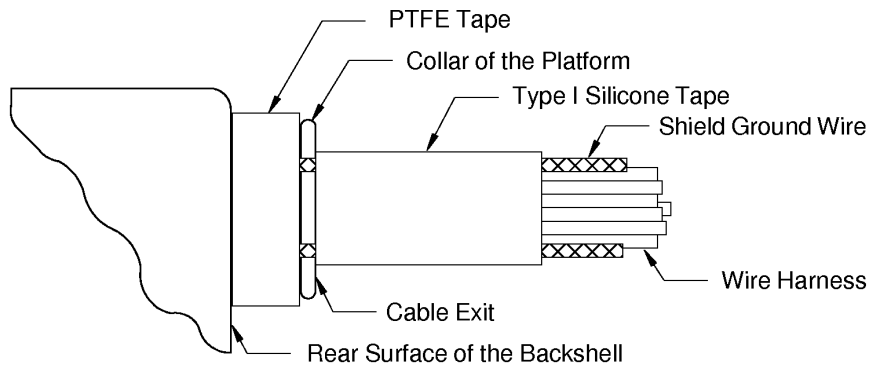
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448984 S00061545160\_V1

#### POSITION OF THE TAPE ON THE WIRE HARNESS

Figure 93

- (7) Put 2 to 3 layers of the PTFE tape on the shield terminator band.
- (8) Put a layer of Type II silicone tape on the wire harness and the shield ground wires. Refer to Figure 94.

Make sure that the layer of tape:

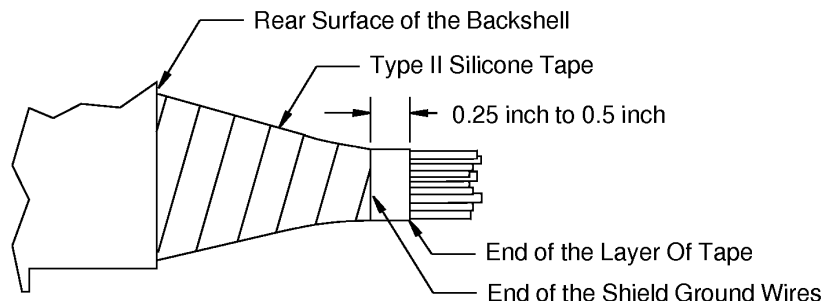
- Starts 0.25 inch maximum rearward from the end of the longest shield ground wire
- Ends at the rear surface of the backshell
- Makes approximately a 50 percent overlap.

**20-25-14**





**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448716 S00061545161\_V1

**POSITION OF THE TAPE ON THE WIRE HARNESS**

**Figure 94**

- (9) Put a second layer of Type II silicone tape on the wire harness and the shield ground wires. Refer to Figure 94.

Make sure that the layer of tape:

- Starts at the rear surface of the backshell
- Extends 0.25 inch to 0.5 inch farther than the longest shield ground wire
- Makes approximately a 50 percent overlap
- At the rear end makes approximately a 100 percent overlap.

**F. Disassembly of the 527-212MA9B9C4S Backshell**

**Table 27**  
**NECESSARY TOOLS**

Tool	Size	Supplier
Screw Bit, Phillips	#0	An available source
	#00	An available source
Screwdriver, Phillips	#0	An available source
	#00	An available source

- (1) Make a selection of a screwdriver from Table 27.
- (2) Remove the overall heat shrinkable sleeve from the wire harness.
- (3) Remove the layers of silicone tape from the wire harness.

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (4) Remove the layers of PTFE tape from the shield termination platform.
- (5) Remove the shield terminator band from the backshell. Refer to Paragraph 15.A..
- (6) Disengage the backshell installation screws on one backshell half.
- (7) Carefully pull the shield ground wires out of the slots in the backshell half.
- (8) Do Step 10.F.(6) and Step 10.F.(7) again for the other half of the backshell.

#### G. Disassembly of the 527-212MA9B9C6S Backshell

Table 28  
NECESSARY TOOLS

Tool	Size	Supplier
Screw Bit, Phillips	#0	An available source
	#00	An available source
Screwdriver, Phillips	#0	An available source
	#00	An available source

- (1) Make a selection of a screwdriver from Table 28.
- (2) Remove the layers of silicone tape from the wire harness.
- (3) Remove the shield terminator band from the backshell. Refer to Paragraph 15.A..
- (4) Disengage the backshell installation screw on one backshell half.
- (5) Carefully pull the shield ground wires out of the slots in the backshell half.
- (6) Do Step 10.G.(4) and Step 10.G.(5) again for the other half of the backshell.

#### H. Replacement of the Overall Heat Shrinkable Sleeve

- (1) Remove the overall heat shrinkable sleeve from the wire harness.
- (2) Remove the layers of silicone tape from the wire harness and the backshell.  
Make sure that the PTFE tape on the shield terminator band stays on the band.
- (3) Put the necessary layers of Type I silicone tape on the wire harness and the shield ground wires at the rear of the cable exit. Refer to Figure 95.

Make sure that:

- The layers of tape make an approximately 100 percent overlap
- If the O.D. of the wire harness is equal to or larger than 75 percent of the O.D. of the cable exit, a minimum of two layers of tape are put on
- If the O.D. of the wire harness is smaller than 75 percent of the O.D. of the cable exit, the necessary layers of tape are put on to make the O.D. of the wire harness approximately equal to 75 percent of the O.D. of the cable exit.

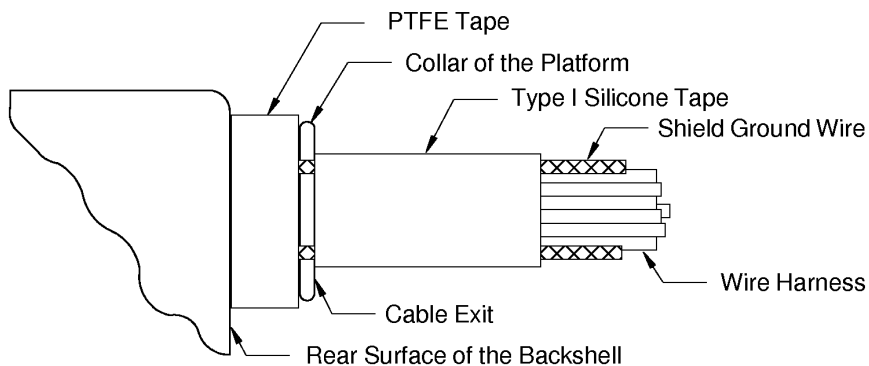
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448984 S00061545160\_V1

#### POSITION OF THE TAPE ON THE WIRE HARNESS

Figure 95

- (4) Put a layer of Type II silicone tape on the wire harness and the shield ground wires. Refer to Figure 96.

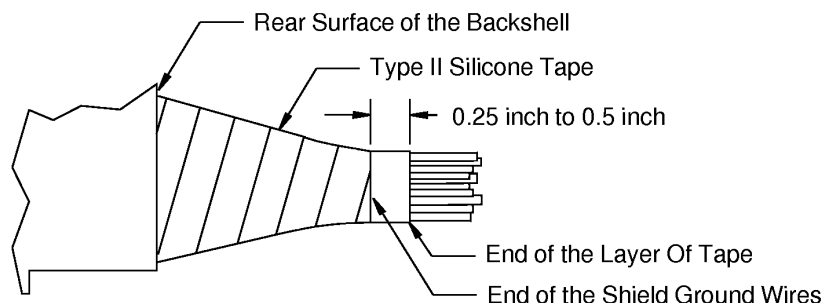
Make sure that the layer of tape:

- Starts 0.25 inch maximum rearward from the end of the longest shield ground wire
- Ends at the rear surface of the backshell
- Makes approximately a 50 percent overlap.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2448716 S00061545161\_V1

**POSITION OF THE TAPE ON THE WIRE HARNESS**

**Figure 96**

- (5) Put a second layer of Type II silicone tape on the wire harness and the shield ground wires. Refer to Figure 96.

Make sure that the layer of tape:

- Starts at the rear surface of the backshell
- Extends 0.25 inch to 0.5 inch farther than the longest shield ground wire
- Makes approximately a 50 percent overlap
- At the rear end makes approximately a 100 percent overlap.

**11. ASSEMBLY OF THE GLENAIR 527-530MP29 OR 527-108() BACKSHELL ON A SHELL SIZE 3 ARINC 600 PLUG CONNECTOR WITH SHIELD GROUND WIRES**

**A. Assembly of the Glenair 527-530MP29 or 527-108() Backshell - Cable Preparation for a Solder Sleeve Shield Termination**

**Table 29**  
**CABLE JACKET REMOVAL LENGTH**

Solder Sleeve	Removal Length L (inch)	
	Target	Tolerance
BACS13CT	2.00	±0.06
BACS13DG	2.00	±0.06
D-104	2.10	±0.06

**20-25-14**

# STANDARD WIRING PRACTICES MANUAL

## ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

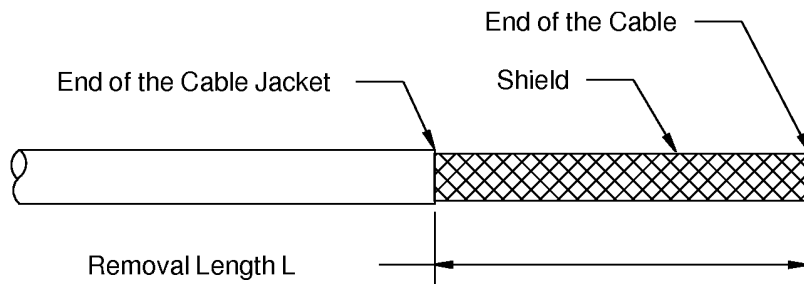
Table 29 CABLE JACKET REMOVAL LENGTH (Continued)

Solder Sleeve	Removal Length L (inch)	
	Target	Tolerance
D-108	2.17	±0.06

- (1) For a Glenair 527-530MP29 or 527-108() backshell:
  - (a) Make a selection of a Grade B, Class 1 heat shrinkable sleeve from Subject 20-00-11.
  - (b) Put a 4.0 inch length of the heat shrinkable sleeve on each wire harness.
- (2) Make a selection of a solder sleeve with an integral shield ground wire from Table 29.
- (3) Put the solder sleeve on the cable.  
Make sure that the shield ground wire is pointed rearward away from the end of the cable.
- (4) Remove the necessary length of jacket from the end of the cable.

Refer to:

- Figure 97 for the cable jacket removal length
- Subject 20-00-15 for the procedure to remove the cable jacket.



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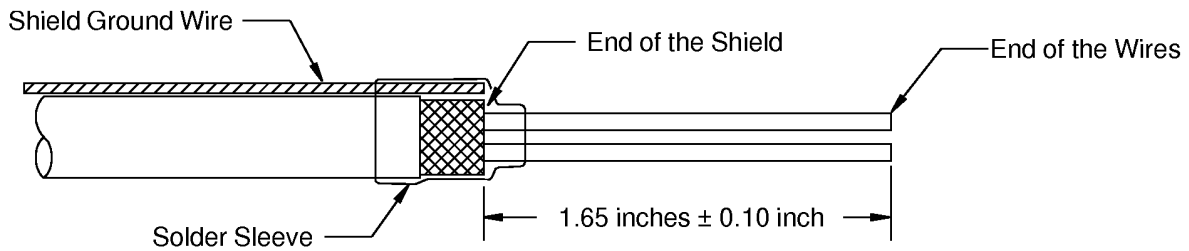
### CABLE PREPARATION

Figure 97

- (5) Assemble an uninsulated shield ground wire at the end of the cable jacket. Refer to Subject 20-10-15.  
Make sure that the free end of the shield ground wire is pointed rearward, away from the end of the wires.
- (6) Remove the necessary length from the end of each component wire to make the distance from the end of the shield to the end of the wire equal to 1.65 inches ±0.10 inch. Refer to Figure 98.

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448959 S00061545150\_V1

#### LENGTH OF THE COMPONENT WIRES

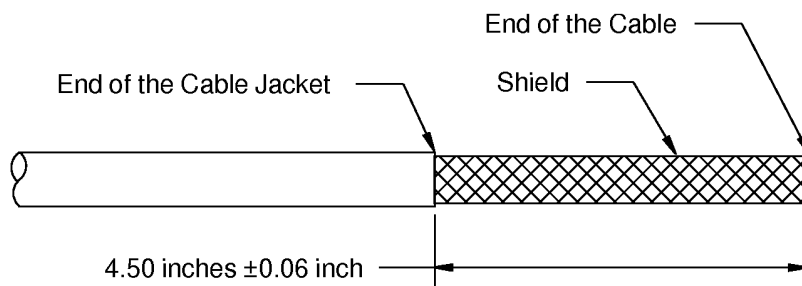
Figure 98

#### B. Assembly of the Glenair 527-530MP29 or 527-108() Backshell - Cable Preparation for a Shield Pull Through Shield Termination

- (1) For a Glenair 527-530MP29 or 527-108() backshell:
  - (a) Make a selection of a Grade B, Class 1 heat shrinkable sleeve from Subject 20-00-11.
  - (b) Put a 4.0 inch length of the heat shrinkable sleeve on each wire harness.
- (2) Remove 4.50 inches  $\pm 0.06$  inch of jacket from the end the cable.

Refer to:

- Figure 99
- Subject 20-00-15 for the procedure to remove the cable jacket.



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#### CABLE JACKET REMOVAL

Figure 99

- (3) Assemble the shield pull through shield ground wire.

Refer to:

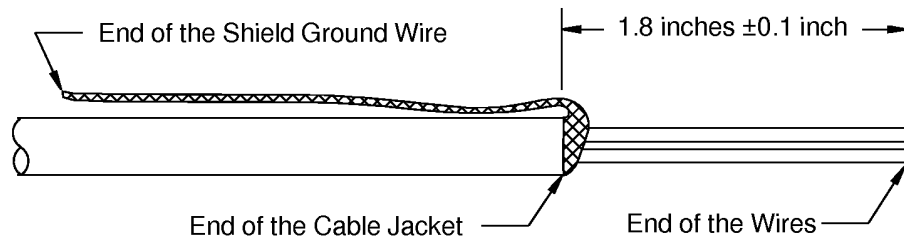
- Figure 100
- Subject 20-10-15 for the procedure to assemble the shield ground wire.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2448961 S00061545152\_V1

#### LENGTH OF THE COMPONENT WIRES

Figure 100

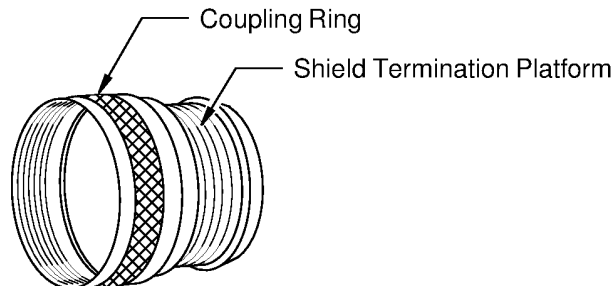
- (4) Remove the necessary length from the end of each component wire to make the distance from the end of the shield to the end of the wire equal to 1.8 inches  $\pm 0.1$  inch. Refer to Figure 100.

#### C. Backshell Assembly

Table 30  
NECESSARY MATERIALS

Material	Part Number	Supplier
Sleeve, Heat Shrinkable	AMS-DTL-23053/12 Class 5	An available source
	RT850	Raychem
	RW175	Raychem
	TFE 4X	Chemplast
		Zeus
Tape, Insulation	Scotch 70	3M

- (1) Make a selection of a BACB42F3 shield terminator band from Table 3 for each endbell that has shielded wires. Refer to Figure 101.



2449727 S00061545162\_V1

#### ENDBELL

Figure 101

- (2) Make a selection of an insulation tape from Table 30.

20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- (3) Make a selection of a heat shrinkable sleeve from Table 30.

**NOTE:** A satisfactory alternative to a heat shrinkable sleeve is a layer of insulation tape.

- (4) Put a 2.0 inch  $\pm$ 0.25 inch length of heat shrinkable sleeve on each group of wires that will terminate in one of the six connector inserts.

Make sure that the sleeve has the smallest diameter that can easily move on the shield termination platform of the endbell after a shield terminator band, and the insulation tape are installed.

**NOTE:** The diameter will be increased by the shield terminator band, and the layers of insulation tape.

- (5) Prepare the ends of the specified shielded cables. Refer to Paragraph 8.A.

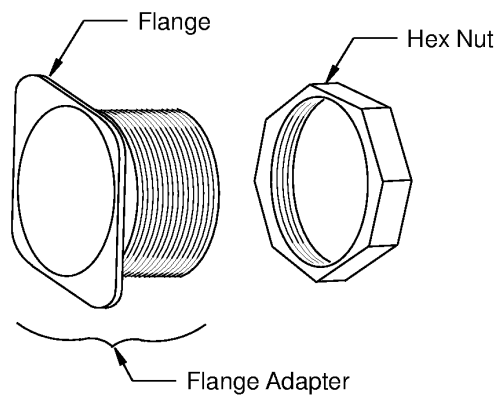
Refer to:

- Paragraph 11.A. for cables that have a solder sleeve shield ground wire
- Paragraph 11.B. for cables that have a shield pull through shield ground wire

- (6) Assemble the contacts on the ends of the wires. Refer to Subject 20-71-14.

- (7) Assemble the backplate of the backshell:

- (a) Engage the threads of one of the six hex nuts with the threads of one of the six flange adapters. Refer to Figure 102 and Figure 103.



2449722 S00061545163\_V1

#### FLANGE ADAPTER AND A HEX NUT

Figure 102

**20-25-14**

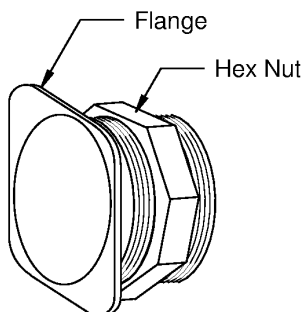




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449723 S00061545164\_V1

#### FLANGE ADAPTER AND HEX NUT ASSEMBLY

Figure 103

- (b) Do Step (a) again for each of the six flange adapters and hex nuts.
- (c) Assemble three of the flange adapter and hex nut assemblies on one of the backshell backplate sections. Refer to Figure 104.

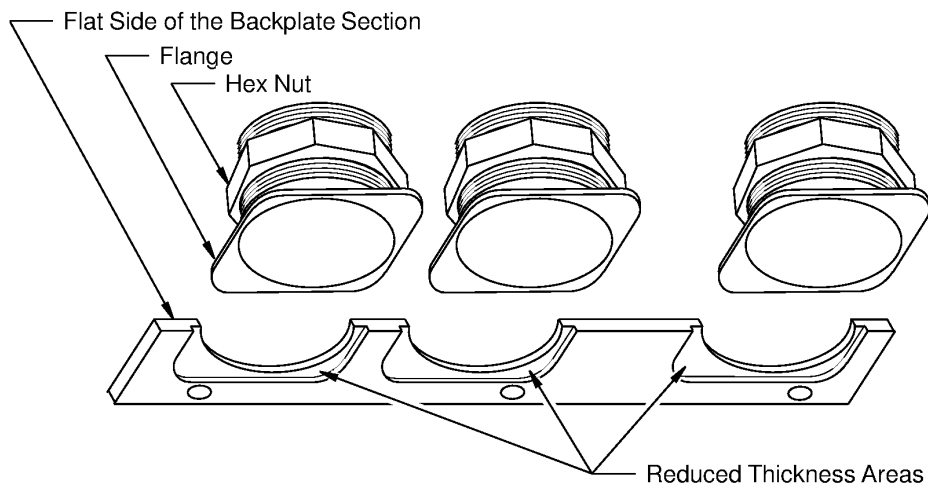
Make sure that:

- The hex nuts are on the flat side of the backplate section
- The flange of the flange adapter is on the side of the backplate section that has reduced thickness areas that have the same shape as the flange.

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449724 S00061545165\_V1

#### ALIGNMENT OF THREE OF THE FLANGE ADAPTERS AND ONE OF THE BACKPLATE SECTIONS

Figure 104

- (d) Tighten each of the three hex nuts with the hand.
- (e) Assemble the remaining three flange adapter assemblies and the three backshell backplate sections. Refer to Figure 105.

Make sure that:

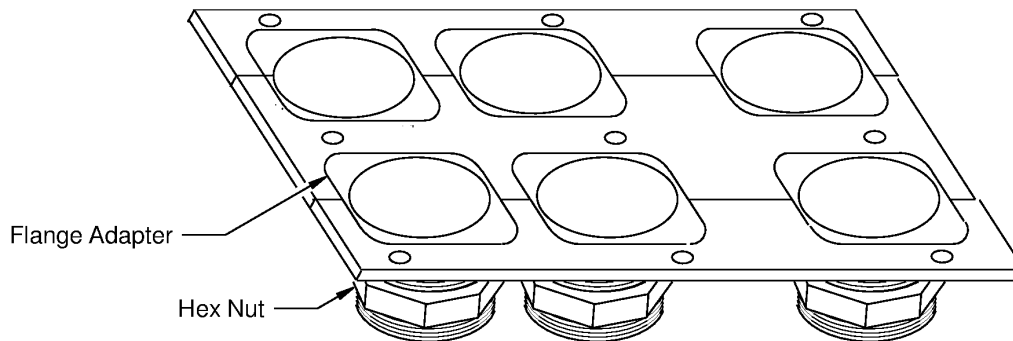
- The hex nuts are on the flat side of the backplate assembly
- The flanges of the flange adapters are on the side of the backplate that has reduced thickness areas that have the same shape as the flange.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

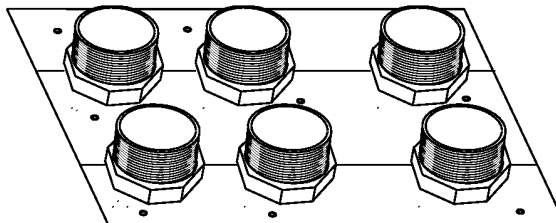


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#### ASSEMBLY OF THE SIX FLANGE ADAPTERS AND THE THREE BACKPLATE SECTIONS

Figure 105

- (f) Hold the three backplate sections together and at the same time, tighten each of the six hex nuts against the backplate assembly 40 inch pounds to 60 inch pounds. Refer to Figure 106.



2449732 S00061545167\_V1

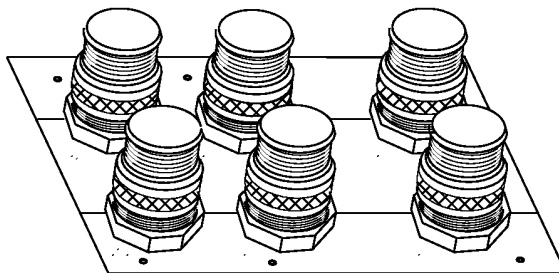
#### FLANGE ADAPTERS AND HEX NUTS INSTALLED ON THE BACKPLATE ASSEMBLY

Figure 106

- (g) Engage the threads an endbell coupling ring with the threads of a flange adapter on the backplate assembly.
- (h) Tighten the endbell coupling ring 40 inch pounds to 60 inch pounds.
- (i) Do Step (g) and (h) again for each of the six endbells. Refer to Figure 107.

**20-25-14**

**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



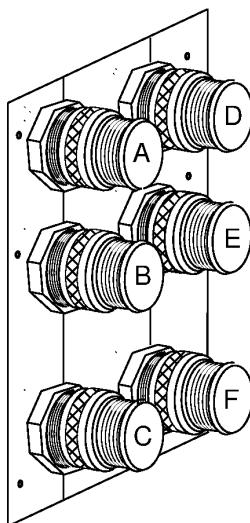
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**ENDBELLS INSTALLED ON THE BACKPLATE ASSEMBLY**

**Figure 107**

- (8) Put the ends of each group of wires that will terminate in one of the six connector inserts through the correct endbell in the assembled backplate. Refer to Figure 108.

Make sure that the termination platforms of the endbells point rearward on the harnesses.



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**ROUTING OF THE WIRE HARNESSES THROUGH THE BACKPLATE**

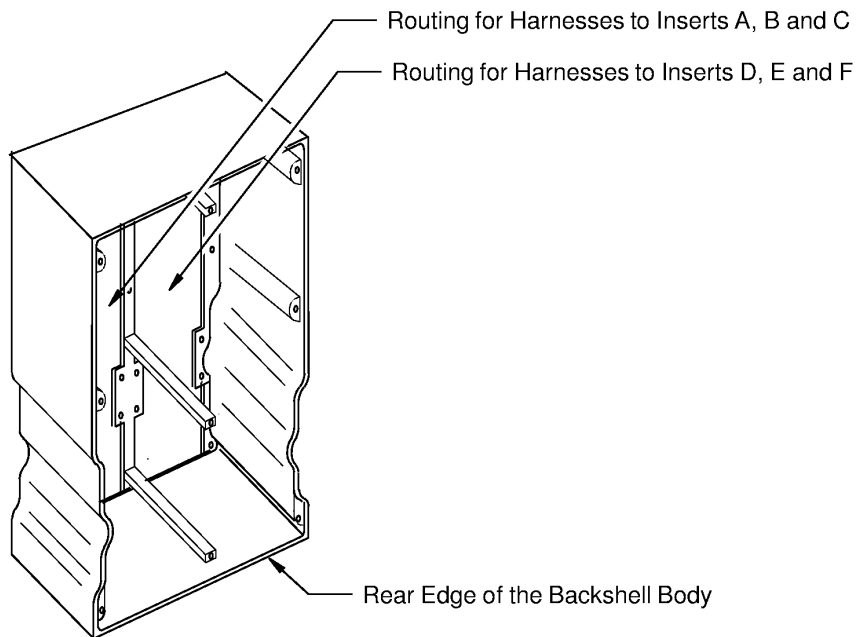
**Figure 108**

- (9) Put the ends of the three groups of wires that will terminate in inserts A, B and C through the correct opening in the backshell body. Refer to Figure 109.

Make sure that the end of the backshell body that has a single opening points rearward on the harnesses.

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449726 S00061545170\_V1

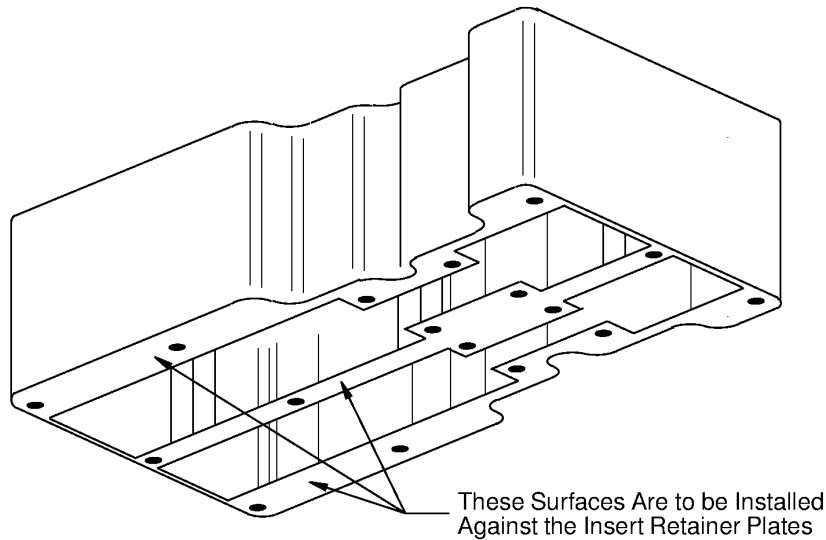
#### ROUTING OF THE HARNESSES THROUGH THE BACKSHELL BODY

Figure 109

- (10) Put the ends of the three groups of wires that will terminate in inserts D, E and F through the correct opening in the backshell body. Refer to Figure 109.  
Make sure that the end of the backshell body that has a single opening points rearward on the harnesses.
- (11) Install the contacts in the connector. Refer to Subject 20-71-14.
- (12) Remove the seventeen screws on the rear of the connector shell that hold the insert retainer plates on the shell.  
**NOTE:** Do not remove the insert retainer plates or the connector inserts.
- (13) Discard the screws.  
**NOTE:** These screws do not have the sufficient length.
- (14) Align the backshell body and the connector shell.  
Make sure that the installation holes of the backshell body align with the connector insert retaining plate screw holes.
- (15) Install the backshell body on the rear of the connector with the screws and lockwashers supplied with the backshell. Refer to Figure 110.  
Make sure that the retainer plates are between the connector shell and the backshell.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2449729 S00061545171\_V1

**BACKSHELL SURFACES ADJACENT TO THE CONNECTOR INSERT RETAINER PLATES**

**Figure 110**

- (a) Align a screw and lockwasher with the applicable backshell installation hole in the backshell.
  - (b) Torque the screw to 3.5 inch pounds to 4.5 inch pounds.
  - (c) Do Step (a) and Step (b) again for each remaining backshell body installation screw.
- (16) Install the backshell backplate assembly on the backshell body. Refer to Figure 111.

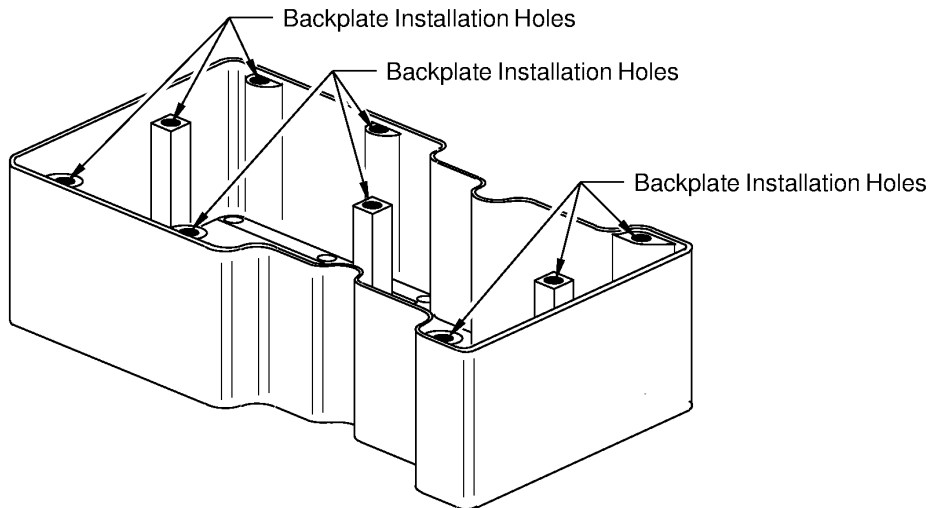
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449730 S00061545172\_V1

#### LOCATION OF THE BACKPLATE INSTALLATION SCREW HOLES

Figure 111

- (a) Align a screw and lockwasher with the applicable backplate installation hole in the backshell body.
- (b) Torque the screw to 3.5 inch pounds to 4.5 inch pounds.
- (c) Do Step (a) and Step (b) again for each remaining backplate installation screw.
- (17) Wind a sufficient number of layers of tape around the wire harness at each backshell wire entrance to increase the harness diameter to the diameter of the endbell wire entrance hole.
- (18) Put the shield ground wires against the endbell around the circumference of the shield termination platform. Refer to Figure 112.

Make sure that:

- The distance between each of the shield ground wires is equal around the shield termination platform
- The shield ground wires do not make an overlap with each other.

**NOTE:** Tape can be used on the connector shell to temporarily hold the shield ground wires in their positions until the band is installed.

**CAUTION:** DO NOT PUT TAPE ON THE BAND TERMINATION PLATFORMS OF THE BACKSHELL.

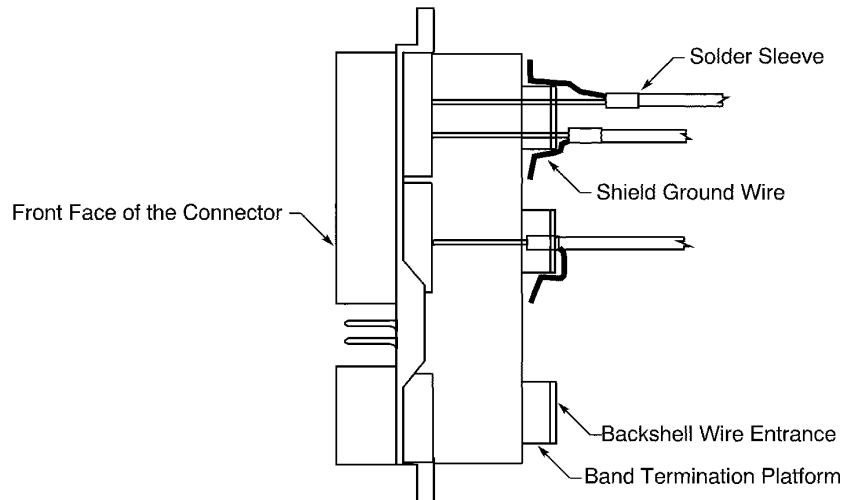
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2447990 S00061545128\_V1

#### CONFIGURATION OF THE SHIELD GROUND WIRES ON THE BAND TERMINATION PLATFORMS OF THE BACKSHELL

Figure 112

- (19) If the wire harness has an overall shield:
  - (a) If the wire harness has a protective sleeve below the overall shield, assemble a wire harness tie on the protective sleeve approximately 2 inches from the rear end of the shield terminations.
  - (b) Pull the end of the overall shield forward on the shield termination platform.
  - (c) If the shield termination platform has shield ground wires on it, put the end of the overall shield braid on the shield ground wires against the band termination platform.
- (20) Install a shield terminator band on the shield termination platform. Refer to Paragraph 15..  
Make sure that no tape is under the shield terminator band.
- (21) Remove the tape used to hold the shield ground wires in their positions.
- (22) Remove the unwanted length of the overall shield. Refer to Figure 113.  
Make sure that the length of the remaining shield braid is 0.10 inch  $\pm$ 0.05 inch.

**20-25-14**

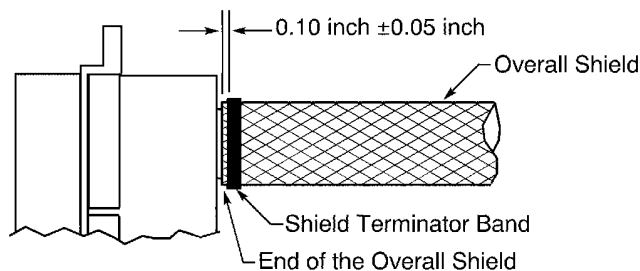




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



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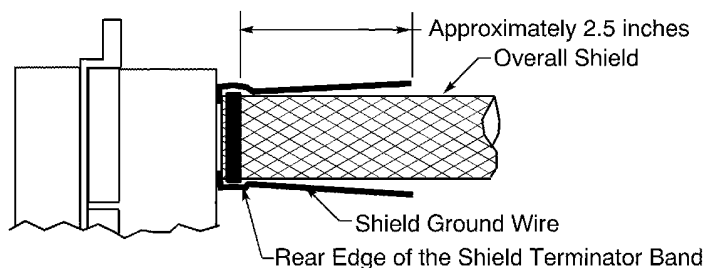
#### POSITION OF THE OVERALL SHIELD

Figure 113

- (23) If the shield termination platform has shield ground wires installed, fold the shield ground wires back on the band and on the wire harness.

- (24) Cut the ends of the shield ground wires. Refer to Figure 114.

Make sure that the remaining length of the shield ground wires is approximately 2.5 inches from the rear edge of the band.



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#### POSITION OF THE SHIELD GROUND WIRES

Figure 114

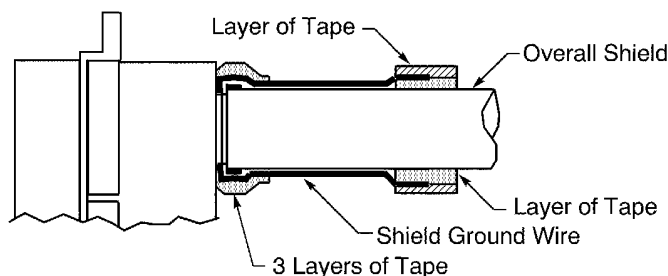
- (25) Wind a sufficient number of layers of insulation tape on the wire harness to hold the ends of the shield ground wires to the harness. Refer to Figure 115.

Make sure that the ends of the shield ground wires are between the layers of tape.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



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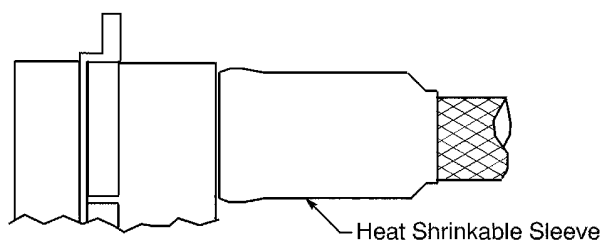
**POSITION OF THE INSULATION TAPE**

**Figure 115**

- (26) Wind a minimum of 3 layers of insulation tape on the shield terminator band. Refer to Figure 115.
- (27) If the wire harness has a protective sleeve on the overall shield:
  - (a) Pull the end of the protective sleeve forward on the band termination platform.
  - (b) Assemble a wire harness tie on the protective sleeve and the band termination platform. Refer to Subject 20-10-11.
- (28) If a length of heat shrinkable sleeve is on the harness:
  - (a) Push the length of heat shrinkable sleeve forward until it is against the rear of the backshell. Make sure that the forward edge of the sleeve is against the rear surface of the backshell.
  - (b) Shrink the sleeve into its position.

Refer to:

- Figure 116 for the location of the sleeve
- Subject 20-10-14 for the procedure to shrink a heat shrinkable sleeve.



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**POSITION OF THE HEAT SHRINKABLE SLEEVE**

**Figure 116**

- (29) If a length of heat shrinkable sleeve is not on the harness, wind another layer of insulation tape on the harness.  
Make sure that:
  - The insulation tape wrap has a 50 percent overlap

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- The insulation tape layers extend a minimum of 0.5 inch farther rearward than the ends of the shield ground wires.

(30) Do Step 11.C.(18) through Step 11.C.(29) again for each endbell.

#### 12. ASSEMBLY OF THE GLENAIR 557-() BACKSHELL

This paragraph gives the procedure to assemble and attach the shield ground wires of these shields to a backshell:

- The shield of a wire or a cable
- The adjacent shields of a wire or a cable.

Refer to Table 31 for the applicable connector part numbers.

##### A. Connector Part Numbers

Table 31  
APPLICABLE M24308 CONNECTOR PART NUMBERS

Part Number	Supplier
DBMA()	ITT Cannon
CAMA()	ITT Cannon
CBMA()	ITT Cannon
CCMA()	ITT Cannon

##### B. Wire Harness Preparation

**NOTE:** If the wire or the cable has two adjacent shields, the shields are prepared as one shield.

- (1) Make a selection of a solder sleeve with an uninsulated integral wire. Refer to Subject 20-10-15.
- (2) If it is necessary, remove the C-clips on the 2 jack screws of the backshell with a C-clip removal tool.
- (3) Remove the 2 jack screws from the backshell.
- (4) Put the jack screws and the C-clips, if any, in a safe place.

The screws and the clips are necessary to attach the backshell to the connector.

- (5) Make a selection of a heat shrinkable sleeve from Table 4.

Make sure that the diameter of the sleeve is greater than the outer diameter of the backshell cable exit.

**NOTE:** For alternative heat shrinkable sleeves, refer to Subject 20-00-11.

- (6) Put an approximate 4 inch length of the heat shrinkable sleeve on the wire harness.
- (7) For each shielded cable in the wire harness, put an uninsulated integral wire of a solder sleeve into the front of the backshell and through the slot in the cable exit.

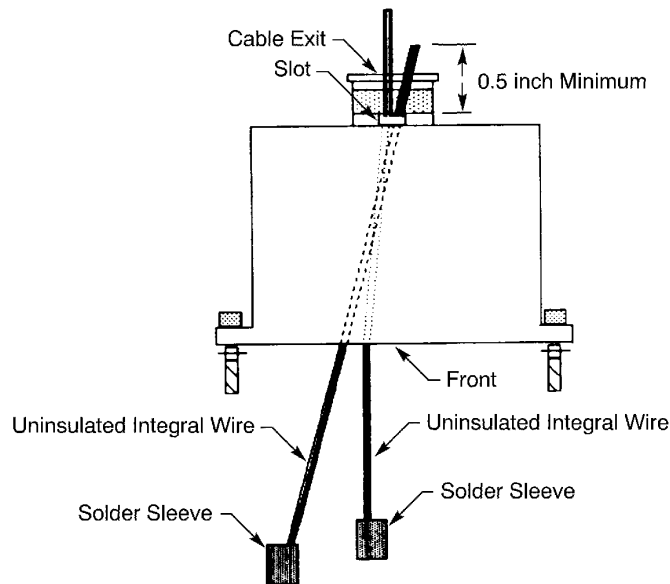
Refer to Figure 117.

Make sure that approximately 0.5 inch of each uninsulated wire extends out of the slot.

20-25-14

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

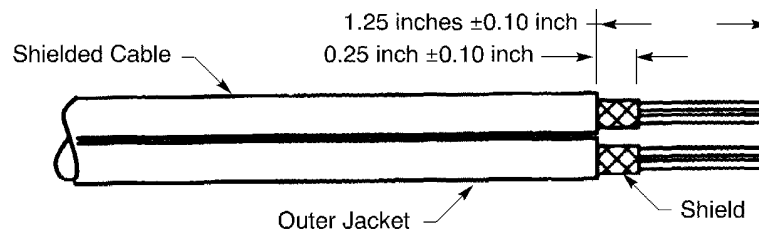


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#### POSITION OF THE UNINSULATED INTEGRAL WIRES

Figure 117

- (8) Put the backshell on the wire harness.  
Make sure that the uninsulated wires stay in the slot in the cable exit.
- (9) Remove 1.25 inches  $\pm 0.10$  inch of the outer jacket from the end one of the shielded cables.
- (10) Remove the necessary length of the shield to make the distance from the end of the shield to the end of the outer jacket equal to 0.25 inch  $\pm 0.10$  inch.  
Refer to Figure 118.



2445774 S00061545174\_V1

#### CABLE PREPARATION

Figure 118

- (11) Put the solder sleeve on the cable. Refer to Figure 119.  
Make sure that:
  - The end of the solder sleeve that has the integral wire is put on the cable first

**20-25-14**

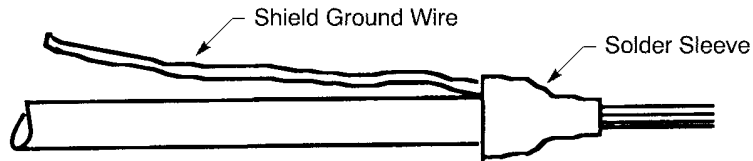


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

- The inner edge of the seal ring is aligned with the end of the outer jacket.



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#### POSITION OF THE SOLDER SLEEVE ON THE CABLE

Figure 119

- (12) Shrink the solder sleeve into position. Refer to Subject 20-10-14.

Make sure that:

- The solder sleeve stays in the correct position
- A minimum of seventy-five percent of the indicator ring on top of the solder ring is melted.

- (13) Do Step 12.B.(9) through Step 12.B.(12) for the remaining shielded cables in the wire harness.

#### C. Connector Assembly

- (1) Assemble the connector. Refer to the applicable Subject for the connector.

#### D. Backshell Installation

- (1) Carefully pull the end of each shield ground wire until the slack in the wires is removed.
- (2) Turn the backshell to the specified clock position for the connector.

Refer to Table 32 and Figure 120.

Table 32  
CLOCK POSITIONS OF THE GLENAIR 557-() BACKSHELL

Backshell	Clock Position (degrees)	Cable Exit
557B()	90	45 Degree
	270	
557E()	90	End
	270	
557S()	0	Side
	180	
557T()	-	Top

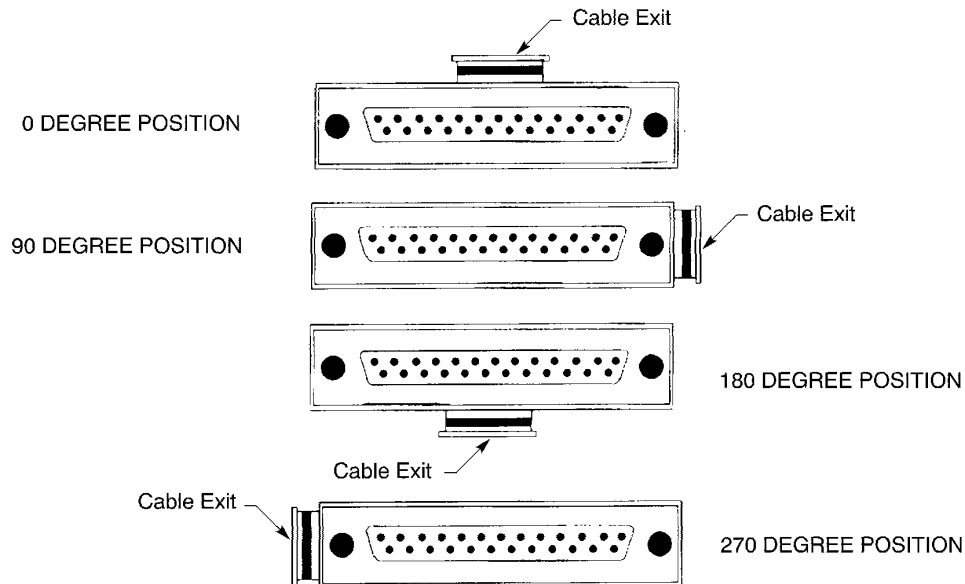
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445776 S00061545176\_V1

#### CLOCK POSITIONS OF THE GLENAIR 557-() BACKSHELL

Figure 120

- (3) At the same time, carefully push the backshell until it is against the rear of the connector and pull the end of shield ground wires away from the backshell.
- (4) Align the screw holes in the backshell with the screw holes in the connector.
- (5) For a backshell with jack screws:
  - (a) Push the jack screws through the screw holes in the backshell and the screw holes in the connector.
  - (b) Install a C-clip on each jack screw where there are no threads.
- (6) For a backshell without jack screws:
  - (a) Put two 0.088 inch 4-40 screws into the two screw holes on the front of the connector.
  - (b) Tighten the screws with a screwdriver.
- (7) Carefully, pull each shield ground wire so that any unwanted length of the wire is removed from the backshell.

Refer to Figure 121.

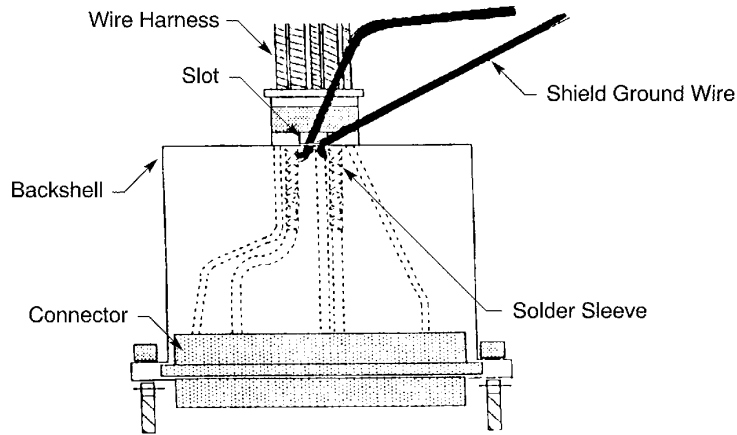
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445777 S00061545177\_V1

#### POSITION OF THE BACKSHELL ON THE CONNECTOR

Figure 121

#### E. Installation of the BACB42F() Shield Terminator Band

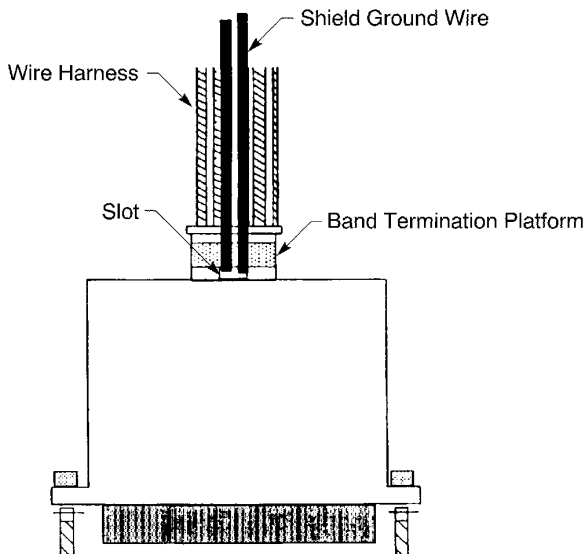
- (1) Put each shield ground wire against band termination platform on the cable exit of the backshell so that the shield ground wires:
  - Are tight, even, and symmetrical around the termination platform
  - Do not make an overlap with another shield ground wire.

Refer to Figure 122.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445778 S00061545178\_V1

**POSITION OF THE SHIELD GROUND WIRES**  
**Figure 122**

- (2) Make a selection of a shield terminator band from Table 3.
- (3) Attach the shield terminator band to the backshell.

Refer to:

- Figure 123 for the location of the installation
- Paragraph 15. for the installation procedure.

Make sure that:

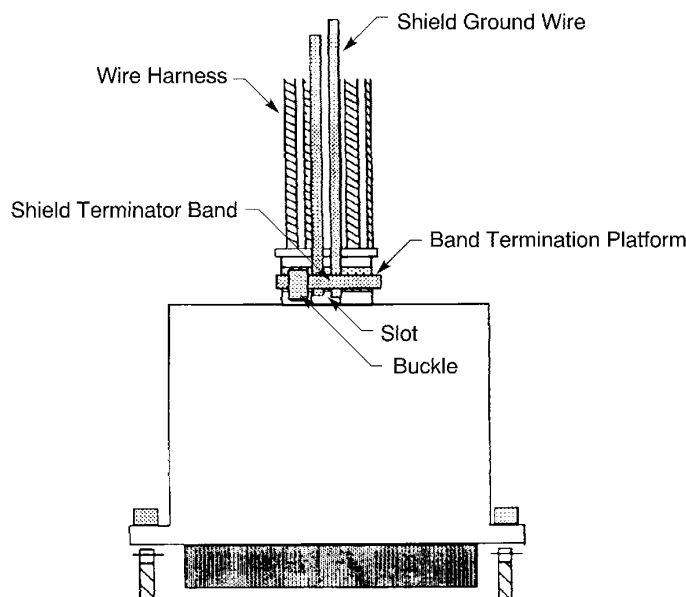
- The band is on the knurled or ribbed area of the band termination platform of the backshell
- There is no unwanted length of shield ground wire between the slot and the shield terminator band
- The buckle of the band is not over a shield ground wire on the backshell
- The buckle of the band is not over a slot in the backshell.

**20-25-14**





**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445779 S00061545179\_V1

**POSITION OF THE SHIELD TERMINATOR BAND ON THE BACKSHELL**

**Figure 123**

**F. Insulation of the Shield Terminator Band**

- (1) Cut each shield ground wire so that the distance from the end of the wire to the shield terminator band is approximately 2.5 inches.
- (2) Make a selection of a 0.19 inch diameter heat shrinkable sleeve from Table 4.  
**NOTE:** For alternative heat shrinkable sleeves, refer to Subject 20-00-11.
- (3) Put a 3.0 inch  $\pm 0.10$  inch length of the heat shrinkable sleeve on each shield ground wire.
- (4) Shrink each sleeve in position. Refer to Subject 20-10-14.
- (5) Align the shield ground wires with the longitudinal axis of the wire harness.  
Make sure that the shield ground wire do not make any overlaps that are not necessary.

**NOTE:** An overlap is acceptable when these conditions occur:

- The diameter of the wire harness is so small that the shield ground wires automatically make an overlap
  - A large number of shield ground wires does not permit them to lie along the wire harness without an overlap.
- (6) Cut a length of Scotch 70 insulation tape that is approximately 2.5 times the distance around the outer surface of the band termination platform.
  - (7) Cut the length of tape again so that the width is 0.25 inch  $\pm 0.03$  inch.
  - (8) Put one end of the tape on the end of the shield terminator band that was cut.
  - (9) Apply the remaining tape around the band until all the tape is on the band.

**20-25-14**

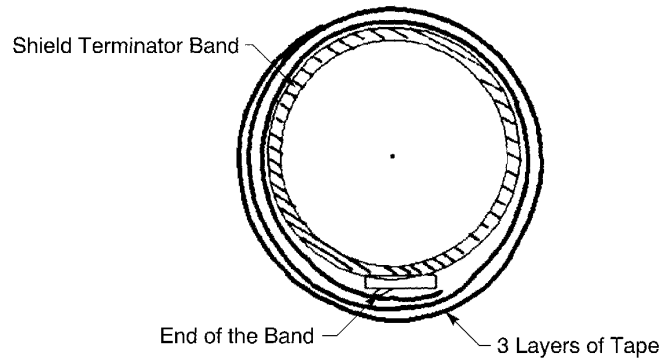


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

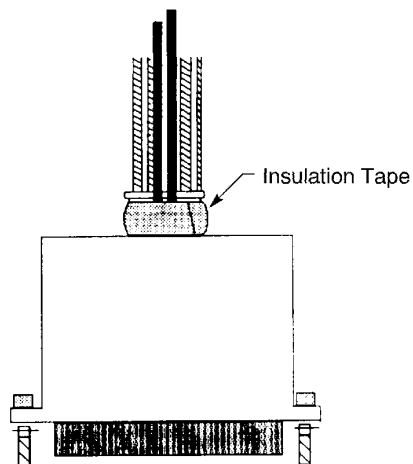
Refer to Figure 124 and Figure 125.



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#### SCOTCH 70 INSULATION TAPE IN POSITION ON THE BAND

Figure 124



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#### POSITION OF THE INSULATION TAPE ON THE BAND TERMINATION PLATFORM

Figure 125

**20-25-14**

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Page 110  
Oct 15/2015

## STANDARD WIRING PRACTICES MANUAL

## ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

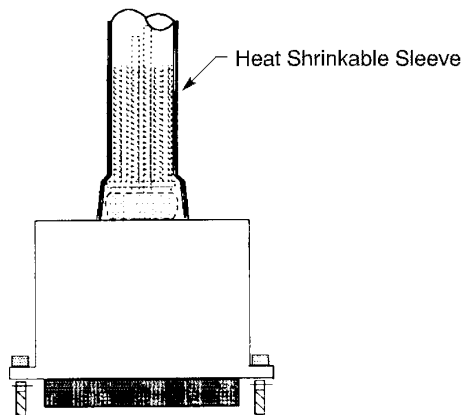
- (10) Push the 4 inch length of the heat shrinkable sleeve until the end of the sleeve is against the rear surface of the backshell.

Make sure that the all the wires that will be subsequently connected with a splice are in the harness.

**NOTE:** If it is necessary to install splice on any of the wires from the connector, put the splice approximately 1 inch from the rear end of the heat shrinkable sleeve.

- (11) Shrink the sleeve in position. Refer to Subject 20-10-14 and Figure 126.

Make sure that the sleeve does not have any cracks.



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## POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE WIRE HARNESS

Figure 126

- (12) If the diameter of the heat shrinkable sleeve does not decrease to the diameter of the wire harness, assemble the necessary number of wire harness ties on the sleeve.  
Refer to Subject 20-10-15 and Subject 20-10-11.
- (13) If the heat shrinkable sleeve is removed from the wire harness, replace the sleeve after the necessary work is done:
- (a) Make a selection of a heat shrinkable sleeve from Table 4.  
Make sure that the diameter of the sleeve is greater than the outer diameter of the backshell cable exit.
- NOTE:** For alternative heat shrinkable sleeves, refer to Subject 20-00-11.
- (b) Cut an approximate 4 inch length of the heat shrinkable sleeve.
  - (c) Cut the sleeve again along the longitudinal axis.
  - (d) Put the sleeve on the cable exit of the backshell and the wire harness.

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Make sure that the longitudinal axis of the sleeve is aligned with the longitudinal axis of the wire harness.

- (e) Assemble the necessary number of wire harness ties on the sleeve to hold it in position. Refer to Subject 20-10-15.

#### 13. ASSEMBLY OF THE GLENAIR 637-221 BACKSHELL AND A SHIELD TERMINATION RING

##### A. Backshell Part Numbers

Table 33  
BACKSHELL PART NUMBERS

Part Number	Shell Size	Cable Exit
637-221M01	15	Straight

##### B. Wiring Assembly Components

Table 34  
WIRING ASSEMBLY COMPONENTS

Component	Type	Part Number or Specification
Tape	PTFE	A-A-59474
	Silicone, Type I	A-A-59163
	Silicone, Type II	A-A-59163
Shield Termination Ring	MIL-C-85049/93-()	Refer to Subject 20-00-11

##### C. Backshell Assembly Preparation

Table 35  
SHIELD SLEEVE LENGTH

Shield Termination Type	Length L(inch)	
	Target	Tolerance
Shield Pull Through	6.25	±0.25
Solder Sleeve	7.50	±0.25

- (1) Cut the necessary length of the shield sleeve. Refer to Table 35.  
Make sure that the ends of the shield sleeve do not have loose fragments of the strands of the shield conductor.
- (2) Put the shield sleeve on the wire harness. Refer to Figure 127.

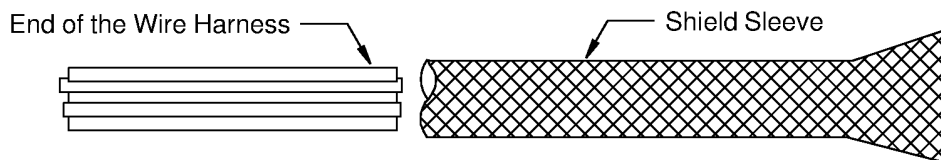
20-25-14



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



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#### POSITION OF THE SHIELD SLEEVE IN RELATION TO THE WIRE HARNESS

Figure 127

- (3) Move the shield sleeve rearward away from the end of the wire harness.
- (4) Prepare the cables for shield termination.

Refer to:

- Paragraph 13.G. for a shield pull through shield termination type
- Paragraph 13.H. for a solder sleeve shield termination type.

#### D. Assembly of the Shield Termination Ring

- (1) Push the shield sleeve forward until the rear end of the shield sleeve is near from the rear end of the backshell.
- (2) Wind a minimum of one layer of Type I silicone tape round the wire harness at the location of the shield termination ring.

Refer to:

- Figure 128 for shield pull through shield ground wires
- Figure 129 for solder sleeve shield ground wires.

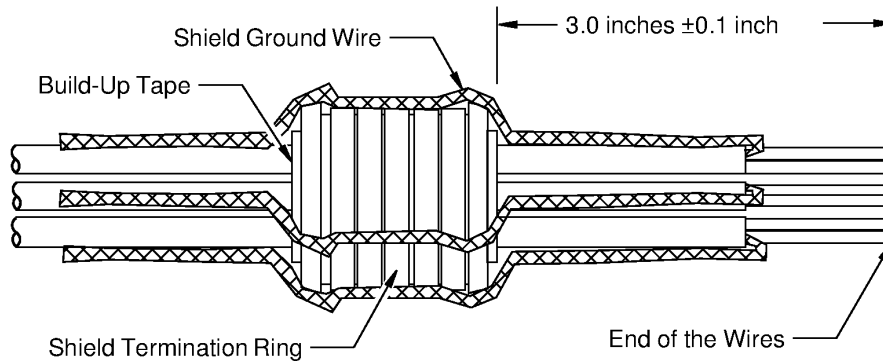
Make sure that:

- The edges of the tape are approximately aligned
- The tape is not on a shield ground wire.

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

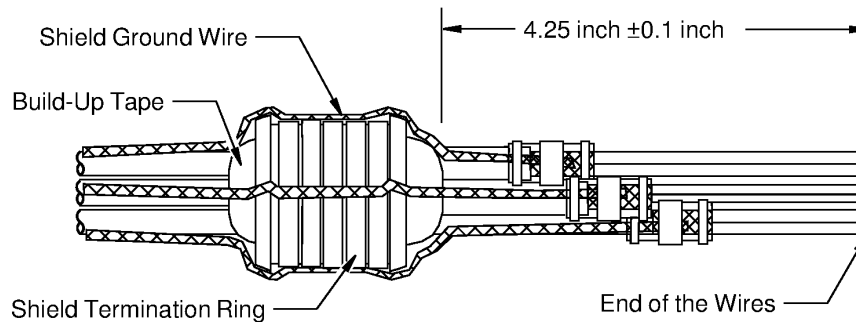
### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449641 S00061545184\_V1

#### SHIELD TERMINATION RING - SHIELD PULL THROUGH SHIELD GROUND WIRES

Figure 128



2449642 S00061545185\_V1

#### SHIELD TERMINATION RING - SOLDER SLEEVE GROUND WIRES

Figure 129

- (3) Assemble the two halves of the shield termination ring on the center of the silicone tape.

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Make sure that:

- A minimum of one side of the shield termination ring has a key and key hole that does not have damage
- The shield ground wires are not between the tape and the shield termination ring
- The keys of one half are aligned with the keyholes of the other half
- The shield termination ring is fully closed
- The shield termination ring does not move on the wire harness.

**NOTE:** The shield termination ring makes a click when it is assembled correctly.

- (4) If the tape does not prevent the movement of the shield termination ring, wind more layers of tape on the harness.

Make sure that:

- The keys of one half are aligned with the keyholes of the other half
- The shield termination ring is fully closed
- The shield termination ring does no move on the wire harness
- The shield ground wires are not between the tape and the shield termination ring.

- (5) Put the shield ground wires on the shield termination ring at approximately equal intervals.

Make sure that the shield ground wires do not go across each other.

- (6) Wind 2 to 4 layers of PTFE tape on the end of the shield ground wires and the wire harness. Refer to Figure 130.

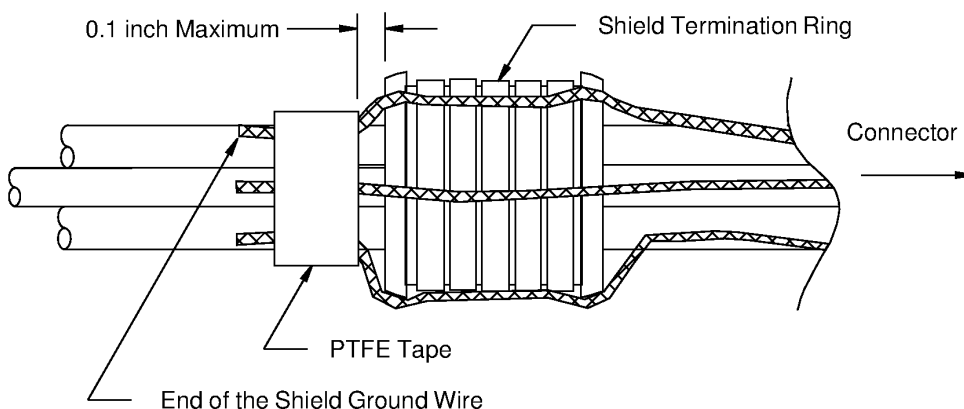
Make sure that:

- The tape does not make an overlap with the shield termination ring
- The layers of tape make an approximately 100 percent overlap
- The shield ground wires are not loose.

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



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#### POSITION OF THE PTFE TAPE ON THE SHIELD GROUND WIRES

Figure 130

- (7) Remove the unwanted length from the end of the shield ground wires Refer to Figure 131.

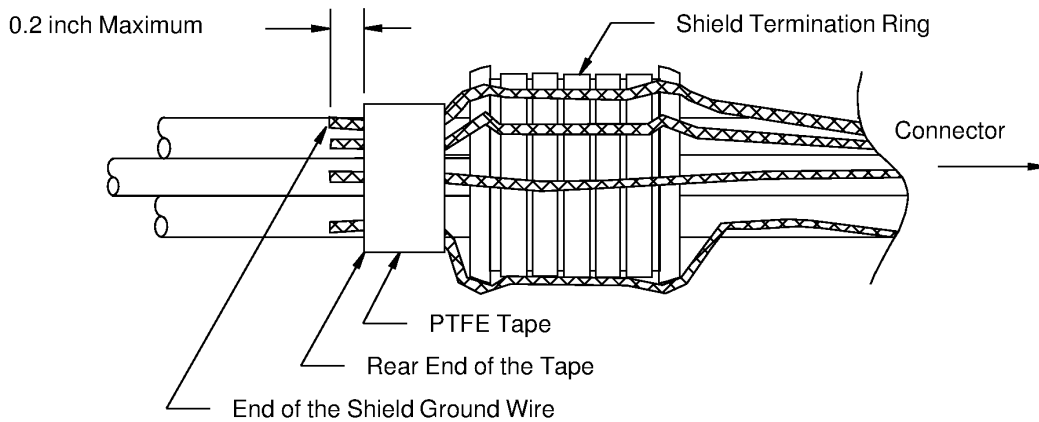
Make sure that:

- The end of the shield ground wire does not extend farther than 0.2 inch from the rear end of the tape
- The shield ground wires are not loose.



## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449644 S00061545187\_V1

#### POSITION OF THE END OF THE SHIELD GROUND WIRES

Figure 131

#### E. Shield Sleeve Termination on a Shield Termination Ring

- (1) Fully extend the rear end of the shield sleeve rearward on the shield termination ring and the wire harness.
- (2) Install a shield terminator band on the shield sleeve at the center of the shield termination ring. Refer to Paragraph 15.A..
- (3) Wind 3 to 4 layers of 0.5 inch wide PTFE tape around the shield terminator band. Refer to Figure 132.

Make sure that:

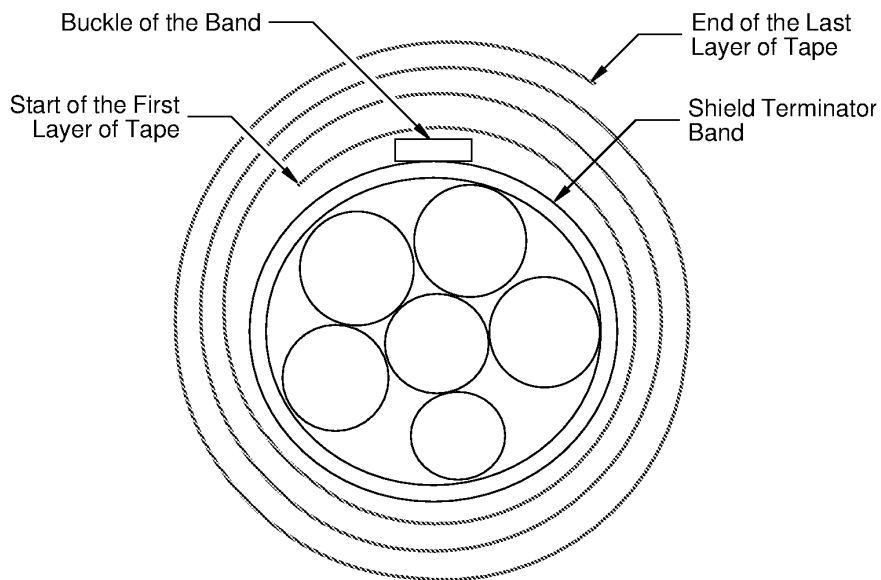
- The center of the tape is aligned with the center of the band
- The first layer of tape starts approximately 0.25 inch from the buckle of the band
- The last layer of tape extends approximately 0.25 inch from the buckle of the band
- The edges of the tape are approximately aligned
- The surface of the band cannot be seen.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449645 S00061545188\_V1

#### POSITION OF THE LAYERS OF THE PTFE TAPE

Figure 132

- (4) Assemble a lacing tape wire harness tie on the end of the shield sleeve to hold it on the wire harness.

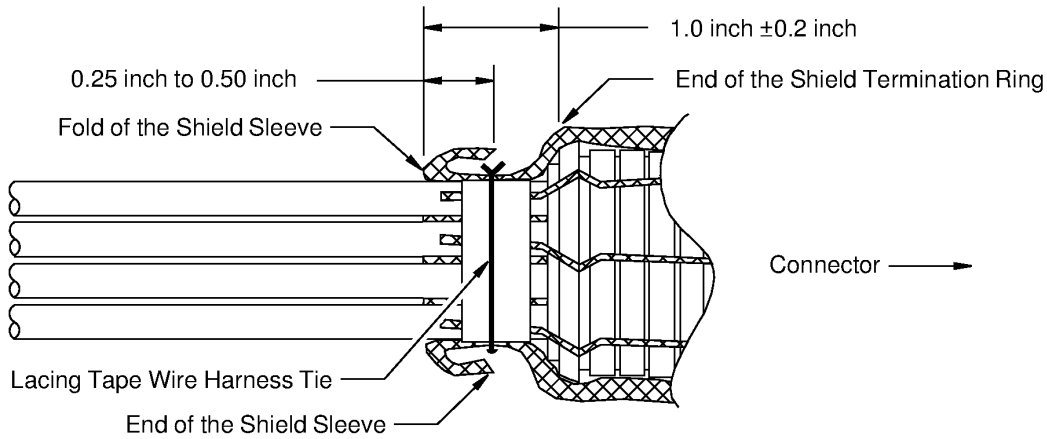
Refer to:

- Figure 133
- Subject 20-10-11 for the procedure to assemble the tie.

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449646 S00061545189\_V1

#### SHIELD SLEEVE TERMINATION

Figure 133

- (5) Fold the free end of the shield sleeve forward toward the end of the shield termination ring.

Make sure that:

- The rear end of the fold of the shield sleeve is not farther than 1.0 inch  $\pm$  0.2 inch from the rear end of the shield termination ring
- The end of the folded shield sleeve is flat against the wire harness or the wire harness and the shield termination ring.

- (6) Wind a layer of Type II silicone tape around the wire harness on the free end of the folded shield sleeve. Refer to Figure 134.

Make sure that:

- The tape extends 0.50 inch  $\pm$  0.25 inch farther than the end of the shield sleeve
- The loose end of the shield sleeve has a layer of tape
- The tape makes approximately a 50 percent overlap with itself
- The tape makes approximately a 100 percent overlap at the end.

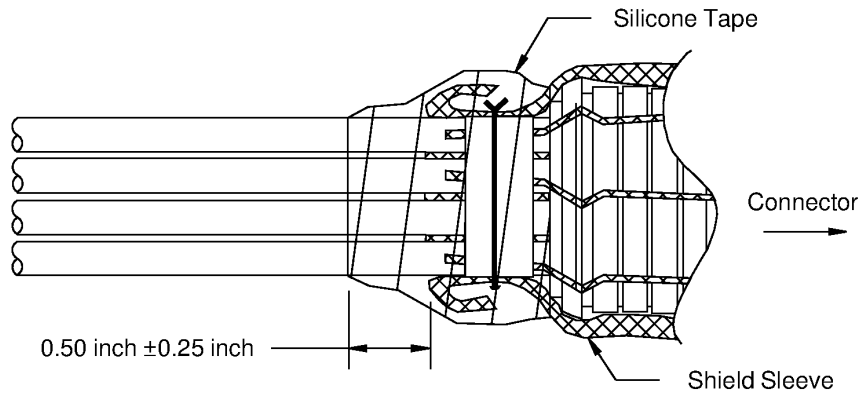
**NOTE:** A continuous layer of Type II silicone tape on the free end of the folded shield sleeve and on the layer of PTFE tape on the shield terminator band is a satisfactory alternative. Refer to Step 7.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

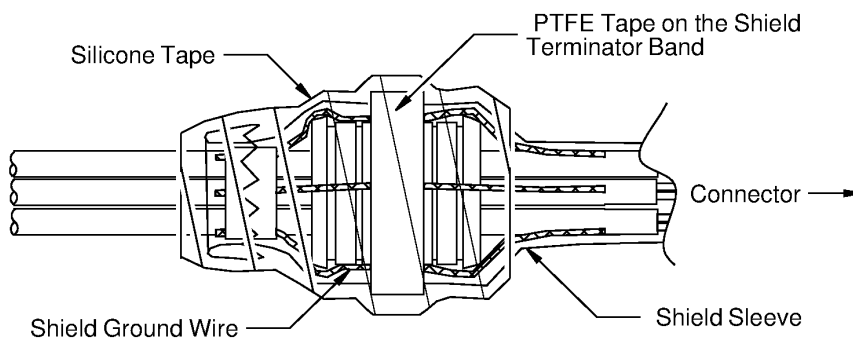


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#### POSITION OF THE SILICONE TAPE ON THE WIRE HARNESS

Figure 134

- (7) Wind 2 to 3 layers of 1 inch wide Type I silicone tape on the PTFE tape that is on the shield terminator band. Refer to Figure 135.



2449648 S00061545191\_V1

#### LAYERS OF TAPE ON THE SHIELD TERMINATOR BAND

Figure 135

**20-25-14**

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### F. Shield Sleeve Termination on a Shield Termination Platform

- (1) Align the rear of the flange of backshell against the rear of the flange of the connector.
- (2) Tie the backshell and the connector together with plastic tie straps.

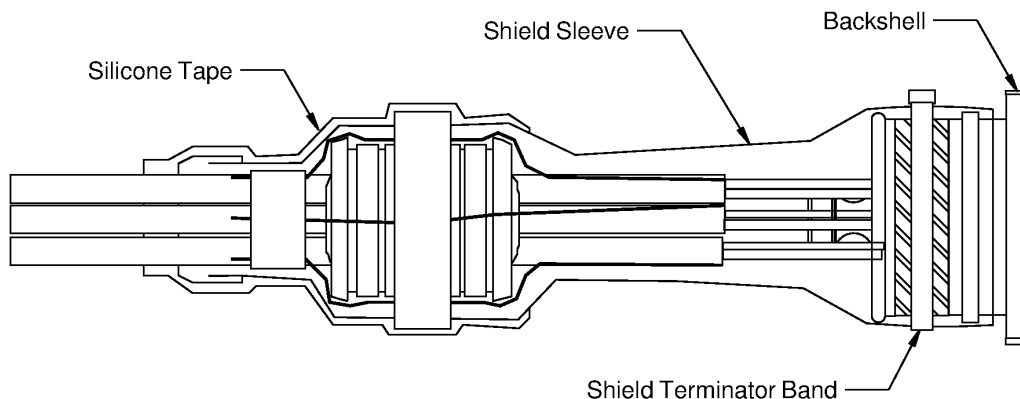
Make sure that:

- A tie is installed in the holes of the flanges in one corner
- A tie is installed in the holes of the flanges in the diagonally opposite corner.

- (3) Align the forward end of the shield sleeve and the shield termination platform.
- (4) Install a shield terminator band on the shield sleeve and the shield termination platform.

Refer to:

- Figure 136
- Paragraph 15.A..



2449649 S00061545192\_V1

#### POSITION OF THE BAND ON THE SHIELD TERMINATION PLATFORM

Figure 136

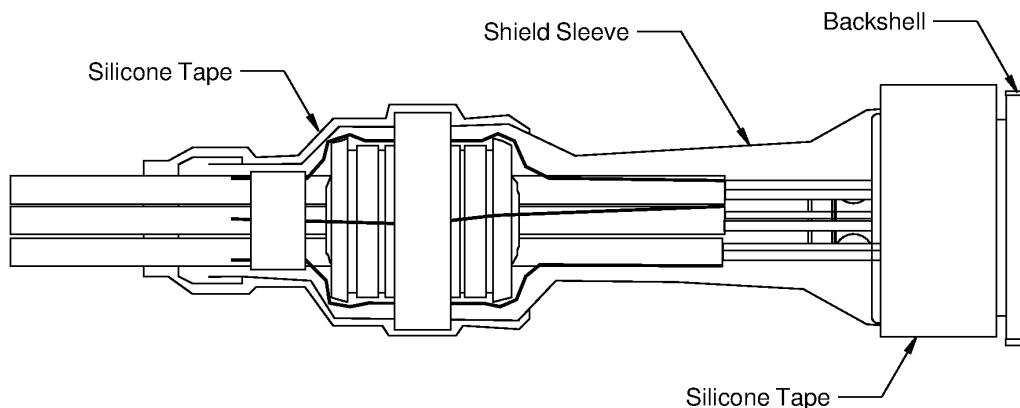
- (5) Wind 2 to 3 layers of PTFE tape on the shield terminator band.

**NOTE:** The tape can be cut longitudinally to decrease the width for a good fit on the termination platform, but the edges of the tape must extend farther than the surfaces of the band.

- (6) Wind 2 to 3 layers of Type I silicone tape on the PTFE tape. Refer to Figure 137.

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



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#### POSITION OF THE SILICONE TAPE ON THE SHIELD TERMINATION PLATFORM

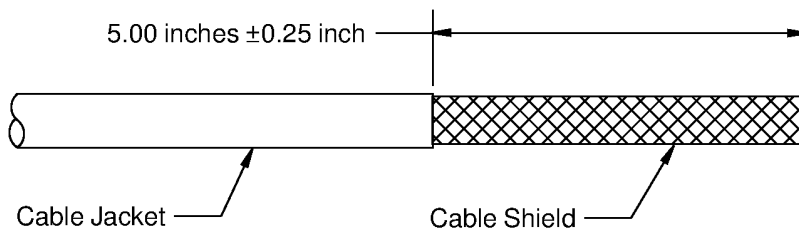
Figure 137

#### G. Cable Preparation - Shield Pull Through Shield Termination

- (1) Remove 5.00 inches  $\pm 0.25$  inch of the jacket from the end of the cable.

Refer to:

- Figure 138
- Subject 20-00-15 for the procedure to remove the cable jacket.



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#### CABLE JACKET REMOVAL

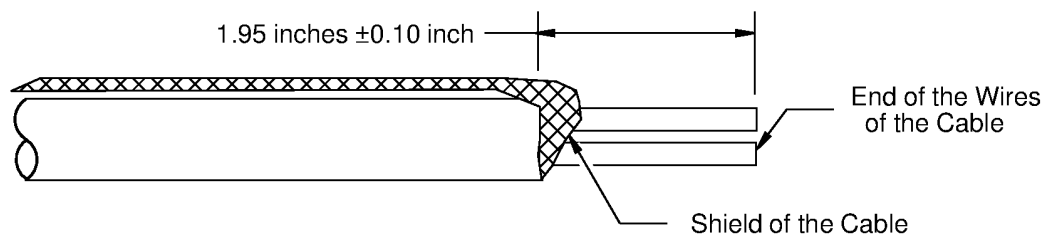
Figure 138

- (2) Assemble the shield pull through shield ground wires. Refer to Subject 20-10-15.
- (3) Remove the necessary length from the end of wires to make the distance from the end of the cable jacket to the end of the wire equal to 1.95 inches  $\pm 0.1$  inch. Refer to Figure 139.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2449652 S00061545195\_V1

**LENGTH OF THE WIRES OF THE CABLE**

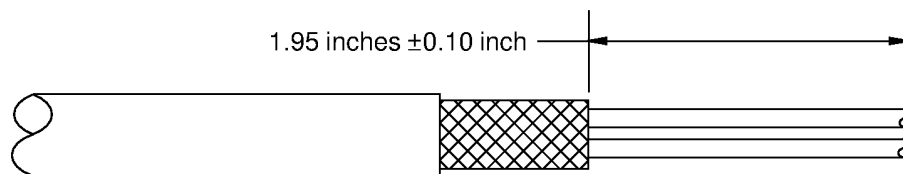
**Figure 139**

**H. Cable Preparation - Solder Sleeve Shield Termination, End Strip Configuration**

- (1) Remove the necessary length of the jacket and the shield from the end of the cable.

Refer to:

- Figure 140 for 3 or less cables
- Figure 141 for 4 or more cables
- Subject 20-00-15 for the procedure to remove the cable jacket.



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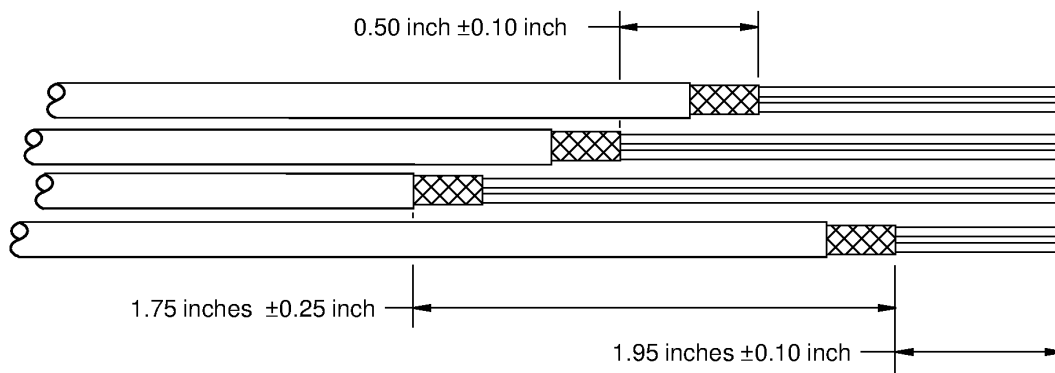
**CABLE PREPARATION FOR 3 OR LESS CABLES**

**Figure 140**

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2449654 S00061545197\_V1

**CABLE PREPARATION FOR 3 OR LESS CABLES**

**Figure 141**

- (2) Assemble the solder sleeve shield ground wires. Refer to Subject 20-10-15.

Make sure that the shield ground wire is pointed away from the end of the wire harness.

**NOTE:** An overlap of solder sleeves is permitted when the wire harness has 3 cables or less

**NOTE:** When the wire harness has 4 or more cables, the solder sleeves must be installed in equal sets  $\pm 1$  solder sleeve at equal distances in a 1.75 inch length area. Refer to Figure 141.

**14. ASSEMBLY OF THE FLIGHT DYNAMICS 6720-0389 BACKSHELL**

**A. Backshell Part Numbers**

**Table 36**  
**BACKSHELL PART NUMBERS**

Description	Applicable Connector	Part Number	Supplier
EMI Backshell and Ground Block	Shell Size 2 ARINC 600 Plug Connector	6720-0389	Flight Dynamics

**20-25-14**





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

#### B. Assembly of the Flight Dynamics 6720-0389 Backshell and Ground Block Contacts

Table 37

PART NUMBERS FOR 6720-0389 BACKSHELL GROUND BLOCK CONTACTS AND CRIMP TOOLS

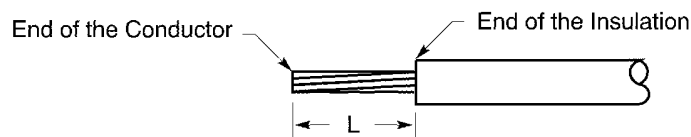
Wire Size	Contact Part Number	Crimp Tool		
		Basic Unit Part Number	Setting	Locator Part Number
24	M39029/22-191	M22520/7-01	3	M22520/7-11
22	M39029/22-191	M22520/7-01	4	M22520/7-11

Table 38

6720-0389 BACKSHELL GROUND BLOCK CONTACT INSERTION AND REMOVAL TOOLS

Description	Part Number	Supplier
Contact Insertion Tool	M81969/14-01	QPL
Contact Removal Tool	M81969/14-01	QPL

- (1) Remove the backshell from the connector.  
Make sure to keep the fasteners for the assembly of the backshell again.
- (2) Use a plastic tie strap to temporarily attach the half of the backshell that has a ground block to the connector.
- (3) Remove 0.17 inch  $\pm$  0.03 inch of insulation from each wire that will be terminated to the backshell ground block. Refer to Figure 142.



2446656 S00061544391\_V1

#### WIRE PREPARATION

Figure 142

- (4) Make a selection of a crimp tool from Table 37.
- (5) Terminate the applicable wires to ground block contacts:
  - (a) Put the end of the wire into the crimp barrel of the contact. Refer to Figure 143.

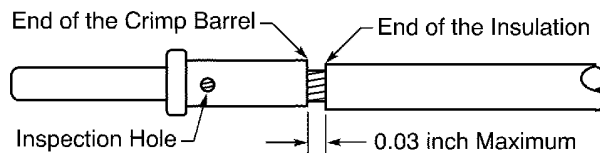
Make sure that:

- All of the strands of the conductor are in the crimp barrel
- The strands of the conductor can be seen in the inspection hole
- The distance from the end of the insulation to the end of the crimp barrel is a maximum of 0.03 inch.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2446855 S00061544427\_V1

**POSITION OF THE WIRE IN THE CRIMP BARREL**

**Figure 143**

- (b) Crimp the contact.
- (c) Examine the contact assembly for these types of damage:
  - Broken strands of the conductor
  - Strands of the conductor on which the base metal can be seen
  - Cracks in the crimp barrel of the contact.
- (d) If the contact or the wire has damage, replace the contact.
- (6) If it is necessary, install or remove contacts in the backshell ground block. Refer to Table 38 for the contact insertion removal tools.
- (7) Assemble the backshell to the connector.  
Make sure to use the original fasteners.
- (8) If the shield terminator bands are not specified, make a selection of three BACB42F3 shield terminator bands from Subject 20-00-11.
- (9) Install the terminator bands on the shields of the cables on the shield termination platforms of the backshell. Refer to Paragraph 15..

**15. INSTALLATION OF THE SHIELD TERMINATOR BAND**

**A. Installation of the Shield Terminator Band**

**Table 39**  
**SHIELD TERMINATOR BAND INSTALLATION TOOLS**

Shield Terminator Band	Installation Tool		
	Type	Part Number	Supplier
BACB42F3()	Manual	600-058	Glenair
		A40199	Band-It Idex
BACB42F4()	Manual	600-061	Glenair
		A30199	Band-It Idex

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

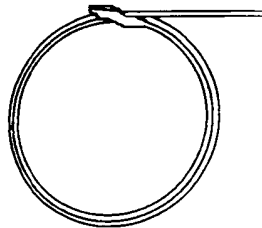
Table 39 SHIELD TERMINATOR BAND INSTALLATION TOOLS (Continued)

Shield Terminator Band	Installation Tool		
	Type	Part Number	Supplier
BACB42F6()	Manual	600-061	Glenair
		A30199	Band-It Idex

**CAUTION:** THE INCORRECT INSTALLATION OF THE SHIELD TERMINATOR BAND, THE SHIELD OF THE CABLE, AND THE SHIELD GROUND WIRE ON THE SHIELD TERMINATION PLATFORM CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

**CAUTION:** IF A SHIELD TERMINATOR BAND HAS BEEN USED, IT MUST NOT BE USED AGAIN. THE INSTALLATION OF A USED BAND CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

- (1) Make a selection of an installation tool from Table 39.
- (2) Clean these components with isopropyl alcohol and a brush:
  - The band
  - The shield of the cable
  - The shield ground wires.
- (3) If the shield terminator band is flat, make the band into a coil around the wire harness. Refer to Figure 144.



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#### INSTALLATION CONFIGURATION OF THE BACB42F() SHIELD TERMINATOR BAND

Figure 144

- (a) Put the free end of the band through the thin slot in the buckle.
  - (b) Pull the free end through the buckle until the diameter of the loop is approximately the same size as the diameter of the backshell.
  - (c) Put the free end of the BACB42F() shield terminator band through the thin slot in the buckle again.
  - (d) Pull the free end through the buckle until the inner surface of the second loop touches the surface of the first loop.
- (4) Pull the release trigger of the tool in the direction of the pull-up handle.
  - (5) Put the free end of the terminator band into the tool. Refer to Figure 145.

**20-25-14**

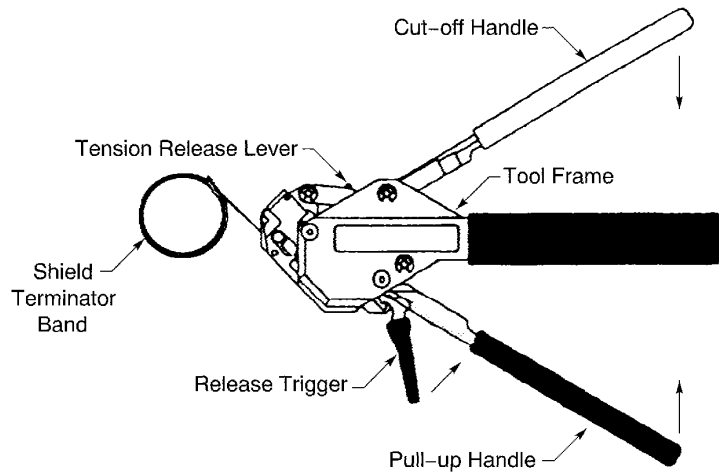


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS

Make sure that the loop is away from the tool.



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#### POSITION OF THE BACB42F() SHIELD TERMINATOR BAND IN THE TOOL

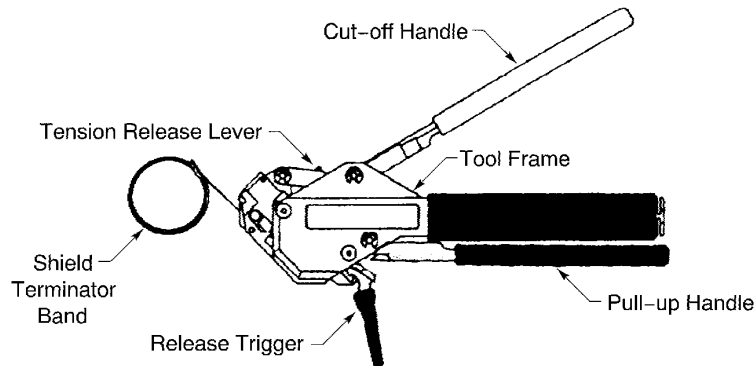
Figure 145

- (6) Pull the pull-up handle toward the tool frame to complete one cycle. Refer to Figure 146. Make sure that the terminator band is held in the internal grip mechanism of the tool.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2445785 S00061544298\_V1

**POSITION OF THE PULL-UP HANDLE AT THE END OF A CYCLE**

**Figure 146**

- (7) Put the shield terminator band on the shield termination platform of the backshell.
  - (8) Align the edges of the two loops of the terminator band. Refer to Figure 147.
- Make sure that the edge of either loop is not more that 0.03 inch beyond the edge of the other.

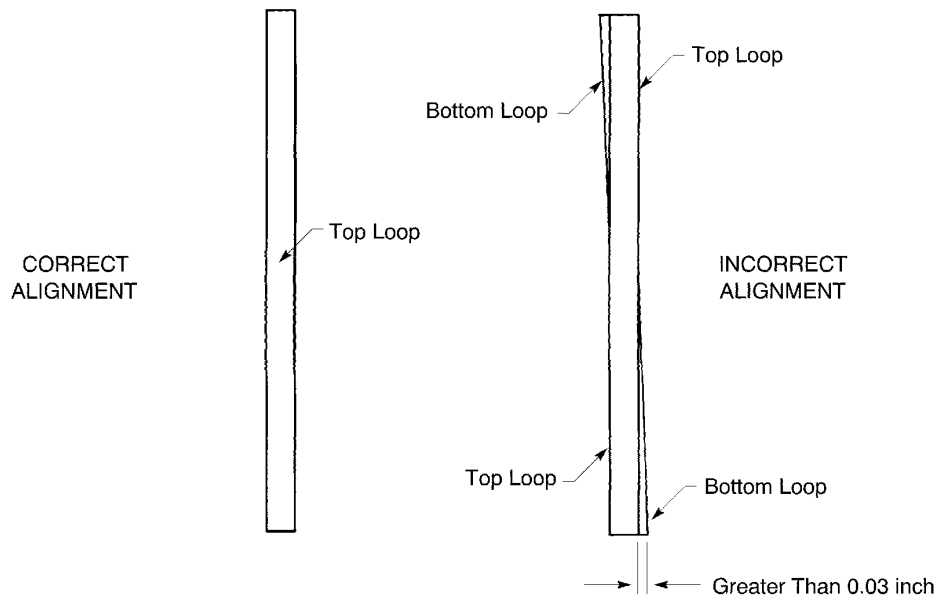
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445786 S00061544299\_V1

#### ALIGNMENT OF THE LOOPS OF THE SHIELD TERMINATOR BAND

Figure 147

- (9) Pull the pull-up handle through the necessary cycles until the terminator band is tight around the backshell.

**NOTE:** Always let the pull-up handle return to the initial open position before the handle is pulled again. If the handle stops in a cycle, push the handle down to the initial open position. Refer to Figure 145.

Make sure that pull-up handle is locked against the tool frame. Refer to Figure 146.

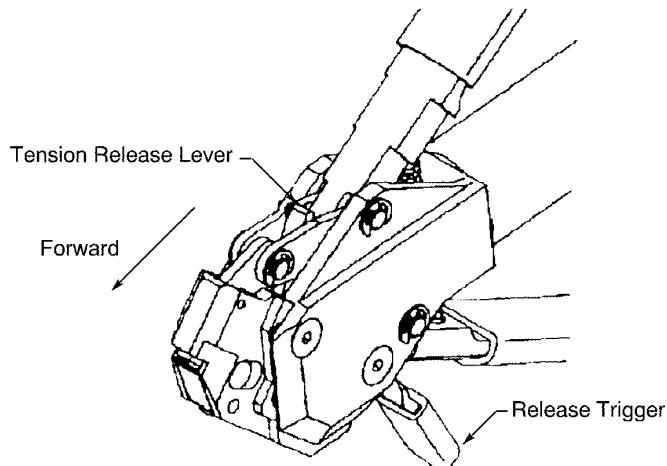
**CAUTION:** DO NOT USE FORCE TO OPEN THE PULL-UP HANDLE AFTER IT IS LOCKED IN POSITION. IF FORCE IS USED, DAMAGE TO THE TOOL OCCURS.

- (10) Examine the alignment of the loops of the band. Refer to Figure 147.  
(11) If the alignment is incorrect, loosen the band, Refer to Figure 148..

**20-25-14**



707, 727-787  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH  
SHIELD TERMINATOR BANDS**



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**OPERATION OF THE TENSION RELEASE LEVER**

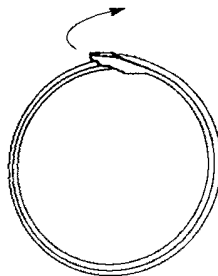
**Figure 148**

- (a) Hold the pull-up handle tightly.
  - (b) Push the tension release lever forward.
  - (c) Release the pull-up handle.  
**NOTE:** The pull-up handle will open automatically.
  - (d) Pull the release trigger toward the tool frame.
  - (e) Loosen the band and do the installation again from Step 15.A.(4).
  - (f) If it is necessary, remove the band and do the installation again from Step 15.A.(4).
- (12) Pull the cut-off handle toward the tool frame until it is against the tool frame..
  - (13) Pull the release trigger in the direction of the pull-up handle to cut the unwanted length of the band.
  - (14) Remove the unwanted length of the band from the tool.
  - (15) If the installation of the shield terminator band is incorrect, remove the band. Refer to Figure 149.

**20-25-14**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH**  
**SHIELD TERMINATOR BANDS**



2446899 S00061544306\_V1

**REMOVAL OF THE SHIELD TERMINATOR BAND**

**Figure 149**

- (a) Hold the end of the band at the buckle with pliers or wire cutters.
- (b) Bend the buckle back in the direction of the top loop of the coil until the loop is released.
- (c) Discard the used band.
- (d) Do the installation again from Step 15.A.(3) with an unused band.

**B. Installation of the Shield Terminator Band - Pneumatic Tool**

**Table 40**  
**SHIELD TERMINATOR BAND INSTALLATION TOOLS**

Shield Terminator Band	Installation Tool	Type	Supplier
BACB42F3	600-051	Pneumatic	Glenair
	601-104	Pneumatic	Glenair
	A35199	Pneumatic	Band-It Idex
	A75099	Pneumatic	Band-It Idex
BACB42F4	A35599	Pneumatic	Band-It Idex
	601-105	Pneumatic	Glenair
BACB42F6	601-105	Pneumatic	Glenair

- (1) Make a selection of an installation tool from Table 40.
- (2) Wind the band into a circular shape around the location of the termination. Refer to Figure 150.

**20-25-14**

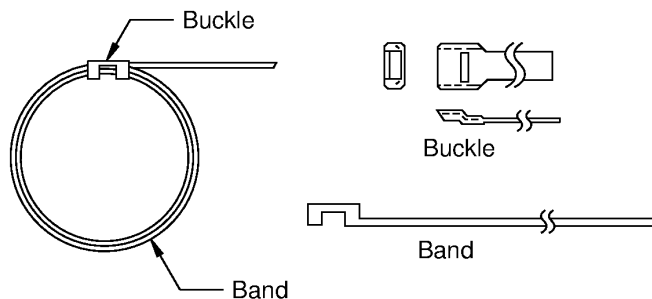




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



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#### SHIELD TERMINATOR BAND

Figure 150

- (a) Put the free end of the band through the thin slot in the buckle.
  - (b) Pull the free end until the diameter of the loop is approximately the same size as the diameter of the termination area.
  - (c) Put the free end of the shield terminator band through the thin slot in the buckle again.
  - (d) Pull the free end until the inner surface of the second loop is against the surface of the first loop.
- (3) Put the shield terminator band in the installation tool. Refer to Figure 151.

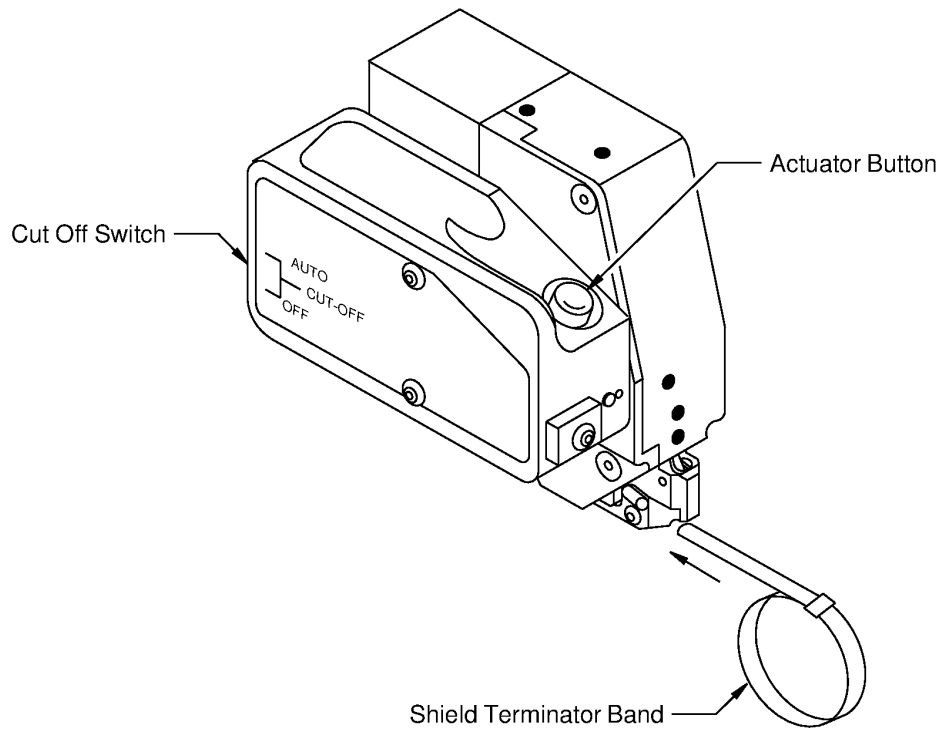
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2449770 S00061545199\_V1

#### ALIGNMENT OF THE SHIELD TERMINATION BAND AND THE PNEUMATIC SHIELD TERMINATION BAND INSTALLATION TOOL

Figure 151

- (4) Push and hold down the actuator button until the band is cut.

Make sure that:

- The cut-off switch is in the auto position
- The edge of a loop is not more than 0.03 inch farther than the edge of the other loop; refer to Figure 152.

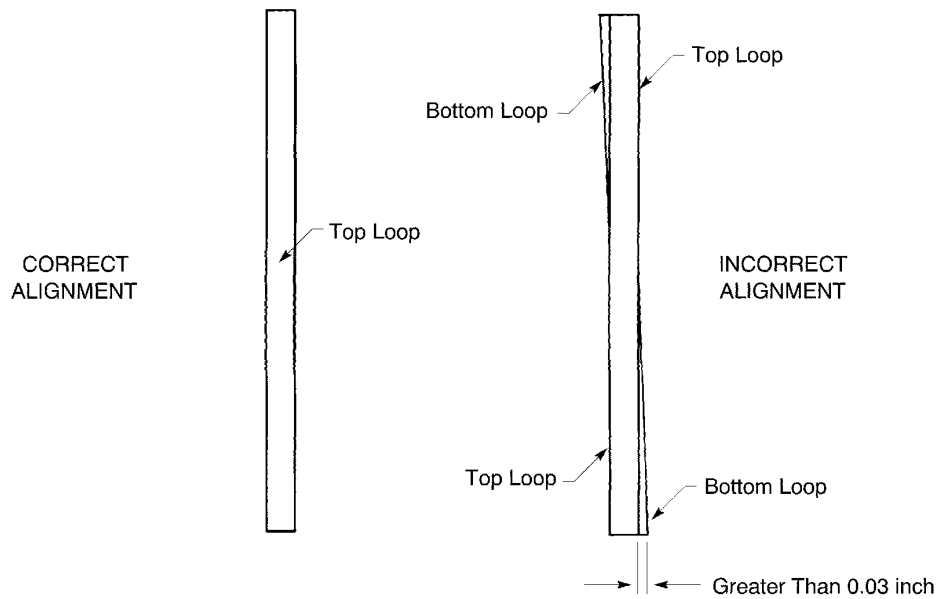
**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ELECTRICAL CONNECTION OF SHIELDED CABLES AND CONNECTOR BACKSHELLS WITH SHIELD TERMINATOR BANDS



2445786 S00061544299\_V1

#### ALIGNMENT OF THE LOOPS OF THE SHIELD TERMINATOR BAND

Figure 152

- (5) Remove the unwanted length of the band from the tool.

**20-25-14**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
<b>1. <u>PART NUMBERS AND DESCRIPTION</u></b>	<b>3</b>
A. Backshell Description	3
B. Backshell Part Numbers	4
C. Shield Termination Ring Part Numbers	7
D. Spacer Part Numbers	8
E. Heat Shrinkable Boot Part Numbers	8
<b>2. <u>NECESSARY TOOLS</u></b>	<b>11</b>
A. Necessary Tools	11
<b>3. <u>BACKSHELL DISASSEMBLY</u></b>	<b>21</b>
A. Backshell Disassembly	21
<b>4. <u>CABLE PREPARATION PROCEDURES AND BACKSHELL ASSEMBLY</u></b>	<b>25</b>
A. Necessary Materials	25
B. Backshell Assembly Preparation	26
C. Selection of a Cable Preparation Procedure	28
D. Cable Preparation Dimensions	30
E. Solder Sleeve Shield Termination - Standard Configuration	31
F. Solder Sleeve Shield Termination - Standard Configuration, Tensolite CAN22TT120-260 Cable	33
G. Solder Sleeve Shield Termination - End Strip Configuration	36
H. Solder Sleeve Shield Termination - End Strip Configuration, Thermax 975-295 Cable	38
I. Shield Pull Through Shield Termination	40
J. Isolated Shields - Outer Shield Standard Shield Pull Through, Inner Shield Standard Shield Pull Through Shield Termination	42
K. Isolated Shields - Outer Shield End Strip Shield Pull Through, Inner Shield Standard or End Strip Shield Pull Through Shield Terminations	43
L. Isolated Shields - Outer Shield Standard Shield Pull Through, Inner Shield Standard Solder Sleeve Shield Terminations	45
M. Isolated Shields - Outer Shield End Strip Shield Pull Through, Inner Shield Solder Sleeve Shield Terminations	48
N. Isolated Shields - Outer Shield Standard or End Strip Shield Pull Through, Inner Shield Standard or End Strip Shield Dead End Shield Terminations	50
O. Isolated Shields - Outer Shield End Strip Solder Sleeve, Inner Shield Standard Solder Sleeve Shield Terminations	53
P. Isolated Shields - Outer Shield End Strip Solder Sleeve, Inner Shield End Strip Solder Sleeve Shield Termination	55
Q. Isolated Shields - Outer Shield End Strip Solder Sleeve, Inner Shield Standard Shield Dead End Shield Terminations	56
R. Assembly of a Backshell that has a Strain Relief Clamp	58
S. Wire Harness Preparation for the Assembly of a Backshell That Has a Strain Relief Boot	63

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

<u>PARAGRAPH</u>		<u>PAGE</u>
4.	<b><u>CABLE PREPARATION PROCEDURES AND BACKSHELL ASSEMBLY (continued)</u></b>	<b>25</b>
	T. Assembly of the Shield Termination Ring	64
	U. Shield Sock Termination for a Backshell with a Strain Relief Clamp	74
	V. Shield Sock Termination for a Backshell with a Strain Relief Boot	81
	W. Installation of a Heat Shrinkable Strain Relief Boot	84
5.	<b><u>BACKSHELL INSTALLATION</u></b>	<b>89</b>
	A. Backshell Installation with a Connector Adapter	89
	B. Backshell Installation with a Mating Connector	93
	C. Assembly of the Strain Relief Cable Clamp on a Backshell that does not have a Braided Shield Sock	94

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

This Subject gives the procedures to assemble composite strain relief backshells that have a hex coupling nut. These backshells have, or do not have a braided shield sock.

For the procedures to assemble other strain relief backshells:

Refer to: Subject 20-60-09 for:

- The assembly of a non-hex coupling nut backshell that does not terminate a shield
- The assembly of the cable clamp on a backshell that does not have a braided shield sock

Refer to:

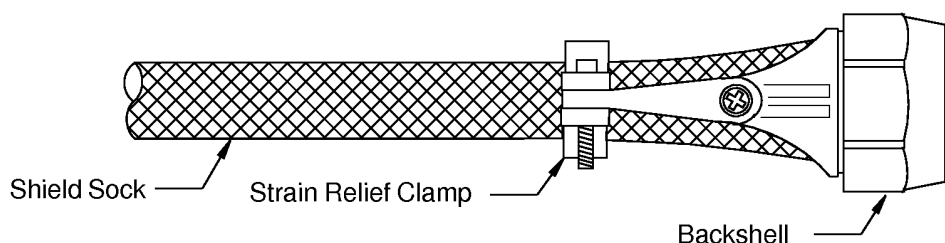
- Subject 20-25-12 for the assembly of a backshell that terminates a shield with shield ground wires and terminal lugs
- Subject 20-25-13 for the assembly of a backshell that terminates a shield with inner and outer ground rings
- Subject 20-25-14 for the assembly of a backshell that terminates shields with a shield terminator band.

#### 1. PART NUMBERS AND DESCRIPTION

##### A. Backshell Description

These backshells have these technical features:

- Have a light weight composite body that has a nickel or cadmium finish
- Are available with an adjustable swing arm and saddle clamp to provide strain relief
- Are available without an adjustable swing arm and saddle clamp to provide strain relief with a heat shrinkable boot
- The termination of the shield sock provides the shield termination and the EMI protection
- Have a hex shape, composite, self-locking coupling ring that must be tightened using special tools.



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#### BACKSHELL THAT HAS A SHIELD SOCK AND A STRAIN RELIEF CLAMP THAT HAS AN ADJUSTABLE SWING ARM

Figure 1

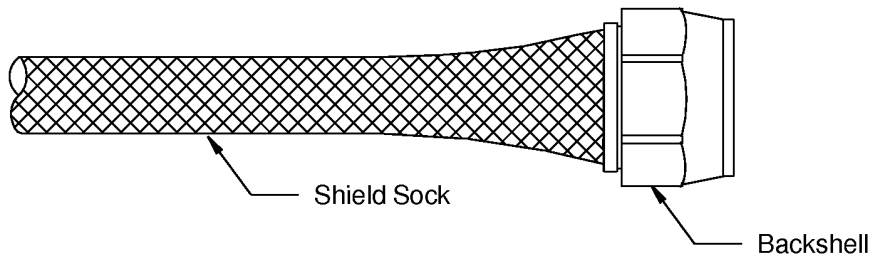
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448583 S00061545202\_V1

#### BACKSHELL THAT HAS A SHIELD SOCK THAT WILL USE A HEAT SHRINKABLE BOOT FOR STRAIN RELIEF

Figure 2

#### B. Backshell Part Numbers

Table 1  
BACKSHELL PART NUMBERS

Part Number	Material	Coupling Ring	Cable Exit	Strain Relief	Supplier	Reference
319AS110BM	Composite	Hex	90 Degree	90 Degree Boot	Glenair	Figure 5
	Composite	Hex	Straight	Straight Boot	Glenair	Figure 5
319F064XO	Composite	Hex	0-45-90 Degree	Cable Clamp	Glenair	Figure 4
319HS110BM	Composite	Hex	Straight	90 Degree Boot	Glenair	Figure 5
447HA557	Composite	Hex	90 Degree	Cable Clamp	Glenair	Figure 6
BACC10MA	Composite	Hex	0-45-90 Degree	Cable Clamp	Glenair	Figure 3
BACC10MB	Composite	Hex	0-45-90 Degree	Cable Clamp	Glenair	Figure 3
BACC10MK	Composite	Hex	0-45-90 Degree No Shield Sock	Cable Clamp	Glenair	Refer to Subject 20-60-09
BACC10MM	Composite	Hex	0-45-90 Degree	Cable Clamp	Glenair	Figure 3
BACC10MP	Composite	Hex	0-45-90 Degree	Cable Clamp	Glenair	Figure 3
BACC10NC	Composite	Hex	0-45-90 Degree No Shield Sock	Cable Clamp	Glenair	Refer to Subject 20-60-09

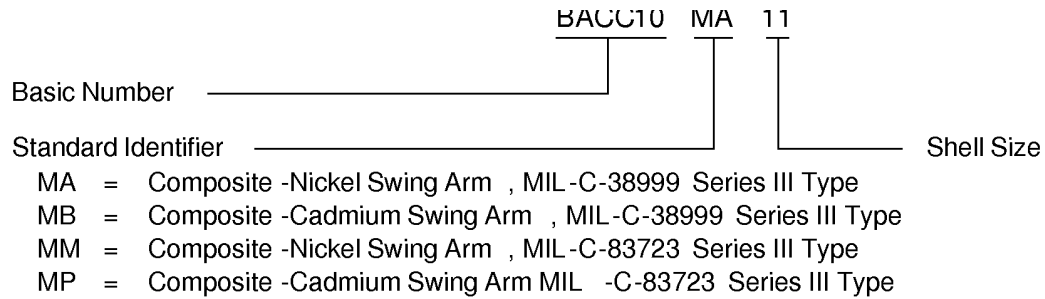
20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

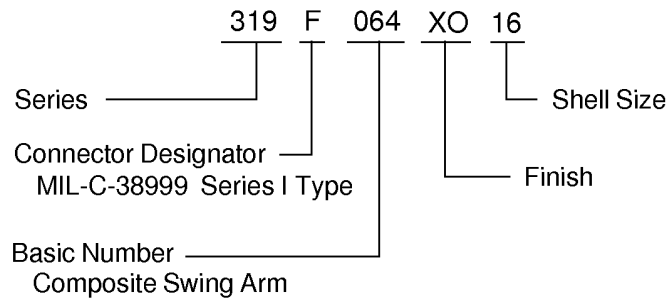
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2450284 S00061545203\_V1

### BACC10MA, BACC10MB, BACC10MM AND BACC10MP SWING ARM BACKSHELL PART NUMBER STRUCTURE

Figure 3



2448428 S00061545204\_V1

### GLENAIR 319()064 SWING ARM BACKSHELL PART NUMBER STRUCTURE

Figure 4

20-25-15

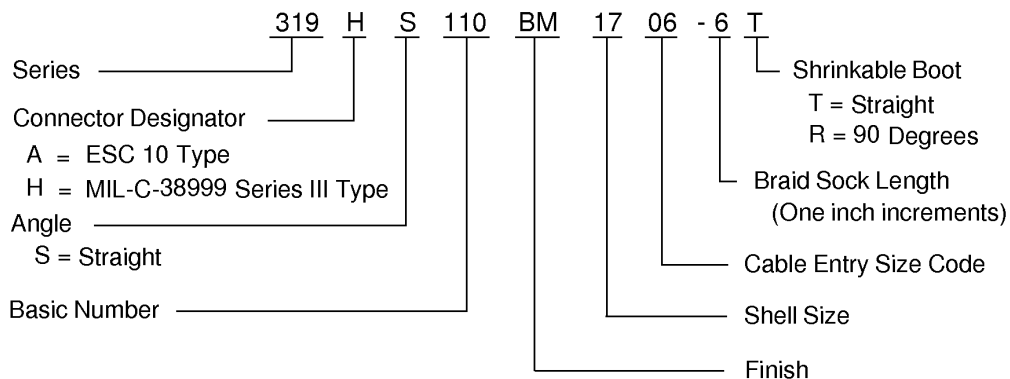




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

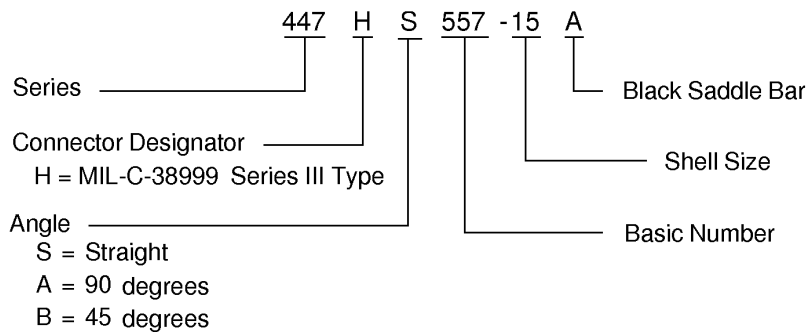
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448429 S00061545205\_V1

#### GLENAIR 319(110) BACKSHELL PART NUMBER STRUCTURE

Figure 5



2448430 S00061545206\_V1

#### GLENAIR 447(557) BACKSHELL PART NUMBER STRUCTURE

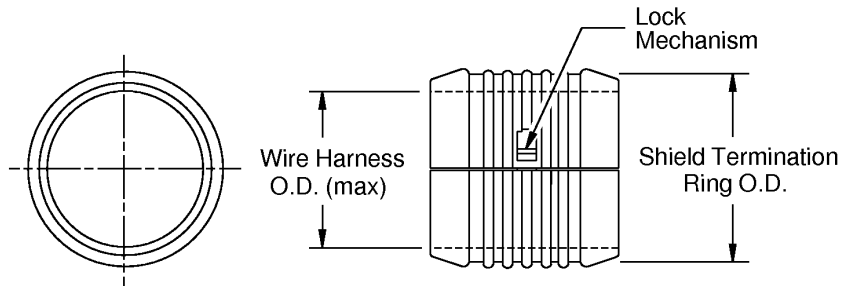
Figure 6

20-25-15

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### C. Shield Termination Ring Part Numbers



2448487 S00061543064\_V1

#### MIL-C-85049/93-( ) SHIELD TERMINATION RING

Figure 7

Table 2

SHIELD TERMINATION RING PART NUMBERS AND SIZES

Part Number	Maximum Wire Harness O.D. (inch)	Shield Termination Ring O.D. (inch)	Supplier
M85049/93-04	.25	.36	Refer to Subject 20-00-11
M85049/93-06	.38	.49	Refer to Subject 20-00-11
M85049/93-08	.50	.61	Refer to Subject 20-00-11
M85049/93-10	.63	.74	Refer to Subject 20-00-11
M85049/93-12	.75	.86	Refer to Subject 20-00-11
M85049/93-14	.88	.99	Refer to Subject 20-00-11
M85049/93-16	1.00	1.10	Refer to Subject 20-00-11
M85049/93-18	1.13	1.24	Refer to Subject 20-00-11
M85049/93-20	1.25	1.36	Refer to Subject 20-00-11
M85049/93-22	1.38	1.49	Refer to Subject 20-00-11
M85049/93-24	1.50	1.61	Refer to Subject 20-00-11
M85049/93-26	1.63	1.74	Refer to Subject 20-00-11
M85049/93-28	1.75	1.86	Refer to Subject 20-00-11



707, 727-787

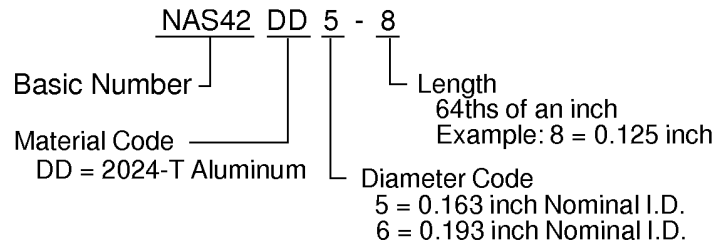
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### D. Spacer Part Numbers

Table 3  
SPACER PART NUMBERS

Component	Type	Part Number	Supplier	Reference
Spacer	Size 4 Saddle Clamp Screw	NAS42DD5-()	QPL	Figure 8
	Size 6 Saddle Clamp Screw	NAS42DD6-()	QPL	Figure 8

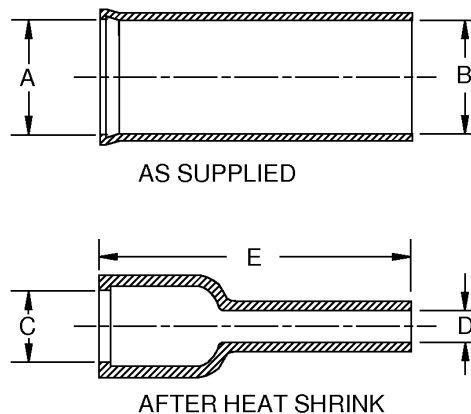


2448431 S00061545207\_V1

#### NAS42 SPACER PART NUMBER STRUCTURE

Figure 8

#### E. Heat Shrinkable Boot Part Numbers



2448501 S00061545208\_V1

#### 809S102-( ) STRAIGHT HEAT SHRINKABLE BOOT

Figure 9

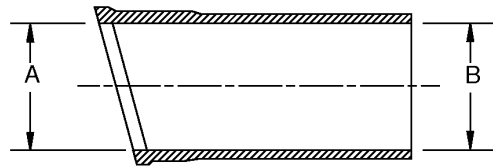
20-25-15



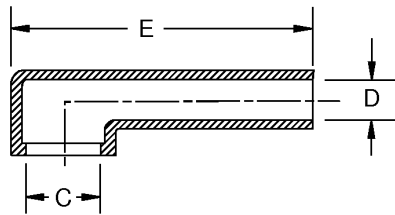
707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



AS SUPPLIED



AFTER HEAT SHRINK

2448502 S00061545209\_V1

#### 809A102-( ) 90 DEGREE HEAT SHRINKABLE BOOT

Figure 10

Table 4

HEAT SHRINKABLE BOOT PART NUMBERS

Part Number	Configuration	Dimension (inches)					Supplier
		A	B	C	D	E	
809S102-1	Straight	.88	.88	.45	.25	4.17	Glenair
809S102-2	Straight	1.01	1.01	.59	.29	4.77	Glenair
809S102-3	Straight	1.16	1.16	.74	.33	5.46	Glenair
809S102-4	Straight	1.34	1.34	.90	.38	6.28	Glenair
809S102-5	Straight	1.47	1.47	1.16	.41	7.00	Glenair
809S102-6	Straight	1.72	1.72	1.34	.48	8.00	Glenair
809S102-7	Straight	1.97	1.97	1.62	.56	8.00	Glenair
809S102-8	Straight	2.47	2.47	1.85	.69	8.00	Glenair
809S102-9	Straight	2.73	2.73	2.35	.77	8.00	Glenair
809S102-10	Straight	3.22	3.22	2.64	.90	8.00	Glenair
809A102-1	90 Degree	.88	.88	.45	.25	4.14	Glenair
809A102-2	90 Degree	1.01	1.01	.59	.29	4.88	Glenair
809A102-3	90 Degree	1.16	1.16	.74	.33	5.76	Glenair
809A102-4	90 Degree	1.34	1.34	.90	.38	6.78	Glenair

20-25-15





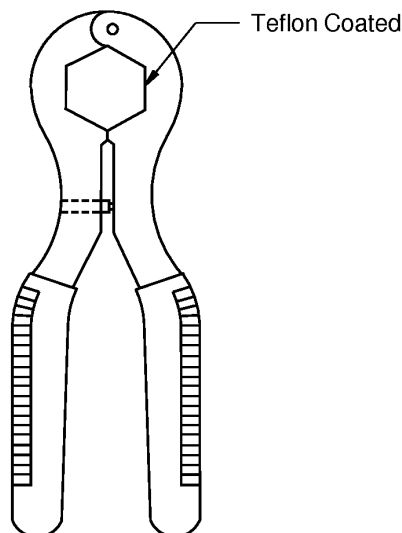
707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### 2. NECESSARY TOOLS

##### A. Necessary Tools



2448412 S00061545211\_V1

#### BACKSHELL HEX NUT TOOL

Figure 12

**CAUTION:** DO NOT USE A STRAP WRENCH TO APPLY TORQUE TO A COMPOSITE COUPLING NUT. ONLY USE A BACKSHELL HEX NUT TOOL TO APPLY TORQUE TO A COMPOSITE COUPLING NUT. FAILURE TO USE THE SPECIFIED BACKSHELL HEX NUT TOOL CAN CAUSE DAMAGE TO THE COUPLING NUT AND UNSATISFACTORY PERFORMANCE OF THE BACKSHELL.

Table 5  
HEX COUPLING NUT TOOLS

Shell Size	Tool	
	Part Number	Supplier
8	600-091-08	Glenair
	600-157-08	
9	600-091-08	Glenair
	600-157-08	
10	600-091-10	Glenair
	600-157-10	
11	600-091-10	Glenair
	600-157-10	

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 5 HEX COUPLING NUT TOOLS (Continued)

Shell Size	Tool	
	Part Number	Supplier
12	600-091-12	Glenair
	600-157-12	
13	600-091-12	Glenair
	600-157-12	
14	600-091-14	Glenair
	600-157-14	
15	600-091-14	Glenair
	600-157-14	
16	600-091-16	Glenair
	600-157-16	
17	600-091-16	Glenair
	600-157-16	
18	600-091-18	Glenair
	600-157-18	
19	600-091-18	Glenair
	600-157-18	
20	600-091-20	Glenair
	600-157-20	
21	600-091-20	Glenair
	600-157-20	
22	600-091-22	Glenair
	600-157-22	
23	600-091-22	Glenair
	600-157-22	
24	600-091-24	Glenair
	600-157-24	
25	600-091-24	Glenair
	600-157-24	
28	600-091-28	Glenair
32	600-091-32	Glenair

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 6  
TORQUE TOOL

Backshell Shell Size		Tool		
Minimum	Maximum	Type	Minimum Torque Capability (inch-pounds)	Supplier
08	19	Torque Driver	35	An Available Source
20	28	Torque Driver	80	An Available Source
32	32	Torque Driver	115	An Available Source

Table 7  
CONNECTOR ADAPTER TOOL SETS

Connector Series	Tool Set		Refer to
	Part Number	Supplier	
59000K	CM-S-389T	Daniels	Table 8
59300F	CM-S-389T	Daniels	Table 8
8D0(J)M	CM-S-389T	Daniels	Table 8
8D5(J)M	CM-S-389TR	Daniels	Table 9
BACC45FT	CM-S-837	Daniels	Table 10
BACC63BP	CM-S-837	Daniels	Table 10
BACC63CB	CM-S-837	Daniels	Table 10
BACC63CC	CM-S-837RB	Daniels	Table 11
BACC63CM	CM-S-837	Daniels	Table 10
BACC63CN	600E005	Glenair	Table 12
BACC63CT	CM-S-389T	Daniels	Table 8
BACC63CU	CM-S-389TR	Daniels	Table 9
BACC63DB	CM-S-389T	Daniels	Table 8
BACC63DC	CM-S-389TR	Daniels	Table 9
BACC63EB	CM-S-389T	Daniels	Table 8
BACC63EK	-	-	-
BACC68E	CM-S-389TR	Daniels	Table 9
BACC68F	CM-S-389T	Daniels	Table 8
D38999/24	CM-S-389T	Daniels	Table 8
D38999/26	CM-S-389TR	Daniels	Table 9
MS27467	CM-S-389L	Daniels	Table 13
MS3450	CM-S-5015R	Daniels	Table 15
MS3459	CM-S-5015	Daniels	Table 14
MS3475	CM-S-264	Daniels	Table 16
MS3476	CM-S-264R	Daniels	Table 17

20-25-15





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 7 CONNECTOR ADAPTER TOOL SETS (Continued)

Connector Series	Tool Set		Refer to
	Part Number	Supplier	
MS83723/75	CM-S-837	Daniels	Table 10
MS83723/77	CM-S-837	Daniels	Table 10
MS83723/78	CM-S-837	Daniels	Table 10
MS83723/83	CM-S-837RB	Daniels	Table 11
MS83723/95	CM-S-837	Daniels	Table 10
MS83723/98	CM-S-837	Daniels	Table 10

Table 8

### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-389T TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
9	N, C, D	CM389T-9A	1/4
	A, B, E	CM389T-9B	
11	N, D, E	CM389T-11A	1/4
	A, B, C	CM389T-11B	
13	N, D, E	CM389T-13A	1/4
	A, B, C	CM389T-13B	
15	N, D, E	CM389T-15A	1/4
	A, B, C	CM389T-15B	
17	N, A, B	CM389T-17A	1/4
	C, D, E	CM389T-17B	
19	N, A, B	CM389T-19A	3/8
	C, D, E	CM389T-19B	
21	N, A, B	CM389T-21A	3/8
	C, D, E	CM389T-21B	
23	N, A, B	CM389T-23A	3/8
	C, D, E	CM389T-23B	
25	N, A, B	CM389T-25A	3/8
	C, D, E	CM389T-25B	

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 9

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-389TR TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
9	N	CM389TR-9A	1/4
	A, B, C, D, E	CM389TR-9B	
11	N	CM389TR-11A	1/4
	A, B, C, D, E	CM389TR-11B	
13	N	CM389TR-13A	1/4
	A, B, C, D, E	CM389TR-13B	
15	N	CM389TR-15A	1/4
	A, B, C, D, E	CM389TR-15B	
17	N	CM389TR-17A	1/4
	A, B, C, D, E	CM389TR-17B	
19	N	CM389TR-19A	3/8
	A, B, C, D, E	CM389TR-19B	
21	N	CM389TR-21A	3/8
	A, B, C, D, E	CM389TR-21B	
23	N	CM389TR-23A	3/8
	A, B, C, D, E	CM389TR-23B	
25	N	CM389TR-25A	3/8
	A, B, C, D, E	CM389TR-25B	

Table 10

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-837 TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	N, 8, 9	CM837-8A	1/4
	6, 7	CM837-8B	1/4
	N, 8, 9	CM837-8C	1/4
	6, 7	CM837-8D	1/4
10	N, 8, 9	CM837-10A	1/4
	6, 7, 10	CM837-10B	3/8
12	N, 6, 8	CM837-12A	3/8
	7, 9, 10	CM837-12B	3/8
14	N, 6, 8	CM837-14A	3/8
	7, 9, 10	CM837-14B	3/8
16	N, 6, 8	CM837-16A	3/8
	7, 9, 10	CM837-16B	3/8

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

**Table 10 ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-837 TOOL SET (Continued)**

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
18	N, 6, 8	CM837-18A	3/8
	7, 9, 10	CM837-18B	3/8
20	N, 6, 8	CM837-20A	3/8
	7, 9, 10	CM837-20B	3/8
22	N, 6, 8	CM837-22A	3/8
	7, 9, 10	CM837-22B	3/8
24	N, 6, 8	CM837-24A	3/8
	7, 9, 10	CM837-24B	3/8
28	N, 6, 8	CM837-28A	3/8
	7, 9, 10	CM837-28B	3/8

**Table 11**

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-837RB TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	All	CM837RB-8	1/4
10	All	CM837RB-10	1/4
12	All	CM837RB-12	1/4
14	All	CM837RB-14	1/4
16	All	CM837RB-16	1/4
18	All	CM837RB-18	3/8
20	All	CM837RB-20	3/8
22	All	CM837RB-22	3/8
24	All	CM837RB-24	3/8

**Table 12**

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE GLENAIR 600E005 TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	N	600E005-8RN	1/4
	6	600E005-8R6	1/4
	7	600E005-8R7	1/4
	8	600E005-8R8	1/4
	9	600E005-8R9	1/4
	10	600E005-8R10	1/4

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 12 ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE GLENAIR 600E005 TOOL SET (Continued)

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
10	N	600E005-10RN	1/4
	6	600E005-10R6	1/4
	7	600E005-10R7	1/4
	8	600E005-10R8	1/4
	9	600E005-10R9	1/4
	10	600E005-10R10	1/4
12	N	600E005-12RN	1/4
	6	600E005-12R6	1/4
	7	600E005-12R7	1/4
	8	600E005-12R8	1/4
	9	600E005-12R9	1/4
	10	600E005-12R10	1/4
14	N	600E005-14RN	3/8
	6	600E005-14R6	3/8
	7	600E005-14R7	3/8
	8	600E005-14R8	3/8
	9	600E005-14R9	3/8
	10	600E005-14R10	3/8
16	N	600E005-16RN	3/8
	6	600E005-16R6	3/8
	7	600E005-16R7	3/8
	8	600E005-16R8	3/8
	9	600E005-16R9	3/8
	10	600E005-16R10	3/8
18	N	600E005-18RN	3/8
	6	600E005-18R6	3/8
	7	600E005-18R7	3/8
	8	600E005-18R8	3/8
	9	600E005-18R9	3/8
	10	600E005-18R10	3/8

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

**Table 12 ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE GLENAIR 600E005 TOOL SET (Continued)**

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
20	N	600E005-20RN	3/8
	6	600E005-20R6	3/8
	7	600E005-20R7	3/8
	8	600E005-20R8	3/8
	9	600E005-20R9	3/8
	10	600E005-20R10	3/8
22	N	600E005-22RN	3/8
	6	600E005-22R6	3/8
	7	600E005-22R7	3/8
	8	600E005-22R8	3/8
	9	600E005-22R9	3/8
	10	600E005-22R10	3/8
24	N	600E005-24RN	3/8
	6	600E005-24R6	3/8
	7	600E005-24R7	3/8
	8	600E005-24R8	3/8
	9	600E005-24R9	3/8
	10	600E005-24R10	3/8
28	N	600E005-28RN	3/8
	6	600E005-28R6	3/8
	7	600E005-28R7	3/8
	8	600E005-28R8	3/8
	9	600E005-28R9	3/8
	10	600E005-28R10	3/8

**Table 13**

### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-389L TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
9	All	CM389L-9	1/4
11	All	CM389L-11	1/4
13	All	CM389L-13	1/4
15	All	CM389L-15	1/4
17	All	CM389L-17	1/4
19	All	CM389L-19	3/8

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 13 ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-389L TOOL SET (Continued)

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
21	All	CM389L-21	3/8
23	All	CM389L-23	3/8
25	All	CM389L-25	3/8

Table 14

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-5015 TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	All	CM5015-8	1/4
10	All	CM5015-10	1/4
12	All	CM5015-12	1/4
14	All	CM5015-14	1/4
16	All	CM5015-16	1/4
18	All	CM5015-18	1/4
20	All	CM5015-20	3/8
22	All	CM5015-22	3/8
24	All	CM5015-24	3/8
28	All	CM5015-28	3/8
32	All	CM5015-32	3/8
36	All	CM5015-26	3/8
40	All	CM5015-40	3/8
44	All	CM5015-44	3/8
48	All	CM5015-48	3/8

Table 15

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-5015R TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	All	CM5015R-8	1/4
10	All	CM5015R-10	1/4
12	All	CM5015R-12	1/4
14	All	CM5015R-14	1/4
16	All	CM5015R-16	1/4
18	All	CM5015R-18	1/4
20	All	CM5015R-20	3/8

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 15 ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-5015R TOOL SET (Continued)

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
22	All	CM5015R-22	3/8
24	All	CM5015R-24	3/8
28	All	CM5015R-28	3/8
32	All	CM5015R-32	3/8
36	All	CM5015R-26	3/8
40	All	CM5015R-40	3/8
44	All	CM5015R-44	3/8
48	All	CM5015R-48	3/8

Table 16

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-264 TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	All	CM264-8	1/4
10	All	CM264-10	1/4
12	All	CM264-12	1/4
14	All	CM264-14	1/4
16	All	CM264-16	1/4
18	All	CM264-18	3/8
20	All	CM264-20	3/8
22	All	CM264-22	3/8
24	All	CM264-24	3/8

Table 17

#### ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-264R TOOL SET

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
8	All	CM264R-8	1/4
10	All	CM264R-10	1/4
12	All	CM264R-12	1/4
14	All	CM264R-14	1/4
16	All	CM264R-16	1/4
18	All	CM264R-18	3/8
20	All	CM264R-20	3/8
22	All	CM264R-22	3/8

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 17 ADAPTER PART NUMBERS AND DRIVE HANDLE SIZES FOR THE DANIELS CM-S-264R TOOL SET (Continued)

Connector Shell Size	Connector Keyway Position	Adapter Part Number	Handle Drive Size (inch)
24	All	CM264R-24	3/8

### 3. BACKSHELL DISASSEMBLY

#### A. Backshell Disassembly

Table 18  
BACKSHELL DISASSEMBLY TOOLS

Tool	Description	Part Number	Backshell Size		Screw Size	Supplier
			Smallest Size	Largest Size		
Screw Driver	Phillips #1	-	08	11	4	An available source
	Phillips #2	-	12	32	6	An available source
Knife	-	-	-	-	-	An available source
Diagonal Cutters	-	-	-	-	-	An available source
Spudger	Black Stick	SP3010	-	-	-	3M
	Nylon Stick	-	-	-	-	An available source
	Orangewood Stick	-	-	-	-	An available source
	Plastic Awl	-	-	-	-	An available source

- (1) If the backshell to be disassembled has a saddle clamp:
  - (a) Make a selection of a screw driver from Table 18.
  - (b) Remove the saddle bar screws, washers, spacers, and the saddle bars.
  - (c) Put the saddle bars, the screws, the washers, and the spacers in a safe place.
  - (d) Remove the tape that is:
    - At the location where the saddle bars hold the wire harness
    - Around the end of the shield sock
    - Around the shield terminator band.
  - (e) Remove the wire harness ties.
- (2) If there is a protective sleeve on the braided shield sock, remove the protective sleeve.
- (3) If the backshell to be disassembled has a strain relief boot:
  - (a) Make a selection of a knife from Table 18.

**20-25-15**



## STANDARD WIRING PRACTICES MANUAL

## ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

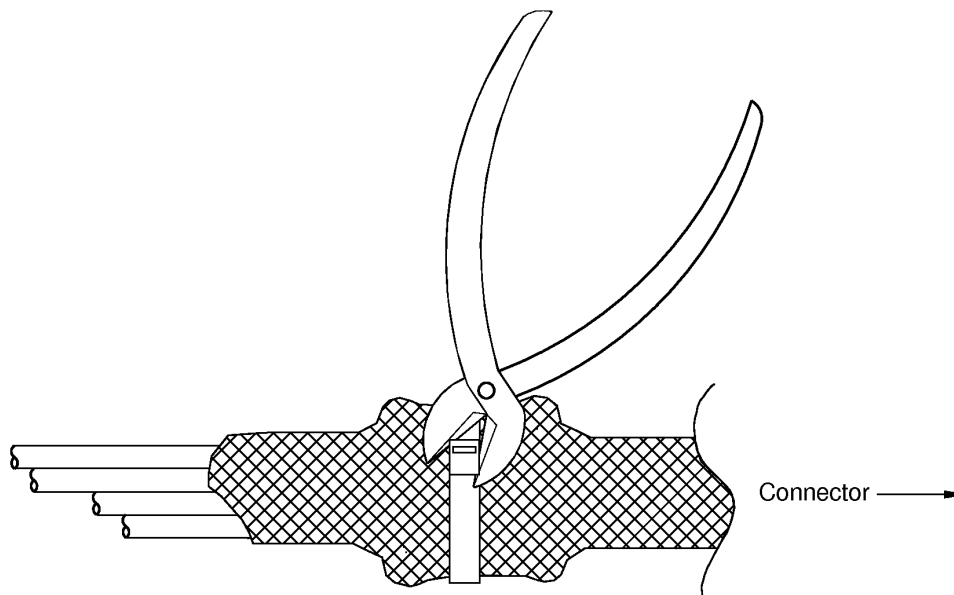
- (b) Carefully make a longitudinal cut from one end of the strain relief boot to the other end of the boot.

**CAUTION:** DO NOT FULLY CUT THROUGH THE STRAIN RELIEF BOOT. DAMAGE TO THE SHIELD SOCK, WIRES, CABLES, OR OTHER COMPONENTS OF THE WIRE HARNESS CAN OCCUR.

- (c) Apply heat the area that is cut to split the boot.  
(d) Remove the strain relief boot from the assembly.  
(e) Examine the shield sock.

Make sure that the shield sock does not have damage.

- (f) Remove the tape that is:
- Around the end of the shield sock
  - Around the shield terminator band.
- (4) Make a selection of a pair of diagonal cutters from Table 18.  
(5) Remove the shield terminator band from the braided shield sock. Refer to Figure 13.



2448432 S00061545214\_V1

## REMOVAL OF THE SHIELD TERMINATOR BAND

Figure 13

- (a) Hold the buckle of the shield terminator band with the cutters.  
(b) Rotate the cutters and lift the buckle of the band away from the braided shield sock until the buckle releases or the band breaks.  
(c) Remove the shield terminator band.
- (6) If the backshell to be disassembled is attached to a receptacle connector:

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Make sure that the receptacle connector shell is held by mounting screws or by other means and cannot rotate.

- (a) Make a selection of a backshell hex coupling nut tool from Table 5.

**CAUTION:** DO NOT USE A STRAP WRENCH TO LOOSEN A COMPOSITE COUPLING NUT. USE ONLY THE SPECIFIED BACKSHELL HEX NUT TOOL. FAILURE TO USE THE SPECIFIED BACKSHELL HEX NUT TOOL CAN CAUSE DAMAGE TO THE COUPLING NUT AND UNSATISFACTORY PERFORMANCE OF THE BACKSHELL.

- (b) Use the tool to loosen the coupling ring of the backshell.
- (c) Disengage the threads of the backshell coupling ring from the connector.
- (7) If the backshell to be disassembled is attached to a plug connector:
- (a) Disconnect the plug connector from the receptacle connector.
- (b) Use the connector shell size and the connector keyway position to make a selection of:
- A backshell hex coupling nut tool from Table 5
  - An adapter tool set from Table 7.
  - An adapter tool and driver from Table 8 through Table 17.

Make sure that the driver is the correct size for the adapter tool.

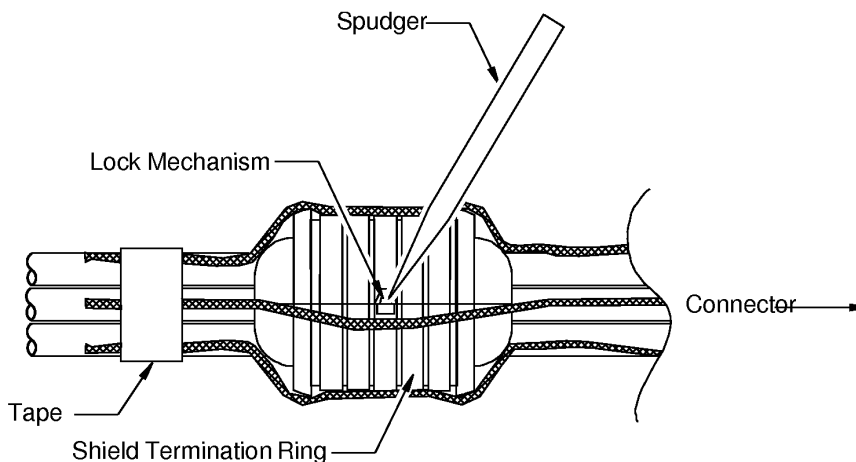
**CAUTION:** DO NOT USE A STRAP WRENCH TO LOOSEN A COMPOSITE COUPLING NUT. USE ONLY THE SPECIFIED BACKSHELL HEX NUT TOOL. FAILURE TO USE THE SPECIFIED BACKSHELL HEX NUT TOOL CAN CAUSE DAMAGE TO THE COUPLING NUT AND UNSATISFACTORY PERFORMANCE OF THE BACKSHELL.

- (c) Use the adapter tool and drive handle to hold the engaging face of the plug connector.
- (d) Use the backshell hex nut tool to loosen the backshell coupling ring.
- (e) Disengage the threads of the backshell coupling ring from the connector.
- (8) Remove the shield termination ring:

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448433 S00061545216\_V1

#### SHIELD TERMINATION RING REMOVAL

Figure 14

- (a) Make a selection of a spudger from Table 18.  
**NOTE:** A different tool that gives equivalent results is a satisfactory alternative.
- (b) Push the rear end of the shield sock toward the connector.  
 Make sure that you can see the shield termination ring.
- (c) Use the tip of the spudger to push against the lock mechanism of the shield termination ring.  
 Refer to Figure 14.
- (d) Remove the shield termination ring from the wire harness.
- (9) Push the backshell and shield sock along the wire harness away from the connector.
- (10) Remove the layers of tape from the wire harness.

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### 4. CABLE PREPARATION PROCEDURES AND BACKSHELL ASSEMBLY

This Paragraph gives the procedures to prepare the ends of shielded cables and to assemble a strain relief backshell that has a braided shield sock. For the procedures to assemble other strain relief backshells, refer to:

- Subject 20-60-09 for the assembly of backshells that do not terminate a shield
- Subject 20-60-09 for the assembly of the cable clamps on backshells that do not have a braided shield sock
- Subject 20-25-12 for the assembly of backshells that terminate shields with shield ground wires and terminal lugs
- Subject 20-25-13 for the assembly of backshells that terminate shields with inner and outer ground rings
- Subject 20-25-14 for the assembly of backshells that terminate shields with a shield terminator band.

#### A. Necessary Materials

Table 19  
NECESSARY MATERIALS

Material	Temperature Grade	Fluid Class	Type	Part Number or Specification	Description	Supplier
Insulation Sleeve, Heat Shrinkable	-	-	-	Refer to Subject 20-00-11	-	-
Insulation Tape	B	1	PTFE	A-A-59474, Type I	PTFE, pressure sensitive, silicone polymer adhesive	QPL
				Scotch 63	TFE fluorocarbon film; pressure sensitive acrylic adhesive; 0.0035 inch thick, 1/2 inch wide	3M
	D	2	Silicone	A-A-59163, Type I	Self-bonding silicone rubber, high temperature, rectangular cross-section, 0.5, 0.75, 1.0, 1.25, and 1.5 inch widths	QPL
				A-A-59163, Type II	Self-bonding silicone rubber, high temperature, triangular cross-section, one inch wide	QPL
				Scotch 70	Self-bonding silicone rubber, high temperature; 0.012 inch thick, 1 inch wide	3M

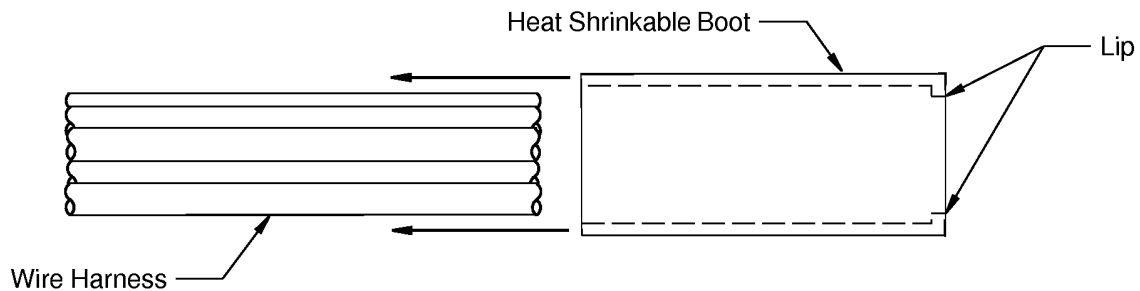
20-25-15

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### B. Backshell Assembly Preparation

- (1) If heat shrinkable sleeve is specified, put the sleeve on the wire harness.
- (2) If the backshell strain relief is a heat shrinkable boot, put the boot on the wire harness.  
Make sure that the end of the boot that has the lip is pointed forward toward the end of the wire harness. Refer to Figure 15.



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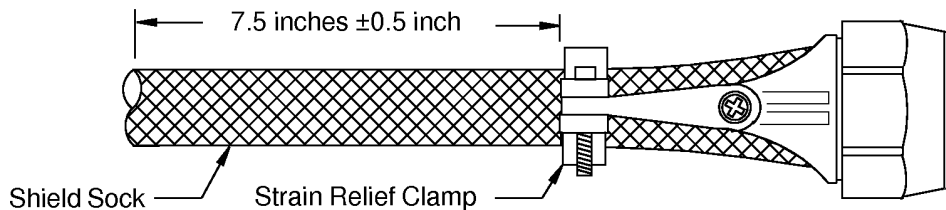
#### INSTALLATION OF THE STRAIN RELIEF BOOT

Figure 15

- (3) For a wire harness that does not have a splice assembly between the shield termination ring and the strain relief clamp, remove the necessary length of the shield sock.

For a backshell that has:

- A swing arm and strain relief clamp, refer to Figure 16
- A strain relief boot, refer to Figure 17.



2448427 S00061545218\_V1

#### LENGTH OF THE SHIELD SOCK FOR A STRAIN RELIEF CLAMP BACKSHELL

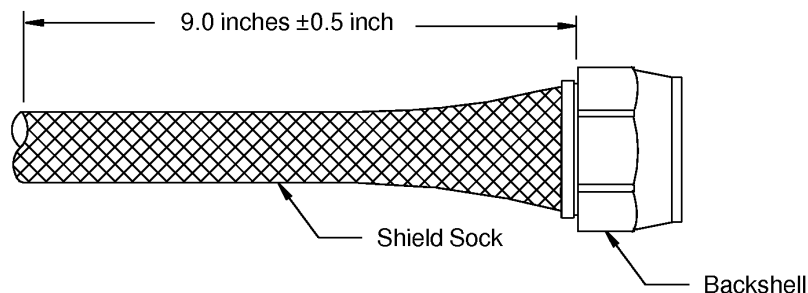
Figure 16



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

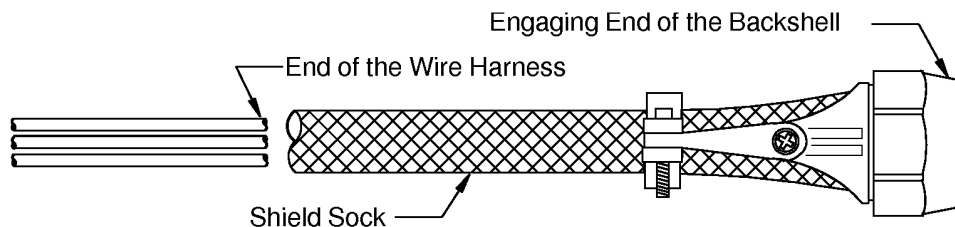


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#### LENGTH OF THE SHIELD SOCK FOR A STRAIN RELIEF BOOT

Figure 17

- (4) For a backshell that has a strain relief clamp:
  - (a) Make a selection of these tools from Table 18.
    - A screw bit driver
    - A screw bit.
  - (b) Remove the saddle clamp bars from the clamp.
  - (c) Keep the saddle clamp bars and the screws in a safe place.
- (5) Put the wire harness in the backshell and shield sock. Refer to Figure 18.



2448581 S00061545220\_V1

#### POSITION OF THE BACKSHELL IN RELATION TO THE WIRE HARNESS

Figure 18

- (6) Move the backshell and shield sock rearward on the wire harness away from the end of the wire harness.

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Make sure that the engaging end of the backshell is pointed forward toward the end of the wire harness.

(7) Prepare the cables for shield termination. Refer to Paragraph 4.C..

#### C. Selection of a Cable Preparation Procedure

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

**Table 20**  
**SHIELD TERMINATION CONFIGURATION DEFINITIONS**

Shield Termination Configuration	Definition
End Strip	The cable jacket and shield removal for non-EMI configurations where the location of the shield termination can occur between the shield termination ring and the strain relief clamp
Standard	The cable jacket and shield removal for EMI configurations where the location of the shield termination must occur between the strain relief clamp and the connector

**Table 21**  
**SPECIAL CABLE PREPARATION PROCEDURES**

Cable	Outer Shield		Inner Shield		Assembly Procedure
	Shield Ground Wire	Termination Configuration	Shield Ground Wire	Termination Configuration	
CAN22TDT120-260, Two Adjacent Shields	Solder Sleeve	Standard	-	-	Paragraph 4.F.
Thermax 975-295	Solder Sleeve	End Strip	-	-	Paragraph 4.H.

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 22  
STANDARD CABLE PREPARATION PROCEDURES

Shielded Cable Configuration	Outer Shield		Inner Shield		Assembly Procedure
	Shield Ground Wire	Termination Configuration	Shield Ground Wire	Termination Configuration	
One Shield	Solder Sleeve	Standard	-	-	Paragraph 4.E.
	Solder Sleeve	End Strip	-	-	Paragraph 4.G.
	Shield Pull Through	Standard	-	-	Paragraph 4.I.
	Shield Pull Through	End Strip	-	-	Paragraph 4.I.
Two Adjacent Shields	Solder Sleeve	Standard	-	-	Paragraph 4.E.
	Solder Sleeve	End Strip	-	-	Paragraph 4.G.
	Shield Pull Through	Standard	-	-	Paragraph 4.I.
	Shield Pull Through	End Strip	-	-	Paragraph 4.I.
Two Isolated Shields	Shield Pull Through	Standard	Shield Pull Through	Standard	Paragraph 4.J.
	Shield Pull Through	End Strip	Shield Pull Through	Standard	Paragraph 4.K.
	Shield Pull Through	End Strip	Shield Pull Through	End Strip	Paragraph 4.K.
	Shield Pull Through	Standard	Solder Sleeve	Standard	Paragraph 4.L.
	Shield Pull Through	End Strip	Solder Sleeve	Standard	Paragraph 4.M.
	Shield Pull Through	Standard	Dead End	Standard	Paragraph 4.N.
	Shield Pull Through	End Strip	Dead End	End Strip	Paragraph 4.N.
	Solder Sleeve	End Strip	Solder Sleeve	Standard	Paragraph 4.O.
	Solder Sleeve	End Strip	Solder Sleeve	End Strip	Paragraph 4.P.
	Solder Sleeve	End Strip	Dead End	Standard	Paragraph 4.Q.

20-25-15





707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### D. Cable Preparation Dimensions

Table 23  
CABLE PREPARATION DIMENSIONS - CONDUCTOR NOT FOLDED BACK

Backshell	Shell Size		Removal Length (inch)			
			Dimension A		Dimension B	
	Min	Max	Target	Tolerance	Target	Tolerance
319AS110BM	10	24	2.75	±0.10	1.95	±0.10
319F064XO	9	19	3.75	±0.10	1.95	±0.10
319HS110BM	9	17	2.75	±0.10	1.95	±0.10
447HA557	9	19	3.5	±0.10	1.95	±0.10
BACC10MA	9	19	3.75	±0.10	1.95	±0.10
	21	25	4.25	±0.10	1.95	±0.10
BACC10MB	9	19	3.75	±0.10	1.95	±0.10
	21	25	4.25	±0.10	1.95	±0.10
BACC10MM	10	18	3.75	±0.10	1.95	±0.10
	20	24	4.25	±0.10	1.95	±0.10
BACC10MP	12	18	3.75	±0.10	1.95	±0.10
	20	22	4.25	±0.10	1.95	±0.10

Table 24  
CABLE PREPARATION DIMENSIONS - CONDUCTOR FOLDED BACK

Backshell	Shell Size		Removal Length (inch)			
			Dimension A		Dimension B	
	Min	Max	Target	Tolerance	Target	Tolerance
319AS110BM	10	24	2.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
319F064XO	9	19	3.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
319HS110BM	9	17	2.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
447HA557	9	19	3.5 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 24 CABLE PREPARATION DIMENSIONS - CONDUCTOR FOLDED BACK (Continued)

Backshell	Shell Size		Removal Length (inch)			
			Dimension A		Dimension B	
	Min	Max	Target	Tolerance	Target	Tolerance
BACC10MA	9	19	3.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
	21	25	4.25 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
BACC10MB	9	19	3.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
	21	25	4.25 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
BACC10MM	10	18	3.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
	20	24	4.25 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
BACC10MP	12	18	3.75 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10
	20	22	4.25 plus 1/2 of the insulation removal length	±0.10	1.95 plus 1/2 of the insulation removal length	±0.10

#### E. Solder Sleeve Shield Termination - Standard Configuration

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the jacket and the shield from the end of the cable.

**NOTE:** If the contact assembly specifies the fold back of the conductor, Dimension A and Dimension B must be increased by one half of the insulation removal length that is applicable for the wire size and the contact crimp barrel size.

Refer to:

**20-25-15**

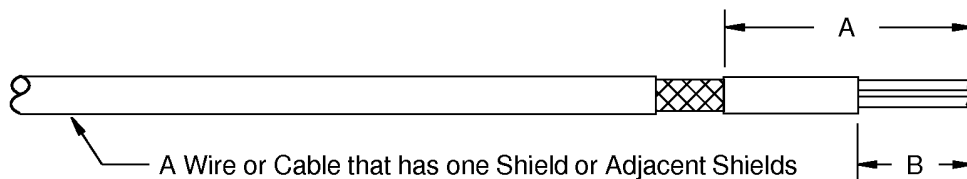


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

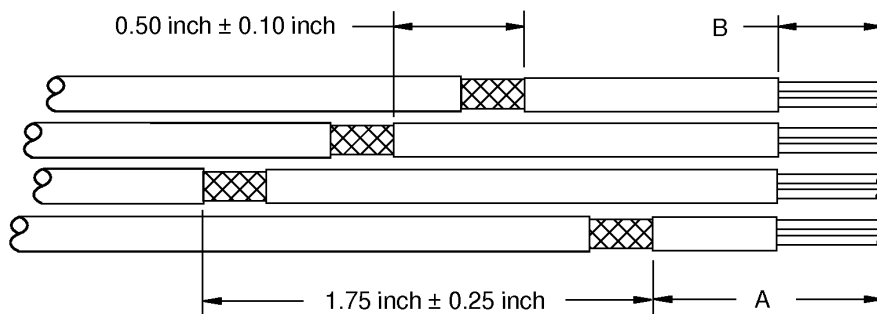
- Table 23 for the cable jacket removal length when the conductor is not folded back
- Table 24 for the cable jacket removal length when the conductor is folded back
- Figure 19 for 3 or less cables
- Figure 20 for 4 or more cables
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448505 S00061545222\_V1

### CABLE PREPARATION FOR 3 OR LESS CABLES - STANDARD CONFIGURATION

Figure 19



2448504 S00061545223\_V1

### CABLE PREPARATION FOR 4 OR MORE CABLES - STANDARD CONFIGURATION

Figure 20

- (2) Assemble a solder sleeve that has an integral uninsulated shield ground wire.

Refer to:

- Figure 21
- Subject 20-10-15 for the procedure to assemble the solder sleeve.

**20-25-15**



707, 727-787

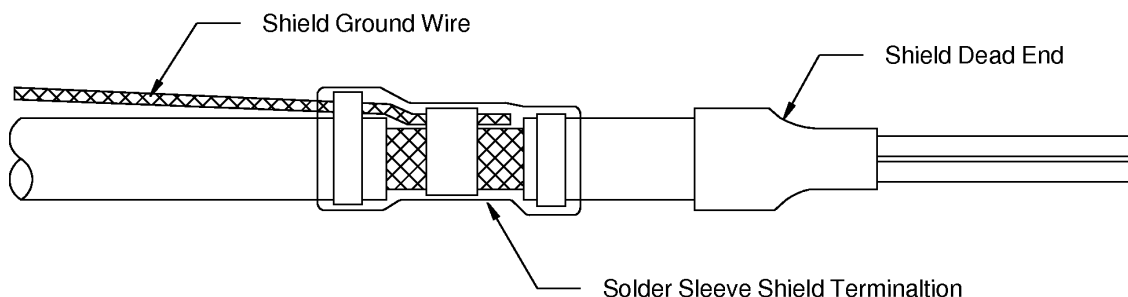
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Make sure that the shield ground wire is pointed away from the end of the wire harness.

**NOTE:** An overlap of the solder sleeves is permitted when the wire harness has 3 cables or less.

**NOTE:** When the wire harness has 4 or more cables, the solder sleeves must be installed in equal sets at equal distances in the 1.75 inch length area. Refer to Figure 20.



2449199 S00061545224\_V1

#### POSITION OF THE SHIELD GROUND WIRE

Figure 21

- (3) Assemble a shield dead end on the cable.

Refer to:

- Figure 21
- Subject 20-10-15 for the procedure to assemble the shield dead end.

#### F. Solder Sleeve Shield Termination - Standard Configuration, Tensolite CAN22TT120-260 Cable

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Put a 1.25 inch  $\pm$ 0.10 inch length of the specified heat shrinkable sleeve on the cable.
- (2) Move the length of heat shrinkable sleeve away from the end of the cable.

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

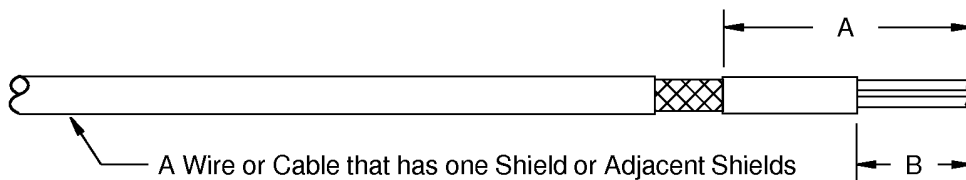
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (3) Remove the necessary length of the jacket and the shield from the end of the cable.

**NOTE:** If the contact assembly specifies the fold back of the conductor, Dimension A and Dimension B must be increased by one half of the insulation removal length that is applicable for the wire size and the contact crimp barrel size.

Refer to:

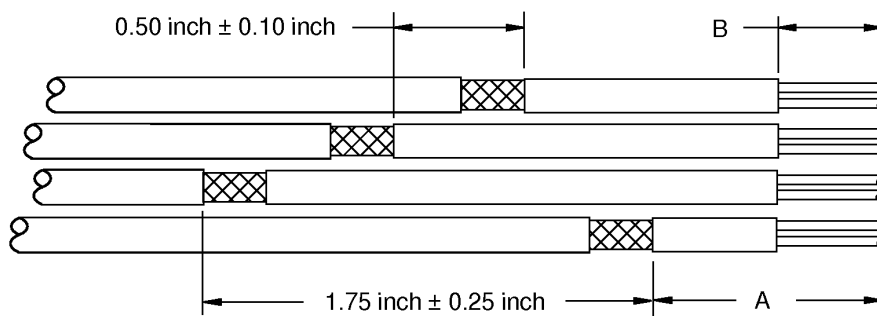
- Table 23 for the cable jacket removal length when the conductor is not folded back
- Table 24 for the cable jacket removal length when the conductor is folded back
- Figure 22 for 3 or less cables
- Figure 23 for 4 or more cables
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448505 S00061545222\_V1

### CABLE PREPARATION FOR 3 OR LESS CABLES - STANDARD CONFIGURATION

Figure 22



2448504 S00061545223\_V1

### CABLE PREPARATION FOR 4 OR MORE CABLES - STANDARD CONFIGURATION

Figure 23

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (4) Assemble a solder sleeve that has an integral uninsulated shield ground wire.

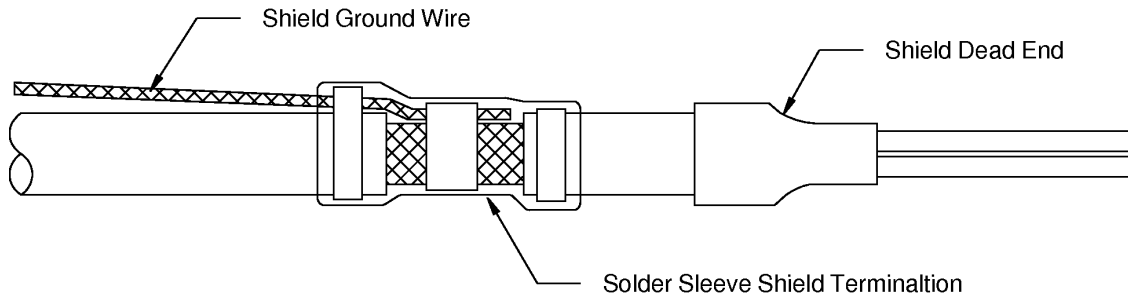
Refer to:

- Figure 24
- Subject 20-10-15 for the procedure to assemble the solder sleeve..

Make sure that the shield ground wire is pointed away from the end of the wire harness.

**NOTE:** An overlap of the solder sleeves is permitted when the wire harness has 3 cables or less.

**NOTE:** When the wire harness has 4 or more cables, the solder sleeves must be installed in equal sets at equal distances in the 1.75 inch length area. Refer to Figure 23.



2449199 S00061545224\_V1

#### POSITION OF THE SHIELD GROUND WIRE

Figure 24

- (5) Assemble a shield dead end on the cable.

Refer to:

- Figure 24
- Subject 20-10-15 for the procedure to assemble the shield dead end.

- (6) Push the heat shrinkable sleeve forward until the center of the sleeve and the center of the solder sleeve are approximately aligned. Refer to Figure 25

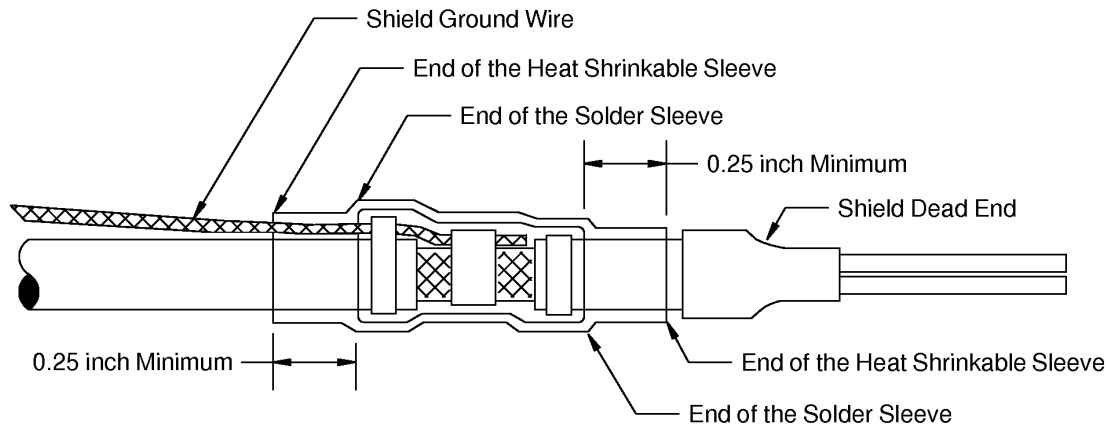
Make sure that:

- The forward end of the sleeve is not farther than 0.25 inch from the rear end of the shield dead end
- The rear end of the sleeve is not farther than 0.25 inch from the rear end of the solder sleeve.

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449200 S00061545225\_V1

#### POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE SOLDER SLEEVE

Figure 25

- (7) Shrink the sleeve into its position.

Refer to:

- Figure 25
- Subject 20-10-14 for the procedure to shrink the sleeve.

#### G. Solder Sleeve Shield Termination - End Strip Configuration

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the jacket and the shield from the end of the cable.

**NOTE:** If the contact assembly specifies the fold back of the conductor, dimension A must be increased by one half of the insulation removal length that is applicable for the wire size and the contact crimp barrel size.

Refer to:

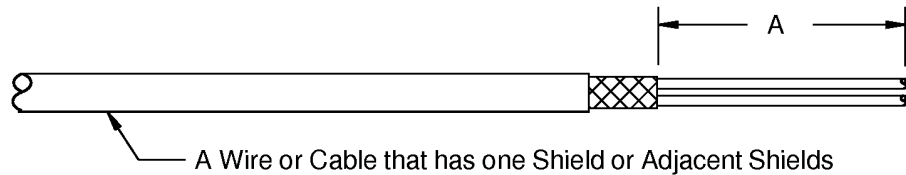
- Table 23 for the cable jacket removal length when the conductor is not folded back
- Table 24 for the cable jacket removal length when the conductor is folded back

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

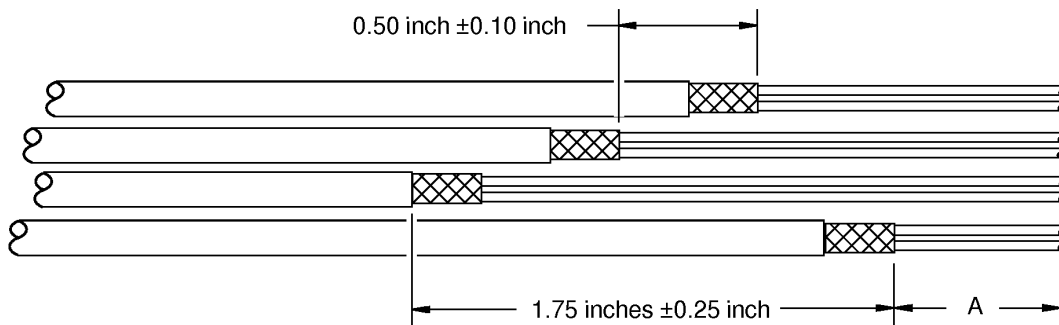
- Figure 26 for 3 or less cables
- Figure 27 for 4 or more cables
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448506 S00061545226\_V1

#### CABLE PREPARATION FOR 3 OR LESS CABLES - END STRIP CONFIGURATION

Figure 26



2448448 S00061545227\_V1

#### CABLE PREPARATION FOR 4 OR MORE CABLES - END STRIP CONFIGURATION

Figure 27

- (2) Assemble a solder sleeve that has an uninsulated shield ground wire on each cable. Make sure that the shield ground wires point away from the end of the wire harness.
- Refer to:
- Figure 28

**20-25-15**



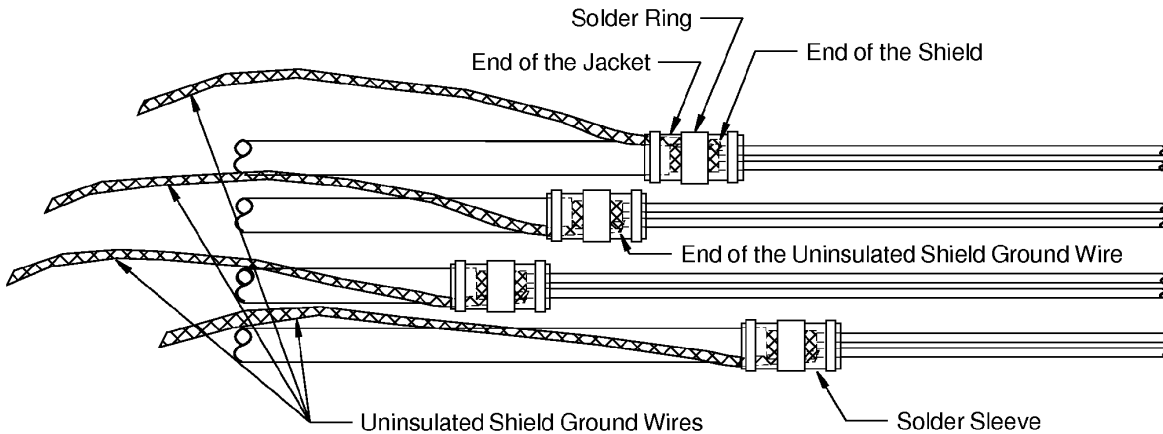
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- Subject 20-10-15 for the procedure to assemble the solder sleeves.

**NOTE:** An overlap of the solder sleeves is permitted when the wire harness has 3 cables or less.

**NOTE:** When the wire harness has 4 or more cables, the solder sleeves must be installed in equal sets at equal distances in a 1.75 inch length area. Refer to Figure 27.



2448449 S00061545228\_V1

#### POSITION OF SOLDER SLEEVES THAT HAVE INTEGRAL UNINSULATED SHIELD GROUND WIRES

Figure 28

#### H. Solder Sleeve Shield Termination - End Strip Configuration, Thermax 975-295 Cable

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

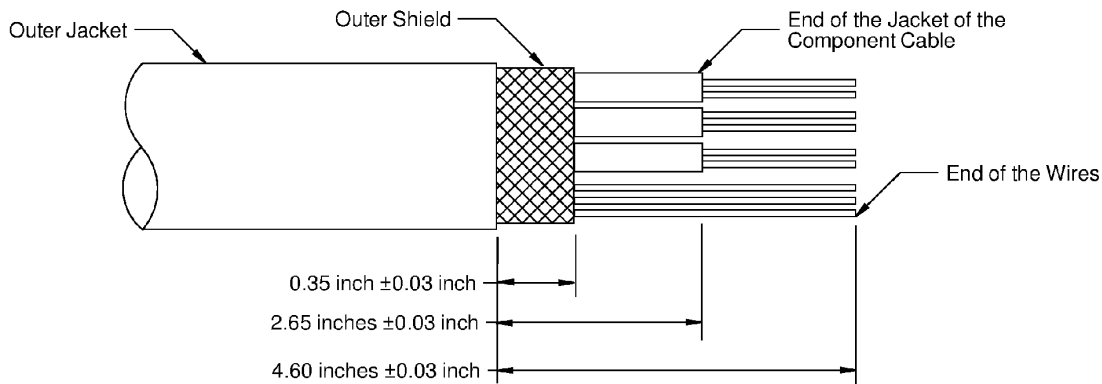
**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449685 S00061545229\_V1

#### CABLE PREPARATION

Figure 29

Refer to Figure 29.

- (1) Remove 4.60 inches  $\pm 0.03$  inch of the outer jacket from the end of the cable.  
Refer to Subject 20-00-15 for the procedure to remove the cable jacket.
- (2) Remove the necessary length of the outer shield to make the distance from the end of the outer jacket to the end of the shield equal to 0.35 inch  $\pm 0.03$  inch.
- (3) Cut the cable fillers at the end of the outer shield.
- (4) For each component shielded cable:
  - (a) Remove the necessary length of the component cable jacket to make the distance from the end of the outer jacket to the end of the component cable jacket equal to 2.65 inches  $\pm 0.03$  inch. Refer to Subject 20-00-15 for the procedure to remove the cable jacket.
  - (b) Remove the shield at the end of the jacket of the component cable.
- (5) Assemble an uninsulated shield ground wire on the cable. Refer to Subject 20-10-15.
- (6) Assemble a shield dead end at the end of the jacket of each component cable. Refer to Subject 20-10-15.

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### I. Shield Pull Through Shield Termination

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

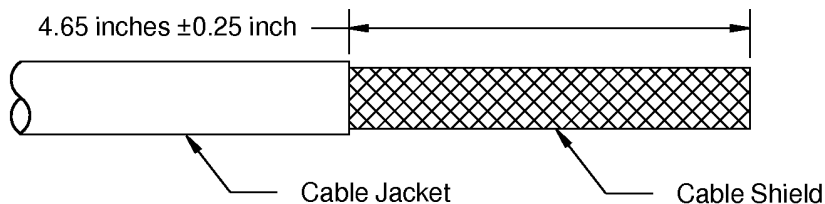
- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the jacket from the end of the cable.

Refer to:

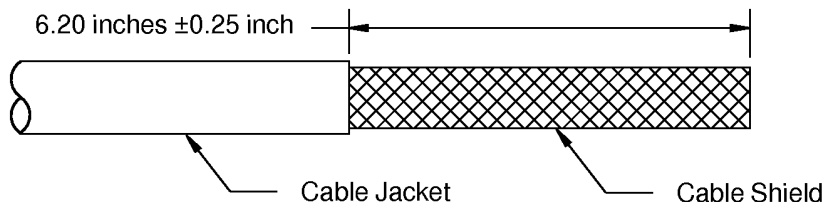
- Figure 30 for the shield ground wire between the strain relief clamp and the connector
- Figure 30 for the shield ground wire for a strain relief boot backshell
- Figure 31 for the shield ground wire between the shield termination ring and the strain relief clamp
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448450 S00061545230\_V1

#### CABLE PREPARATION - STANDARD CONFIGURATION

Figure 30



2448451 S00061545231\_V1

#### CABLE PREPARATION - END STRIP CONFIGURATION

Figure 31

- (2) Assemble the shield pull through shield ground wires.

**20-25-15**



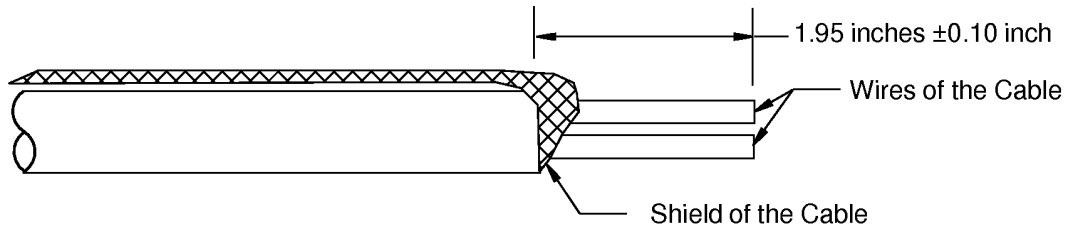
707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Refer to:

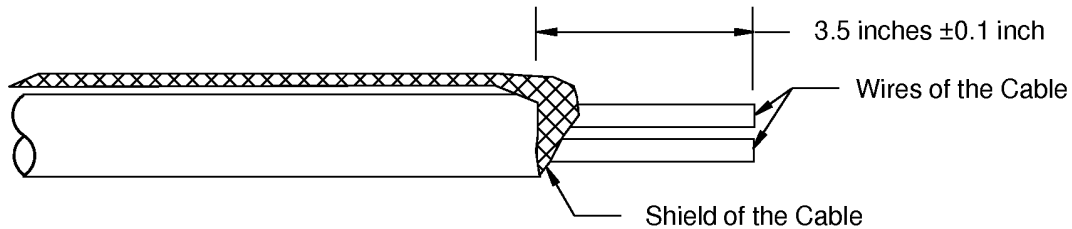
- Figure 32 for the shield ground wire between the strain relief clamp and the connector
- Figure 32 for the shield ground wire for a strain relief boot backshell
- Figure 33 for the shield ground wire between the shield termination ring and the strain relief clamp
- Subject 20-10-15 for the procedure to assemble the pull through shield ground wire.



2448452 S00061545232\_V1

#### SHIELD PULL THROUGH SHIELD GROUND WIRE - STANDARD CONFIGURATION

Figure 32



2448453 S00061545233\_V1

#### SHIELD PULL THROUGH SHIELD GROUND WIRE - END STRIP CONFIGURATION

Figure 33

- (3) Remove the necessary length from the end of the wires.

Refer to:

- Figure 32 for the shield ground wire between the strain relief clamp and the connector
- Figure 33 for the shield ground wire between the shield termination ring and the strain relief clamp.

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### J. Isolated Shields - Outer Shield Standard Shield Pull Through, Inner Shield Standard Shield Pull Through Shield Termination

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

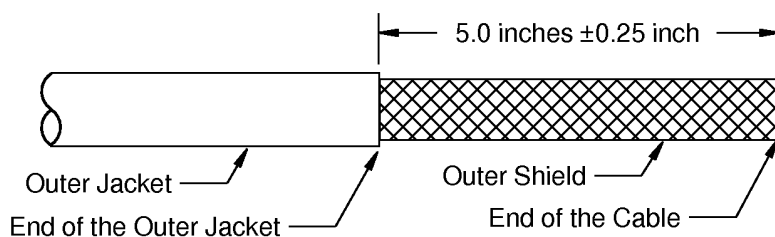
- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the outer jacket from the end of the cable.

Refer to:

- Figure 34 for the shield ground wire between the strain relief clamp and the connector
- Figure 34 for the shield ground wire for a strain relief boot backshell
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448454 S00061545234\_V1

#### OUTER JACKET REMOVAL - STANDARD CONFIGURATION

Figure 34

- (2) Assemble the shield pull through shield ground wire of the outer shield. Refer to Subject 20-10-15.
- (3) Remove the necessary length of inner jacket to make the distance from the end of the outer jacket to the end of the inner jacket equal to 0.2 inch to 0.3 inch.

Refer to:

- Figure 35
- Subject 20-00-15 for the procedure to remove the cable jacket.

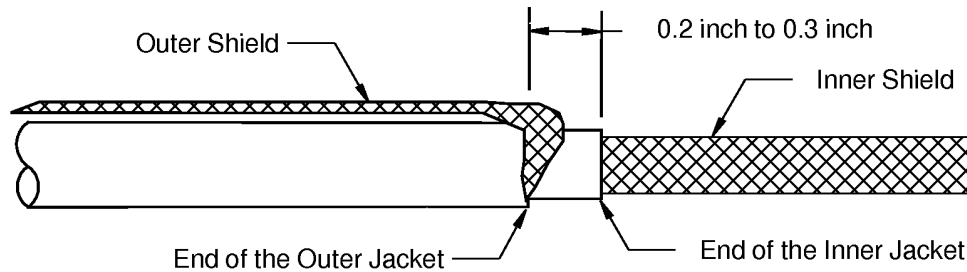
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

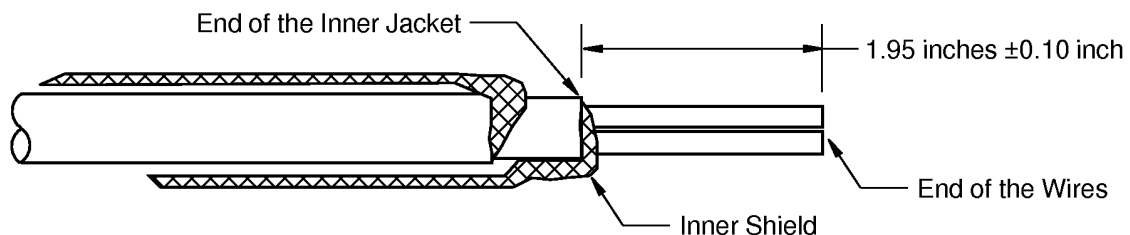


2448456 S00061545235\_V1

#### INNER JACKET REMOVAL - STANDARD CONFIGURATION

Figure 35

- (4) Assemble the shield pull through shield ground wire of the inner shield. Refer to Subject 20-10-15.
- (5) Remove the necessary length from the end of the wires of the cable. Refer to Figure 36.



2448460 S00061545236\_V1

#### LENGTH OF THE INNER SHIELD SHIELD GROUND WIRE

Figure 36

#### K. Isolated Shields - Outer Shield End Strip Shield Pull Through, Inner Shield Standard or End Strip Shield Pull Through Shield Terminations

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the outer jacket from the end of the cable.

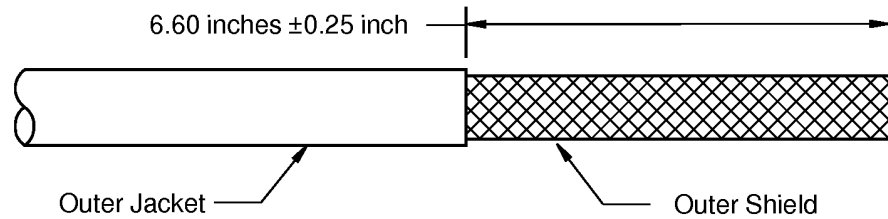
Refer to:

- Figure 37
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448572 S00061545237\_V1

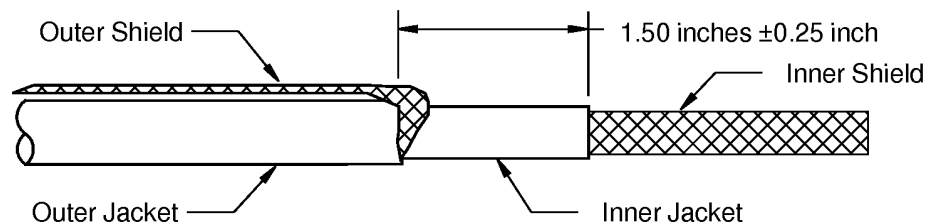
#### OUTER JACKET REMOVAL - END STRIP CONFIGURATION

Figure 37

- (2) Assemble a shield pull through shield ground wire of the outer shield. Refer to Subject 20-10-15.
- (3) Remove the necessary length of inner jacket from the end of the cable.

Refer to:

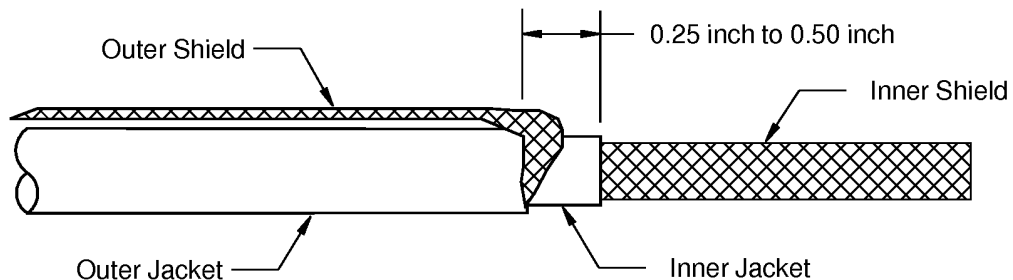
- Figure 38
- Figure 39
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448576 S00061545238\_V1

#### INNER JACKET REMOVAL - STANDARD CONFIGURATION

Figure 38



2448573 S00061545239\_V1

#### INNER JACKET REMOVAL - END STRIP CONFIGURATION

Figure 39

**20-25-15**

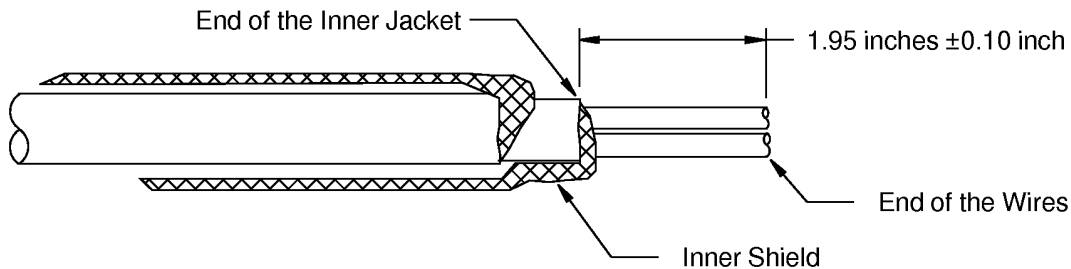
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (4) Assemble a shield pull through shield ground wire of the inner shield. Refer to Subject 20-10-15.
- (5) Remove the necessary length from the end of the wires of the cable.

Refer to:

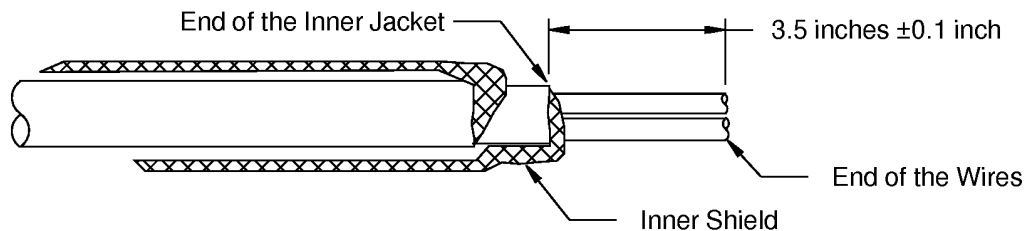
- Figure 40 for the shield ground wire between the strain relief clamp and the connector
- Figure 41 for the inner shield ground wire between the shield termination ring and the strain relief clamp.



2448458 S00061545240\_V1

#### LENGTH OF THE WIRES OF THE CABLE - STANDARD CONFIGURATION

Figure 40



2448459 S00061545241\_V1

#### LENGTH OF THE INNER SHIELD SHIELD GROUND - END STRIP CONFIGURATION

Figure 41

#### L. Isolated Shields - Outer Shield Standard Shield Pull Through, Inner Shield Standard Solder Sleeve Shield Terminations

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of outer jacket from the end of the cable.

**20-25-15**





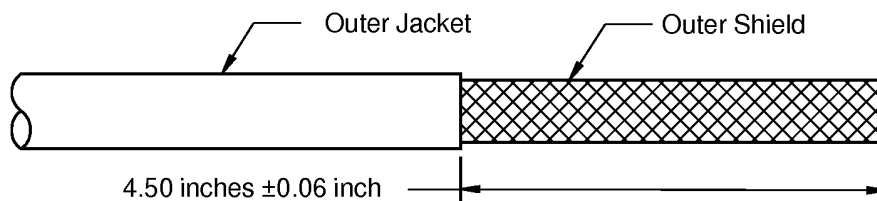
707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Refer to:

- Figure 42
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448461 S00061545242\_V1

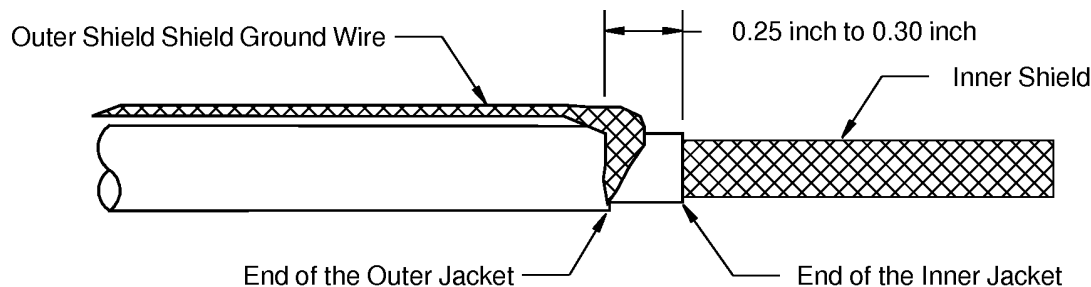
#### OUTER JACKET REMOVAL - STANDARD CONFIGURATION

Figure 42

- (2) Assemble a shield pull through shield ground wire of the outer shield. Refer to Subject 20-10-15.
- (3) Remove the necessary length of the inner jacket to make the distance from the end of the outer jacket to the end of the inner jacket equal to 0.25 inch to 0.30 inch.

Refer to:

- Figure 43
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448463 S00061545243\_V1

#### INNER JACKET REMOVAL - STANDARD CONFIGURATION

Figure 43

- (4) Assemble a solder sleeve that has an insulated shield ground wire at the end of the inner jacket.

Refer to:

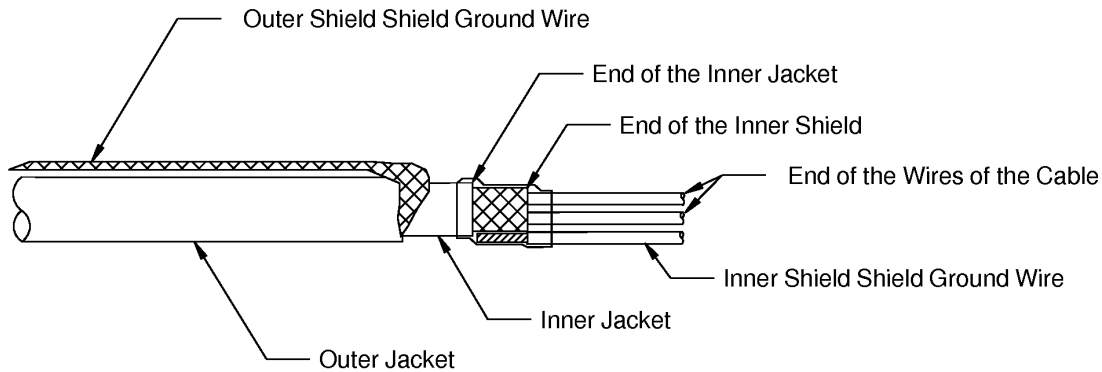
- Figure 44
- Subject 20-10-15 for the procedure to assemble the shield ground wire.

Make sure that the end of the shield ground wire is pointed forward toward the end of the cable.

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

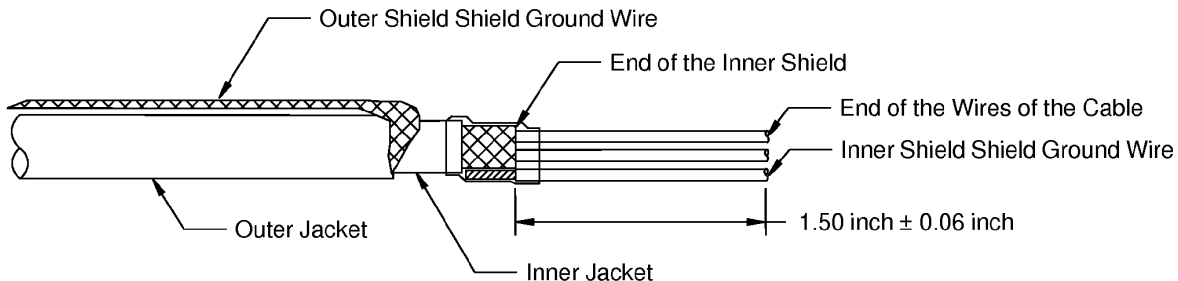


2448465 S00061545244\_V1

#### SHIELD GROUND WIRE OF THE INNER SHIELD

Figure 44

- (5) Remove the necessary length from the end of the wires of the cable and from the end of the inner shield shield ground wire. Refer to Figure 45.



2448507 S00061545245\_V1

#### LENGTH OF THE SHIELD GROUND WIRE OF THE INNER SHIELD AND THE WIRES OF THE CABLE

Figure 45

**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### M. Isolated Shields - Outer Shield End Strip Shield Pull Through, Inner Shield Solder Sleeve Shield Terminations

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

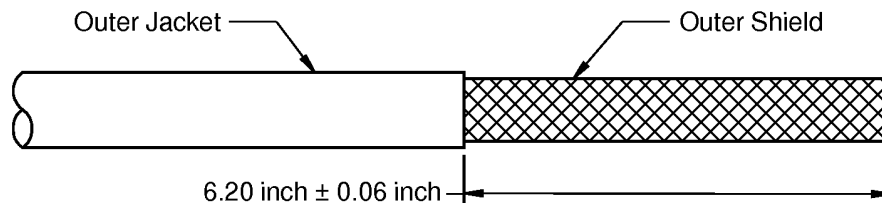
- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the outer jacket from the end of the cable.

Refer to:

- Figure 46
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448462 S00061545246\_V1

#### OUTER JACKET REMOVAL - END STRIP CONFIGURATION

Figure 46

- (2) Assemble a shield pull through shield ground wire of the outer shield. Refer to Subject 20-10-15.
- (3) Remove the necessary length of the inner jacket to make the distance from the end of the outer jacket to the end of the inner jacket equal to 1.50 inches ±0.25 inch.

Refer to:

- Figure 47
- Subject 20-00-15 for the procedure to remove the cable jacket.

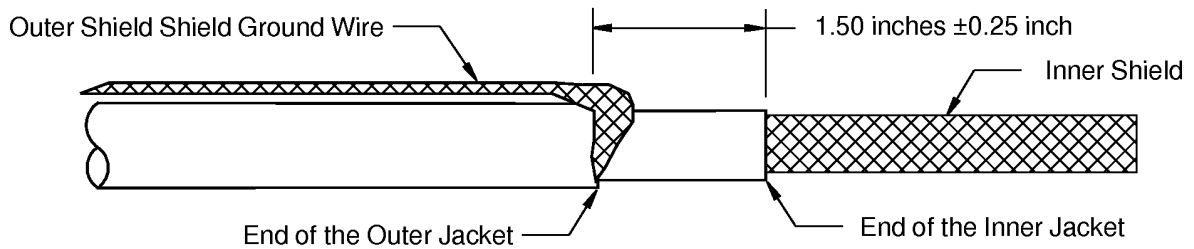
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448464 S00061545247\_V1

#### INNER JACKET REMOVAL - STANDARD CONFIGURATION

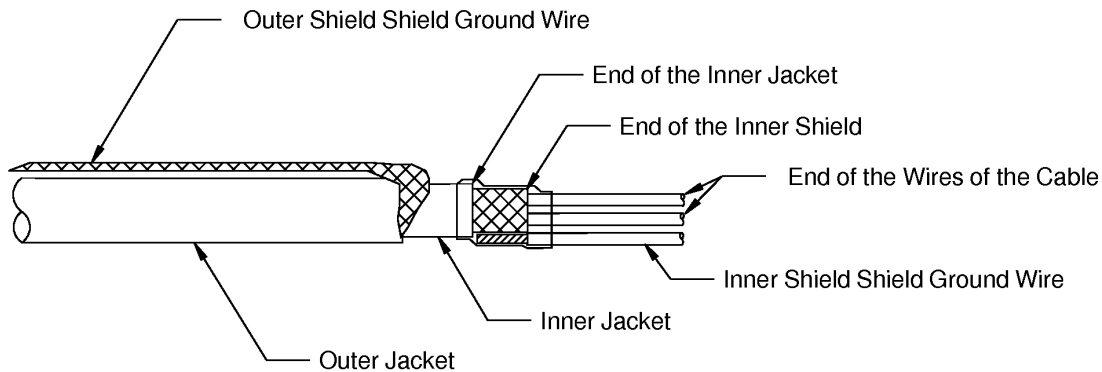
Figure 47

- (4) Assemble a solder sleeve shield ground wire at the end of the inner jacket.

Refer to:

- Figure 48
- Subject 20-10-15 for the procedure to assemble the solder sleeve shield ground wire.

Make sure that the end of the shield ground wire is pointed forward toward the end of the cable.



2448465 S00061545244\_V1

#### INNER SHIELD SHIELD GROUND WIRE

Figure 48

- (5) Remove the necessary length from the end of the wires of the cable and from the end of the shield ground wire of the inner shield. Refer to Figure 49.

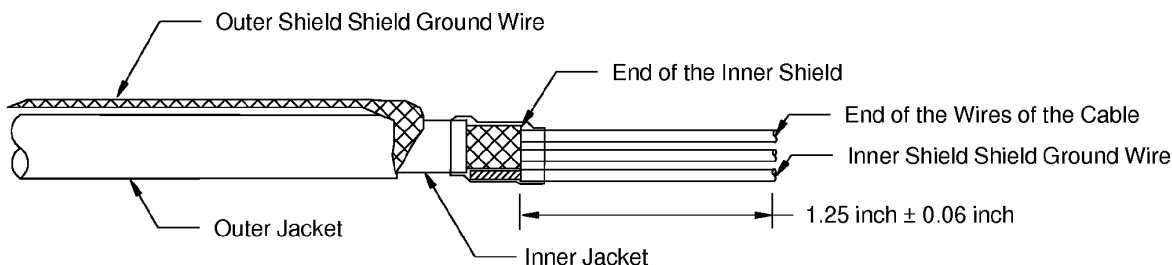
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448508 S00061545248\_V1

#### LENGTH OF THE INNER SHIELD SHIELD GROUND WIRE AND THE WIRES OF THE CABLE

Figure 49

#### N. Isolated Shields - Outer Shield Standard or End Strip Shield Pull Through, Inner Shield Standard or End Strip Shield Dead End Shield Terminations

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary length of the outer jacket from the end of the cable.

Refer to:

- Figure 50 for the shield ground wire between the strain relief clamp and the connector
- Figure 51 for the shield ground wire between the shield termination ring and the strain relief clamp
- Subject 20-00-15 for the procedure to remove the cable jacket.

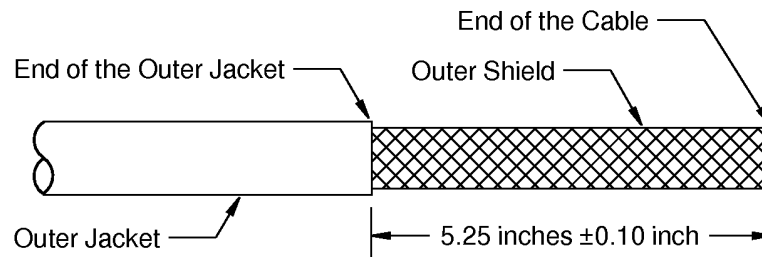
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

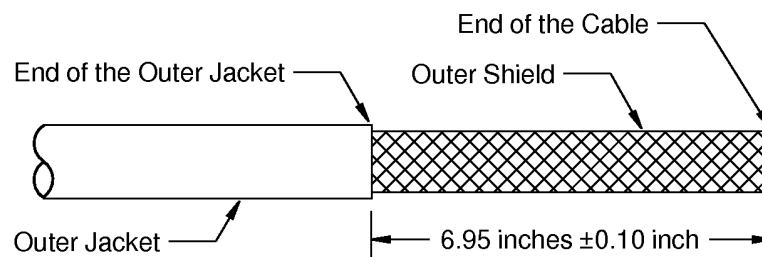
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449213 S00061545249\_V1

#### OUTER JACKET REMOVAL - STANDARD CONFIGURATION

Figure 50



2449214 S00061545250\_V1

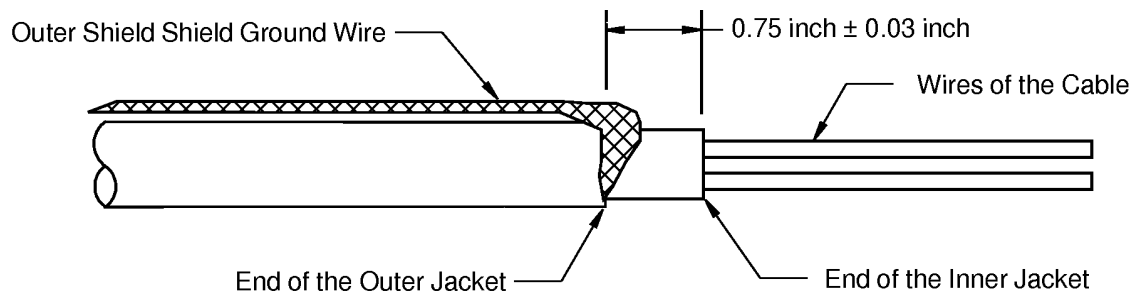
#### OUTER JACKET REMOVAL - END STRIP CONFIGURATION

Figure 51

- (2) Assemble a shield pull through shield ground wire of the outer shield. Refer to Subject 20-10-15.
- (3) Remove the necessary length of the inner jacket and the inner shield to make the distance from the end of the outer jacket to the end of the inner jacket equal to 0.75 inch  $\pm 0.03$  inch.

Refer to:

- Figure 52
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448455 S00061545251\_V1

#### INNER JACKET AND INNER SHIELD REMOVAL

Figure 52

**20-25-15**

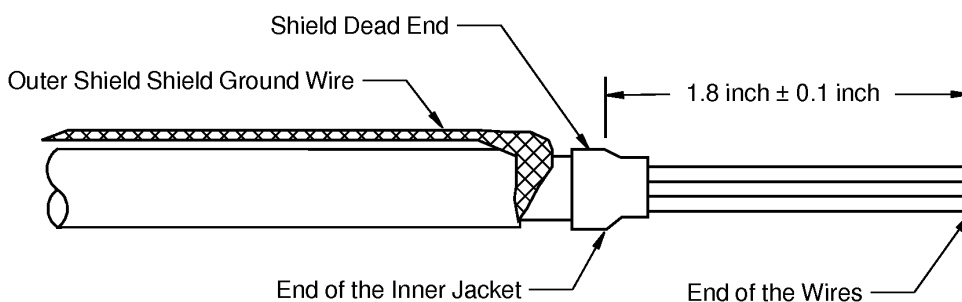
## STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE  
A BRAIDED SHIELD SOCK

- (4) Assemble a shield dead end of the inner shield. Refer to Subject 20-10-15.
- (5) Remove the necessary length from the end of the wires of the cable.

Refer to:

- Figure 53 for the shield ground wire between the strain relief clamp and the connector
- Figure 54 for the shield ground wire between the shield termination ring and the strain relief clamp.



2448457 S00061545252\_V1

## SHIELD DEAD END OF THE INNER SHIELD - STANDARD CONFIGURATION

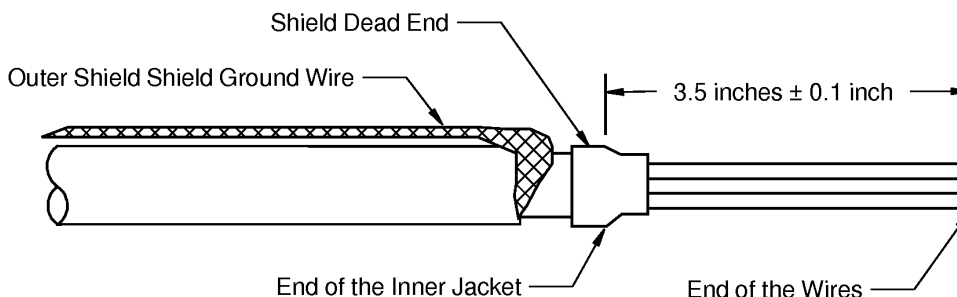
Figure 53



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448550 S00061545253\_V1

#### SHIELD DEAD END OF THE INNER SHIELD - END STRIP CONFIGURATION

Figure 54

#### O. Isolated Shields - Outer Shield End Strip Solder Sleeve, Inner Shield Standard Solder Sleeve Shield Terminations

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary lengths of the outer and inner jackets and shields from the cable.

**NOTE:** If the contact assembly specifies the fold back of the conductor, dimension A and dimension B must be increased by one half of the insulation removal length that is applicable for the wire size and the contact crimp barrel size.

Refer to:

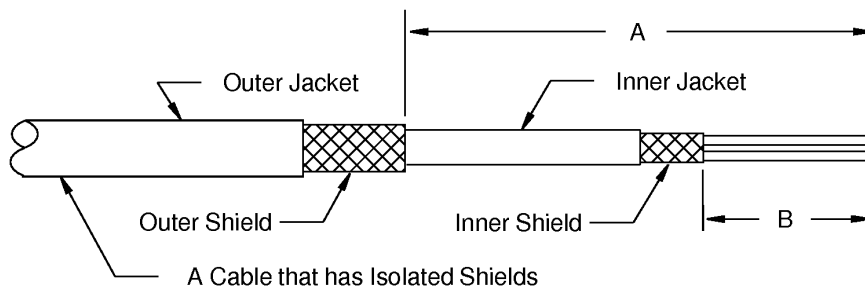
- Figure 55
- Table 23 for the cable jacket removal length when the conductor is not folded back
- Table 24 for the cable jacket removal length when the conductor is folded back
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-15**



## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448509 S00061545254\_V1

#### CABLE PREPARATION - OUTER SHIELD END STRIP AND INNER SHIELD STANDARD CONFIGURATIONS

Figure 55

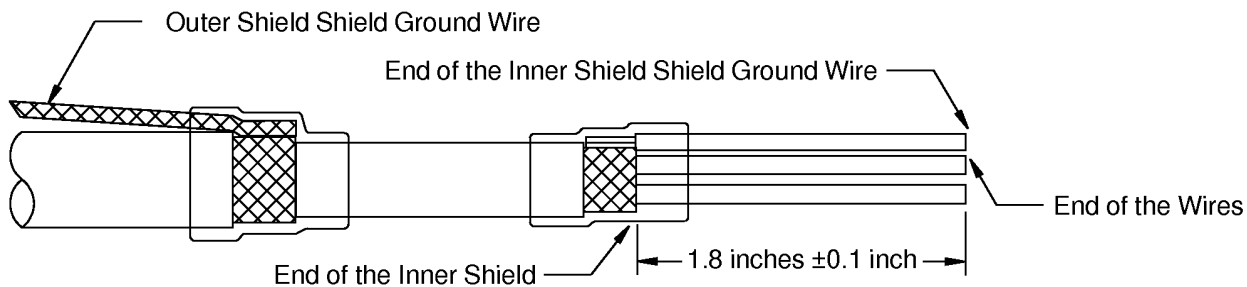
- (2) Assemble the solder sleeve shield ground wires.

Refer to:

- Figure 56
- Subject 20-10-15 for the procedure to assemble the solder sleeve shield ground wires.

Make sure that:

- The shield ground wire of the inner shield is pointed toward from the end of the wire harness
- The shield ground wire of the outer shield is pointed away from the end of the wire harness.



2448551 S00061545255\_V1

#### POSITION OF THE SHIELD GROUND WIRES

Figure 56

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### P. Isolated Shields - Outer Shield End Strip Solder Sleeve, Inner Shield End Strip Solder Sleeve Shield Termination

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

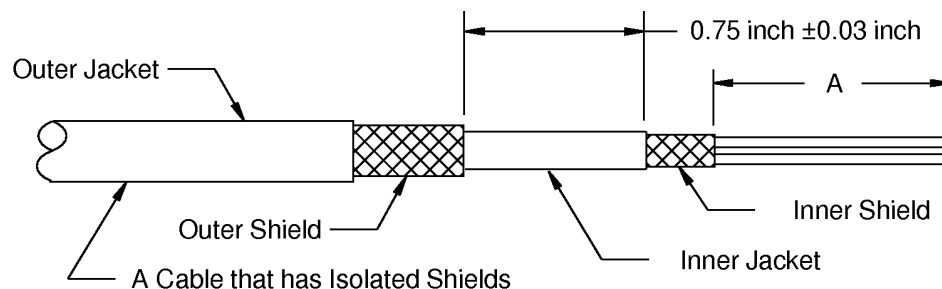
**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary lengths of the outer and inner jackets and shields from the cable.

**NOTE:** If the contact assembly specifies the fold back of the conductor, increase dimension A by one half of the insulation removal length that is applicable for the wire size and the contact crimp barrel size.

Refer to:

- Figure 57
- Table 23 for the cable jacket removal length when the conductor is not folded back
- Table 24 for the cable jacket removal length when the conductor is folded back
- Subject 20-00-15 for the procedure to remove the cable jacket.



2448552 S00061545256\_V1

#### CABLE PREPARATION - OUTER SHIELD END STRIP AND INNER SHIELD STANDARD CONFIGURATIONS

Figure 57

- (2) Assemble the solder sleeve shield ground wires.

Refer to:

- Figure 58
- Subject 20-10-15 for the procedures to assemble a solder sleeve shield ground wire.

Make sure that the shield ground wires are pointed away from the end of the wires of the cable.

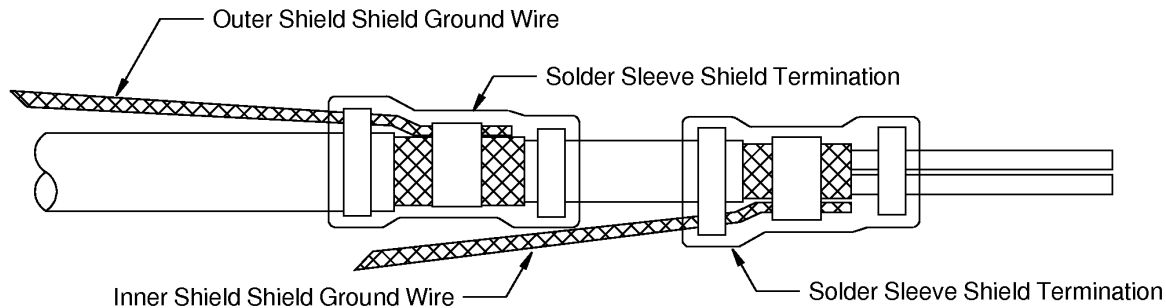
20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448553 S00061545257\_V1

#### POSITION OF THE SOLDER SLEEVE SHIELD GROUND WIRES

Figure 58

**Q. Isolated Shields - Outer Shield End Strip Solder Sleeve, Inner Shield Standard Shield Dead End Shield Terminations**

For the conditions that are applicable for this procedure, refer to Paragraph 4.C..

**NOTE:** If a wire harness is to be reterminated, the repaired configuration must be the same as the initial configuration:

- Shields that were terminated initially, must be terminated.
- Shields that were not terminated initially, must not be terminated.

**CAUTION:** A SHIELD TERMINATION, OR AN ELECTRICAL CONNECTION, BETWEEN THE SHIELD TERMINATION RING, AND A CABLE SHIELD THAT IS NOT SPECIFIED TO BE TERMINATED, CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (1) Remove the necessary lengths of the outer and inner jacket and shield from the cable.

**NOTE:** If the contact assembly specifies the fold back of the conductor, increase dimension A and dimension B by one half of the insulation removal length that is applicable for the wire size and the contact crimp barrel size.

Refer to:

- Figure 59
- Table 23 for the cable jacket removal length when the conductor is not folded back
- Table 24 for the cable jacket removal length when the conductor is folded back
- Subject 20-00-15 for the procedure to remove the cable jacket.

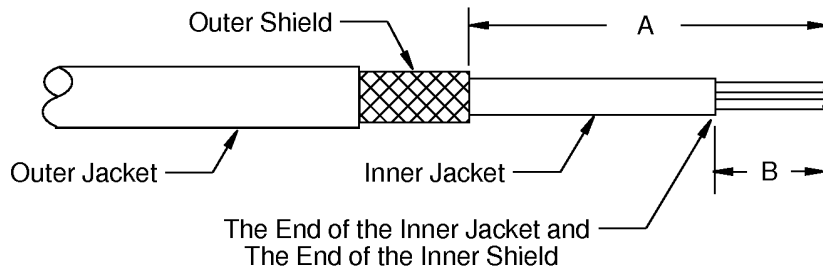
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

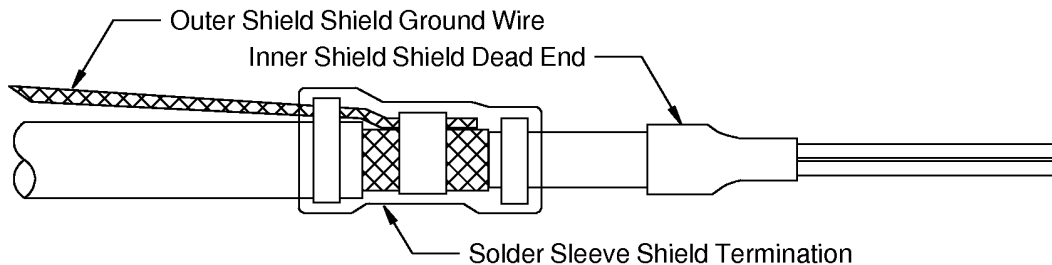


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#### CABLE PREPARATION - OUTER SHIELD END STRIP AND INNER SHIELD DEAD END CONFIGURATIONS

Figure 59

- (2) Assemble a solder sleeve shield ground wire on the outer shield.
- Make sure that the shield ground wire is pointed away from the end of the wire harness.
- Refer to:
- Figure 60
  - Subject 20-10-15 for the procedure to assemble the solder sleeve.



2448511 S00061545259\_V1

#### POSITION OF THE SHIELD GROUND WIRE

Figure 60

- (3) Assemble a shield dead end on end of the inner jacket.
- Refer to:
- Figure 60
  - Subject 20-10-15 for the procedure to assemble the shield dead end.

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### R. Assembly of a Backshell that has a Strain Relief Clamp

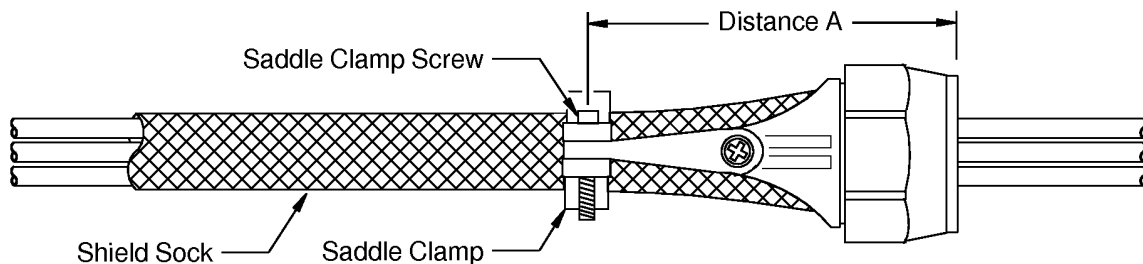
Table 25  
NECESSARY TOOLS

Tool	Description	Supplier
Brush	Fine brush with bristles that are not affected by alcohol	An available source

Table 26  
BACKSHELL ASSEMBLY SCREW TORQUE VALUES

Shell Size		Screw Size	Torque (inch-pound)	
Minimum	Maximum		Minimum	Maximum
8	11	4	4	6
12	28	6	6	8

- (1) Make a selection of a torque tool and a screw bit from Table 6.
- (2) Measure Distance A from the front of the backshell to the center of the saddle clamp screws. Refer to Figure 61.



2448466 S00061545260\_V1

#### LOCATION OF THE PTFE TAPE

Figure 61

- (3) Make a selection of PTFE tape from Table 19.  
Make sure that the temperature grade and the fluid class of the tape is applicable for the location on the airplane.
- (4) Wind two to four layers of the PTFE tape around the diameter of the wire harness at the location on the harness that is equal to Distance A from the rear of the connector coupling ring or connector mounting flange. Refer to Figure 62.

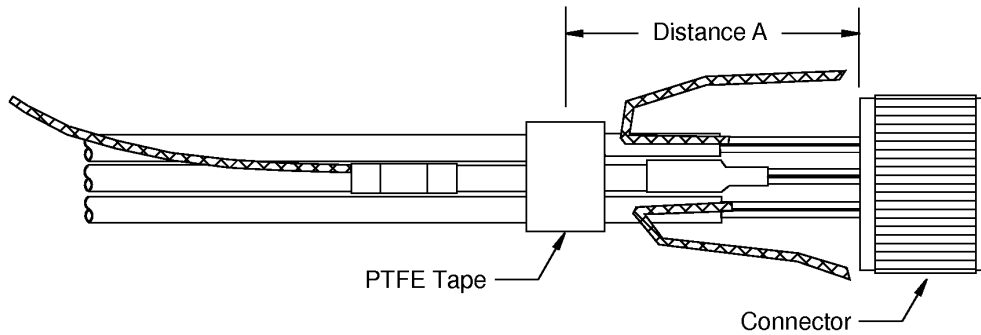
Make sure that:

- The center of the tape is at Distance A
- The tape makes an overlap with itself
- The tape is not on a shield ground wire.

20-25-15

# STANDARD WIRING PRACTICES MANUAL

## ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

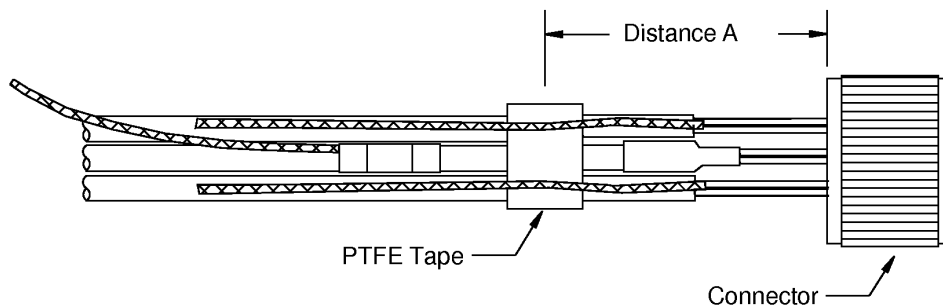


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### POSITION OF THE PTFE TAPE ON THE WIRE HARNESS

Figure 62

- (5) Fold each shield pull through shield ground wire back on the tape. Refer to Figure 63.



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### POSITION OF THE SHIELD PULL THROUGH SHIELD GROUND WIRES ON THE PTFE TAPE

Figure 63

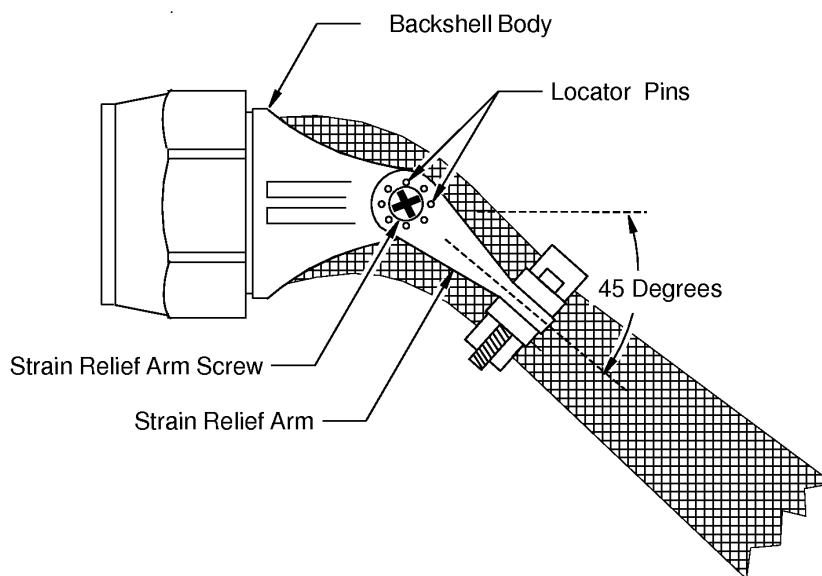
**20-25-15**

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (6) If a 45 degree or a 90 degree angle of strain relief arm of the backshell is specified, adjust the angle of the strain relief arms. Refer to Figure 64.

**CAUTION:** IF A 45 DEGREE OR A 90 DEGREE ANGLE FOR THE STRAIN RELIEF ARMS OF THE BACKSHELL IS NECESSARY, THE STRAIN RELIEF ARMS OF THE BACKSHELL MUST BE PUT IN THE SPECIFIED POSITION BEFORE THE STRAIN RELIEF CLAMP IS ASSEMBLED. UNSATISFACTORY PERFORMANCE OF THE SHIELD SOCK CAN OCCUR.



2448482 S00061545264\_V1

#### 45 DEGREE POSITION OF THE STRAIN RELIEF ARMS

Figure 64

- (a) Loosen the strain relief arm screws on the two sides of the strain relief arms.  
Make sure that:
  - The saddle clamp screws are loose
  - The strain relief arm screws are not fully removed.
- (b) At the same time, pull the backshell arms apart until the locator pins are released.  
**NOTE:** If the locator pins cannot be released, the screws can be loosened more.
- (c) Adjust the position of the arm to the specified angle and release the side of the arm.  
Make sure that the locator pins on the arms are engaged in the backshell body.  
**NOTE:** Each hole position for the locator-pins on the backshell body is equal to 45-degrees.
- (d) Torque the strain relief arm screws.  
Refer to:
  - Figure 64 for the location of the strain relief arm screws

**20-25-15**

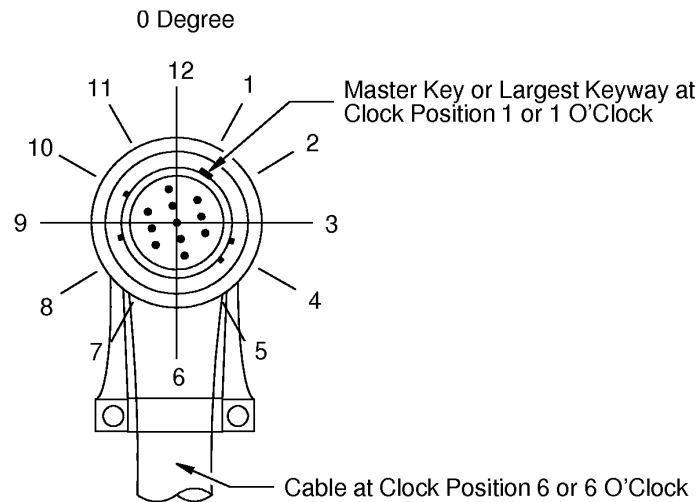


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- Figure 3 through Figure 6 to find the shell size of the backshell
  - Table 26 for the screw size and torque value.
- (7) Put the Master Key or Keyway of the connector in the specified clock position:  
Refer to Figure 65:



2448469 S00061545265\_V1

#### 1 O'CLOCK POSITION OF THE CONNECTOR AND THE BACKSHELL

Figure 65

- (a) For a backshell with a 45 degree or a 90 degree angle of the strain relief arms, hold the backshell and the wire harness in the 6 o'clock position  $\pm$  the specified tolerance.

**NOTE:** If the tolerance is not specified, put the strain relief arm in the 6 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees.

- (b) Put the Master Key or Keyway of the connector in the specified clock position in relation to the 6 o'clock wire harness position.

**NOTE:** If the clock position is not specified, put the master key or keyway of the connector in the clock position that restores the backshell to its initial orientation.

**CAUTION:** DO NOT TURN THE CONNECTOR MORE THAN 180 DEGREES. DAMAGE TO THE WIRE HARNESS CAN OCCUR.

- (8) Clean the threads of the backshell and the connector.
- (a) Make a selection of these materials from Subject 20-00-11:
- A solvent
  - A canned air.
- NOTE:** An equivalent canned air is a satisfactory alternative.

**20-25-15**



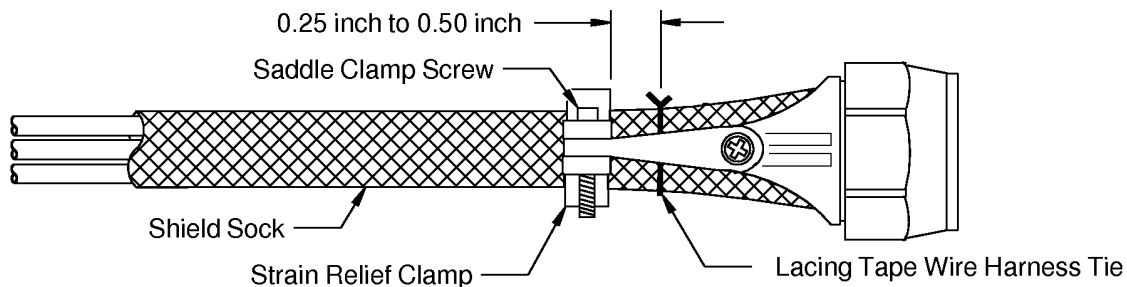


707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (b) Make a selection of a brush from Table 25.
- (c) Apply a sufficient quantity of solvent with the brush to clean the threads of the backshell and the connector.
- (d) Let the threads of the backshell and the connector dry for approximately 30 seconds.
- (9) Engage the threads of the backshell and the connector.  
Make sure that the connector teeth and the backshell teeth are engaged.
- (10) Install the backshell on the connector.  
Refer to:
- Figure 3 through Figure 6 for the shell size of the backshell
  - Paragraph 5.A. for the procedure to install the backshell.
- Make sure that the strain relief arms are in the correct position in relation to the clock position of the master keyway of the connector.
- (11) Fully extend the shield sock rearward along the wire harness.  
Make sure that the shield sock does not have a vertical, horizontal, or diagonal separation of the strands that is larger than 0.13 inch.
- (12) Wind the necessary layers of Type I silicone tape on the shield sock to increase the diameter where the strain relief clamp holds the wire harness.  
Make sure that the tape is not put on the bend of the jumper wire.
- NOTE:** The diameter of the wire harness must be sufficient for the strain relief clamp to hold the wire harness tightly.
- (13) Assemble a lacing tape wire harness tie on the shield sock 0.25 inch to 0.50 inch forward of the strain relief clamp of the backshell. Refer to Figure 66.  
Make sure that the shield sock does not have a vertical, horizontal, or diagonal separation of the strands that is larger than 0.13 inch.



2448514 S00061545267\_V1

#### POSITION OF THE LACING TAPE WIRE HARNESS TIE ON THE SHIELD SOCK

Figure 66

- (14) Put the saddle bar that has the captive fasteners on the wire harness and the legs of the backshell.  
Make sure that sleeves of the captive fasteners are in the holes of the legs.
- (15) Align the holes of the remaining saddle bar with the holes in the legs.

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (16) Engage the threads of each saddle clamp screw and the captive fasteners.
- (17) Tighten a saddle clamp screw on one side of the saddle bar with the hand.
- (18) Tighten the saddle clamp screw on the other side of the saddle bar with the hand.

Make sure that:

- The ends of the saddle bars are fully against the legs of the backshell
- The saddle bars are against the wire harness
- The shield sock does not have a vertical, horizontal, or diagonal separation of the strands that is larger than 0.13 inch.

**CAUTION:** DO NOT FULLY TIGHTEN ONE SCREW IF THE OTHER SCREW IS NOT INSTALLED. DAMAGE TO THE STRAIN RELIEF CLAMP CAN OCCUR.

- (19) If the ends of the saddle bars are not fully against the legs of the backshell:
  - (a) Remove the saddle bars.
  - (b) Put one spacer on each side of the saddle bar that has the captive fasteners.
  - (c) Do Step 4.R.(14) through Step 4.R.(18) again.
- (20) Torque the saddle clamp screws.

Refer to:

- Figure 3 through Figure 6 to find the shell size of the backshell
- Table 26 for the torque values.

Make sure that:

- The wire harness does not move in the saddle bars
- The shield sock does not have a vertical, horizontal, or diagonal separation of the strands that is larger than 0.13 inch
- Each screw extends a minimum of one thread from the captive fastener
- Each screw does not extend more than 0.25 inch from the captive fastener.

#### **S. Wire Harness Preparation for the Assembly of a Backshell That Has a Strain Relief Boot**

- (1) For a wire harness with a shield pull through shield ground wires:
  - (a) Wind two to three layers of PTFE tape on the wire harness at the end of the cable jacket. Refer to Figure 67.

Make sure that:

- The forward edge of the tape is not more than 0.20 inch from the end of the cable jacket
- The tape makes an overlap with itself
- The tape is not on a shield ground wire.

- (b) Fold each shield ground wire back on the tape. Refer to Figure 67.

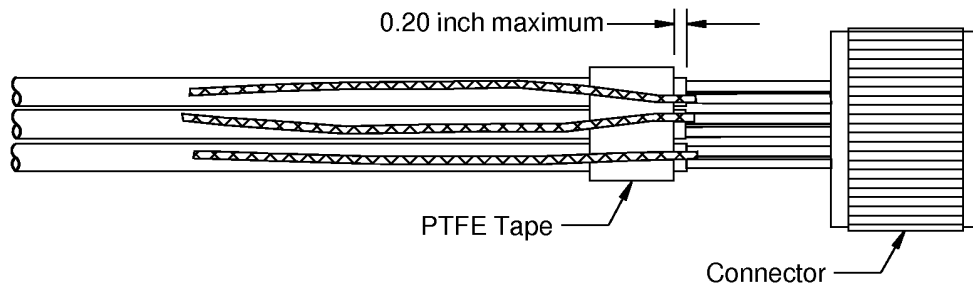
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448470 S00061545269\_V1

#### POSITION OF THE TAPE ON THE WIRE HARNESS

Figure 67

- (2) Push the backshell forward until it is against the rear of the connector.

**NOTE:** If the diameter of the shield termination ring is smaller than the inside diameter of the backshell, the backshell can be assembled after the shield ground wire termination to make the assembly easier.

- (3) Clean the threads of the backshell and the connector.

- (a) Make a selection of these materials from Subject 20-00-11:

- A solvent
- A canned air.

**NOTE:** An equivalent canned air is a satisfactory alternative.

- (b) Make a selection of a brush from Table 25.
  - (c) Apply a sufficient quantity of solvent with the brush to clean the threads of the backshell and the connector.
  - (d) Let the threads of the backshell and the connector dry for approximately 30 seconds.
- (4) Engage the threads backshell and the connector.  
Make sure that the connector teeth and the backshell teeth are engaged.
  - (5) Install the backshell on the connector. Refer to Paragraph 5.A..  
Refer to Figure 3 through Figure 6 to find the shell size of the backshell.

#### T. Assembly of the Shield Termination Ring

- (1) If a shield termination ring is not specified, make a selection of a shield termination ring from Table 2.

Make sure that the shield termination ring is the smallest size that will allow the wire harness, its tape layer, and the guard wire or ground connection wire to go through the ring after the ring is installed.

- (2) Push the end of the shield sock forward until the end of the sock is between the strain relief arms of the backshell.
- (3) Wind a minimum of one layer of Type I silicone tape around the wire harness at the location of the shield termination ring.

Refer to:

**20-25-15**

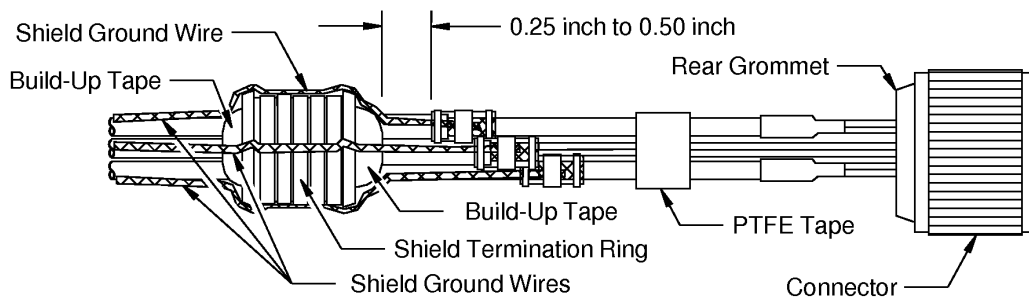
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- Figure 68 for the configuration with solder sleeve shield ground wires
- Figure 69 for the configuration with shield pull through shield ground wires without an end strip shield termination
- Figure 70 for the configuration with shield pull through shield ground wires with one or more end strip shield terminations
- Figure 71 for the configuration with solder sleeve and shield pull through shield ground wires
- Figure 72 for the configuration with a splice area between the strain relief clamps and the shield termination ring
- Figure 73 for the configuration with shield pull through shield ground wires and a protective sleeve.

Make sure that:

- The edges of the tape are approximately aligned
- The tape is not on a shield ground wire
- The tape is not located on the bend of the jumper wire.



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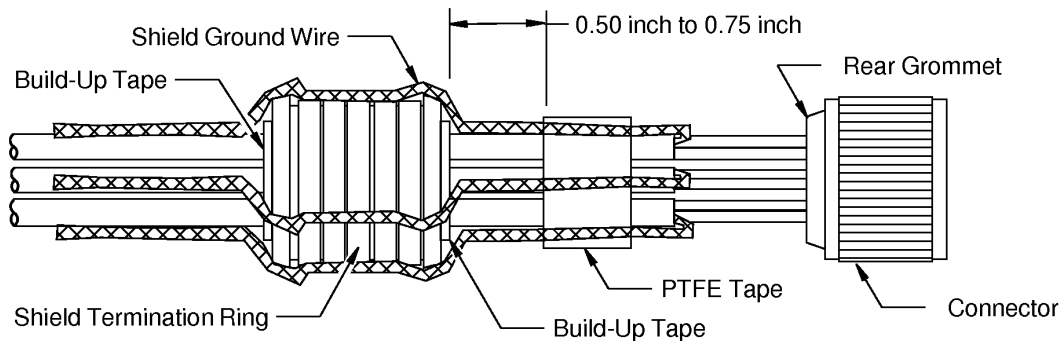
#### SHIELD TERMINATION RING - SOLDER SLEEVE SHIELD GROUND WIRES

Figure 68

20-25-15

## STANDARD WIRING PRACTICES MANUAL

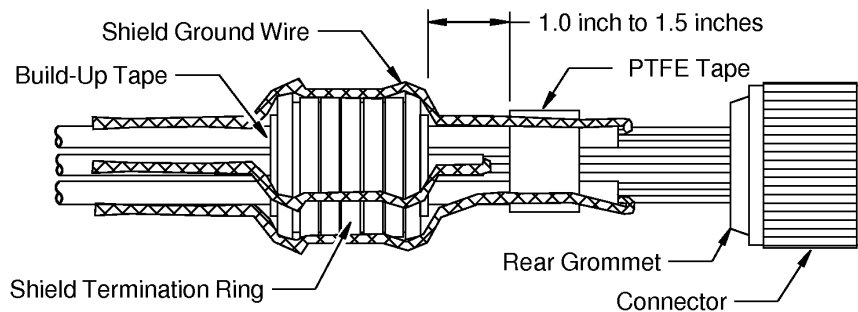
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



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#### SHIELD TERMINATION RING - SHIELD PULL THROUGH SHIELD GROUND WIRES WITHOUT AN END STRIP SHIELD TERMINATION

Figure 69



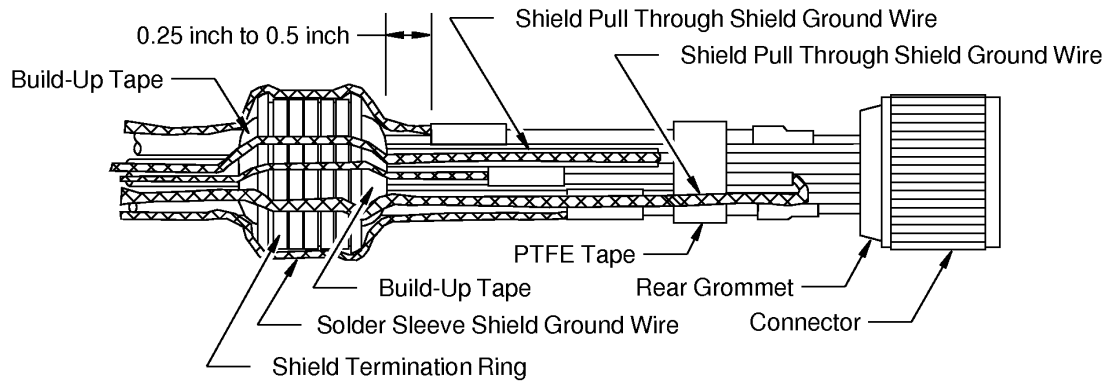
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#### SHIELD TERMINATION RING - SHIELD PULL THROUGH SHIELD GROUND WIRES WITH ONE OR MORE END STRIP SHIELD TERMINATIONS

Figure 70

**20-25-15**

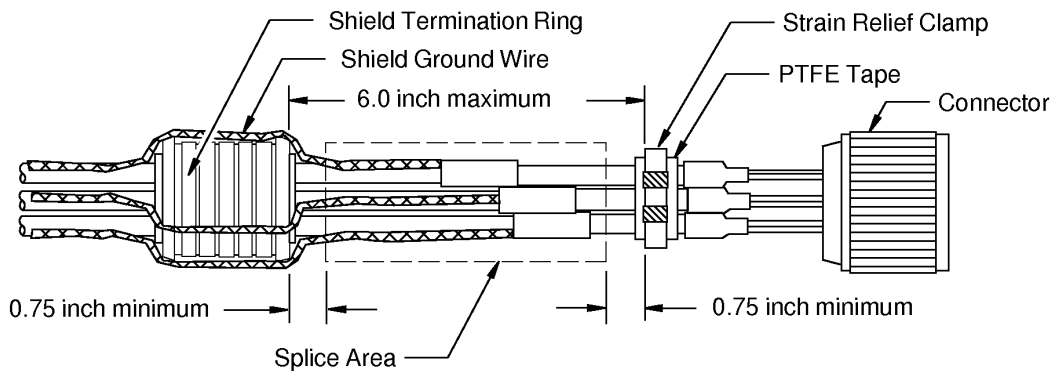
ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



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SHIELD TERMINATION RING - SOLDER SLEEVE AND SHIELD PULL THROUGH SHIELD GROUND WIRES

Figure 71



2448474 S00061545274\_V1

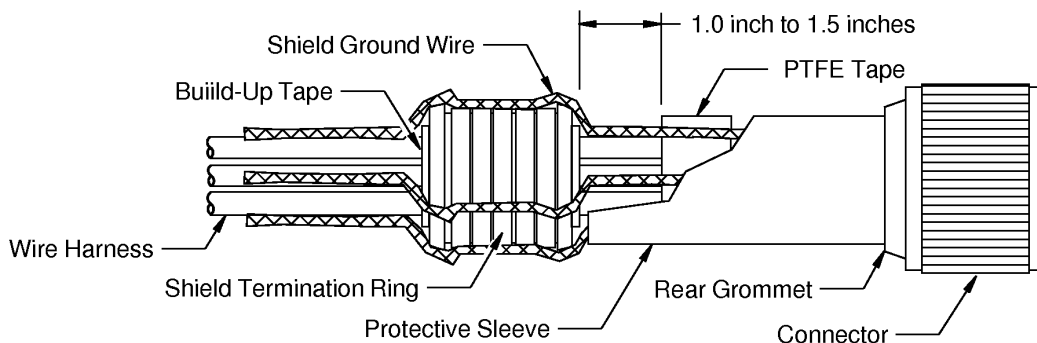
SHIELD TERMINATION RING - SPLICE ASSEMBLY BETWEEN THE STRAIN RELIEF AND THE TERMINATION RING

Figure 72

20-25-15

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448516 S00061545275\_V1

#### SHIELD TERMINATION RING - SHIELD PULL THROUGH SHIELD GROUND WIRES AND A PROTECTIVE SLEEVE

Figure 73

- (4) For a wire harness with guard wire or ground connection wire, put each guard wire or ground connection wire shield ground wire against the layer of tape.  
Make sure that the shield ground wires do not go across each other.
- (5) Assemble the two halves of the shield termination ring on the center of the silicone tape.  
Make sure that:
  - A minimum of one side of the shield termination ring has a key and key hole that does not have damage
  - The shield ground wire of a guard wire, a ground connection wire, or an equipment ground wire is between the tape and the shield termination ring
  - The other shield ground wires are not between the tape and the shield termination ring
  - The keys of one half are aligned with the keyholes of the other half
  - The shield termination ring is fully closed
  - The shield termination ring does not move on the wire harness.

**NOTE:** The shield termination ring makes a click when it is assembled correctly.

- (6) If the tape does not prevent the movement of the shield termination ring, wind more layers of the tape on the harness.

Make sure that:

- The keys of one half are aligned with the keyholes of the other half
- The shield termination ring is fully closed

**20-25-15**



707, 727-787

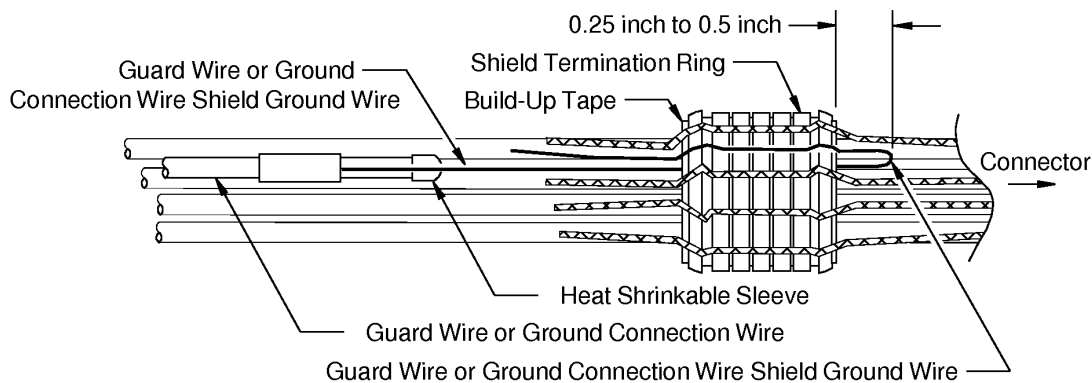
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- The shield termination ring does not move on the wire harness
  - The shield ground wires are not between the tape and the shield termination ring.
- (7) Put the shield ground wires on the shield termination ring at approximately equal intervals. Make sure that the shield ground wires do not go across each other.
- (8) For a wire harness that has a guard wire, a ground connection wire, or an equipment ground wire:
- (a) Fold each shield ground wire back on the shield termination ring. Refer to Figure 74 and Figure 75.

Make sure that:

- The fold of the shield ground wire is 0.25 inch to 0.5 inch forward from the shield termination ring
- Each shield ground wire does not go across a different shield ground wire.



2448512 S00061545276\_V1

#### POSITION OF A GUARD WIRE OR A GROUND CONNECTION WIRE SHIELD GROUND WIRE

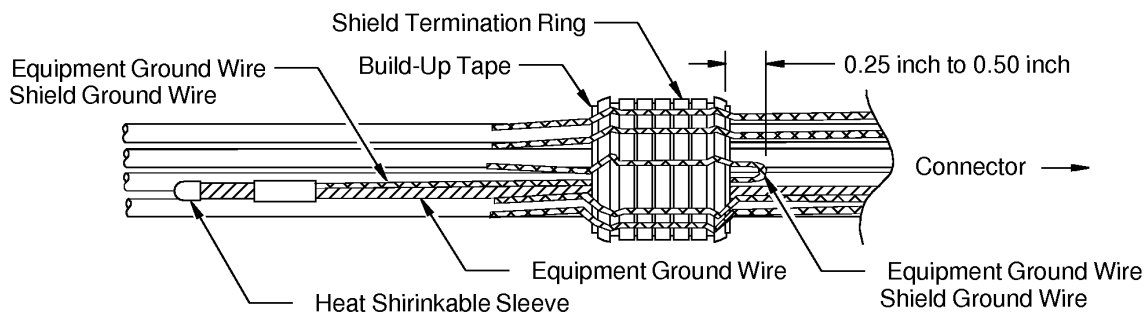
Figure 74

20-25-15



## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449170 S00061545277\_V1

#### POSITION OF AN EQUIPMENT GROUND WIRE SHIELD GROUND WIRE

Figure 75

- (b) Wind 2 to 3 layers of PTFE tape on the folded shield ground wires and the wire harness. Refer to Figure 76.

Make sure that the distance between the build-up tape and the PTFE tape is not more than 0.03 inch.

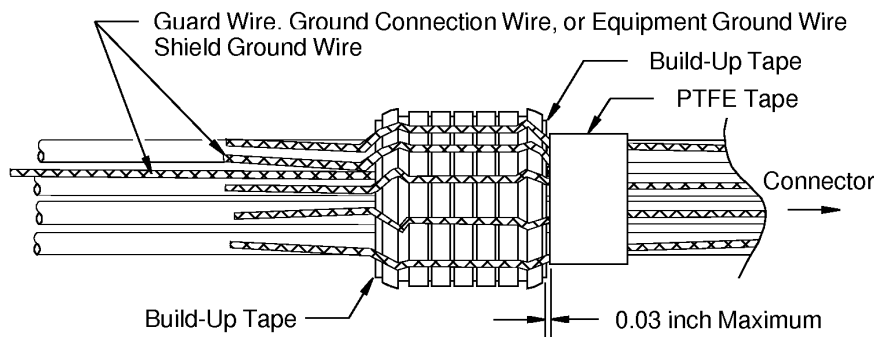
**NOTE:** PTFE tape on shield ground wires that are not a guard wire, a ground connection wire, or an equipment ground wire shield ground wire is not necessary.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2450285 S00061545278\_V1

#### POSITION OF THE TAPE ON A GUARD WIRE, A GROUND CONNECTION WIRE, OR AN EQUIPMENT GROUND WIRE SHIELD GROUND WIRE

Figure 76

- (9) Wind 2 to 4 layers of PTFE tape on the end of the shield ground wires and the wire harness.

Refer to:

- Figure 77 for the configuration of the wire harness shield ground wires
- Figure 78 for the configuration of a guard wire or a ground connection wire shield ground wire
- Figure 79 for the configuration of an equipment ground wire shield ground wire.

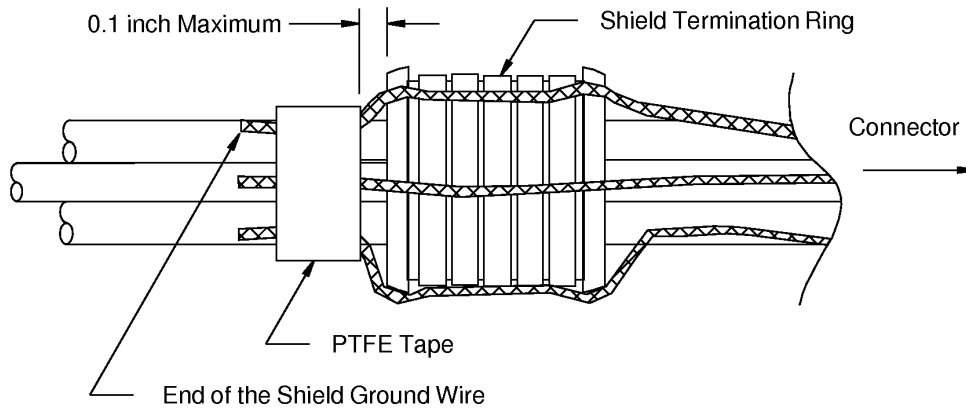
Make sure that:

- The tape does not make an overlap with the shield termination ring
- The layers of tape make an approximately 100 percent overlap
- The shield ground wires are not loose.

**20-25-15**

# STANDARD WIRING PRACTICES MANUAL

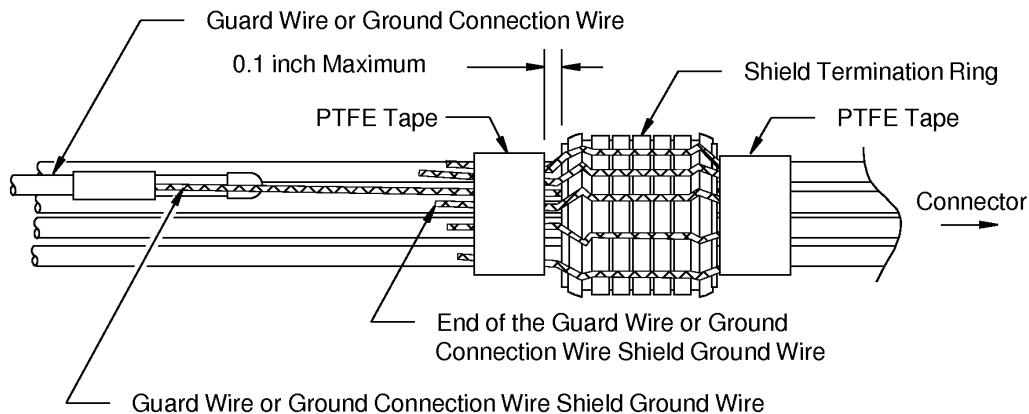
## ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448475 S00061545279\_V1

### POSITION OF THE TAPE ON THE SHIELD GROUND WIRES

Figure 77



2448517 S00061545280\_V1

### POSITION OF THE TAPE ON A GUARD WIRE OR GROUND CONNECTION WIRE SHIELD GROUND WIRE

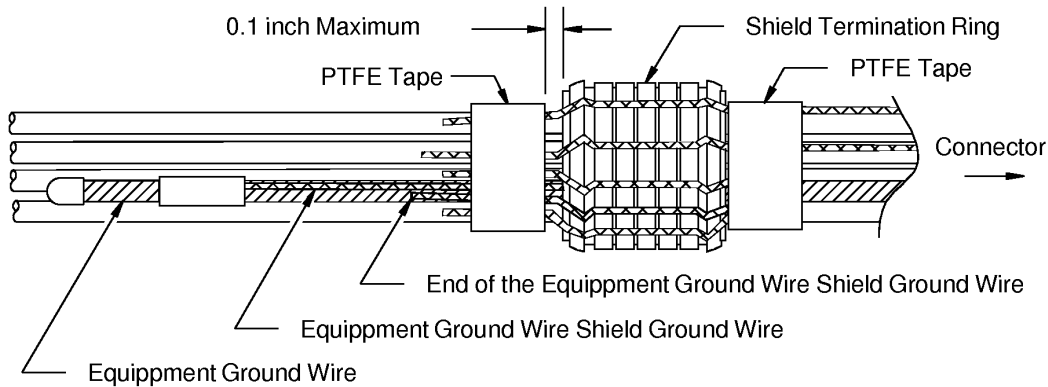
Figure 78



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449171 S00061545281\_V1

#### POSITION OF THE TAPE ON AN EQUIPMENT GROUND WIRE SHIELD GROUND WIRE

Figure 79

- (10) Remove the unwanted length from the end of the shield ground wires. Refer to Figure 80.

Make sure that:

- The end of the shield ground wire does not extend farther than 0.2 inch from the rear end of the tape
- The shield ground wires are not loose.

**20-25-15**

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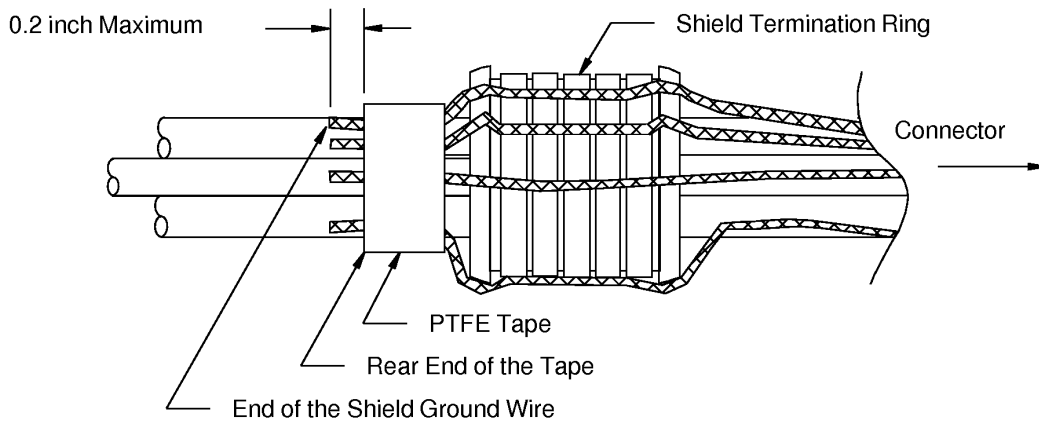
Page 73  
Oct 15/2015



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449172 S00061545282\_V1

#### POSITION OF THE END OF THE SHIELD GROUND WIRES

Figure 80

#### U. Shield Sock Termination for a Backshell with a Strain Relief Clamp

- (1) Fully extend the shield sock rearward on the shield termination ring and the wire harness.  
Make sure that the shield sock does not have a vertical, horizontal, or diagonal separation of the strands that is larger than 0.13 inch.
- (2) Install a shield terminator band on the shield sock at the center of the shield termination ring.  
Refer to Subject 20-25-14.
- (3) Wind 1 to 2 layers of 0.5 inch wide PTFE tape around the shield terminator band. Refer to Figure 81.

Make sure that:

- The center of the tape is aligned with the center of the band
- The first layer of tape starts approximately 0.25 inch from the buckle of the band
- The last layer of tape extends approximately 0.25 inch from the buckle of the band
- The edges of the tape are approximately aligned
- The surface of the band cannot be seen

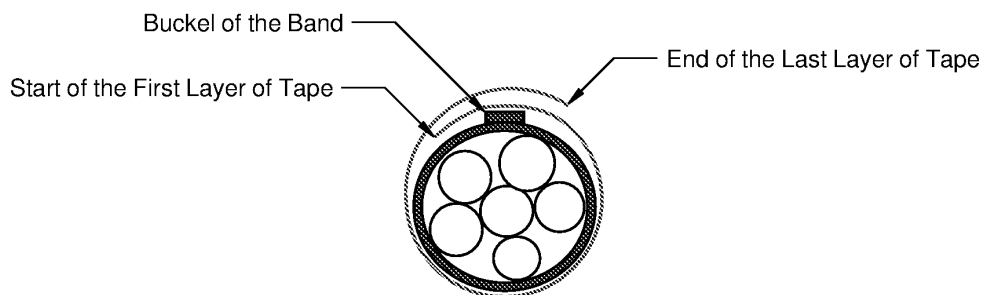
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449897 S00061545283\_V1

#### POSITION OF THE LAYERS OF PTFE TAPE

Figure 81

- (4) Assemble a lacing tape wire harness tie on the end of the shield sock at the necessary location to fold the shield sock forward 1.0 inch  $\pm$ 0.2 inch from the rear end of the shield termination ring.

Refer to:

- Figure 82.
- Subject 20-10-11 for the procedure to assemble the lacing tape wire harness tie.

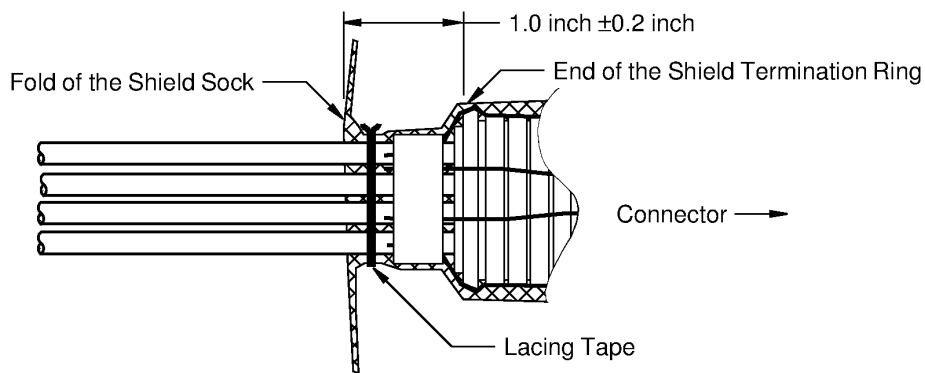
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449898 S00061545284\_V1

#### POSITION OF THE LACING TAPE ON THE WIRE HARNESS

Figure 82

- (5) Fold the loose end of the shield sock forward toward the shield termination ring. Refer to Figure 83.

Make sure that:

- The rear end of the fold of the shield sock is not farther than 1.0 inch  $\pm$ 0.2 inch from the rear end of the shield termination ring
- The end of the folded shield sock is flat against the wire harness or the wire harness and the shield termination ring.

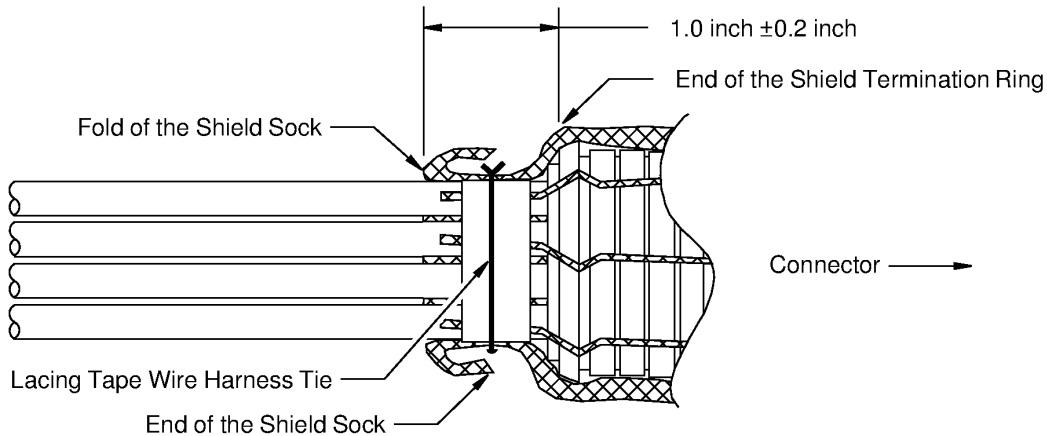
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449899 S00061545285\_V1

#### FOLD OF THE SHIELD SOCK

Figure 83

- (6) If the loose end of the shield sock does not extend farther than the forward edge of the buckle of the shield terminator band on the shield termination ring, wind 1 to 2 more layers of 0.5 inch wide PTFE tape on the PTFE tape that is on the shield terminator band. Refer to Figure 81.

Make sure that:

- The center of the tape is aligned with the center of the band
- The first layer of the tape starts approximately 0.25 inch from the forward end of the buckle of the band
- The last layer of the tape extends approximately 0.25 inch from the buckle of the band
- The edges of the tape are approximately aligned.

- (7) Wind a layer of Type II silicone tape around the wire harness on the folded end of the shield sock.

Refer to:

- Figure 84 for the tape on a wire harness without shield ground wires on the rear end of the fold of the shield sock
- Figure 85 for the tape on a wire harness with shield ground wires from the rear end of fold of the shield sock.

Make sure that:

- The tape extends 0.50 inch  $\pm$ 0.25 inch farther than the end of the shield sock
- The tape makes approximately a 50 percent overlap with itself

**20-25-15**





707, 727-787

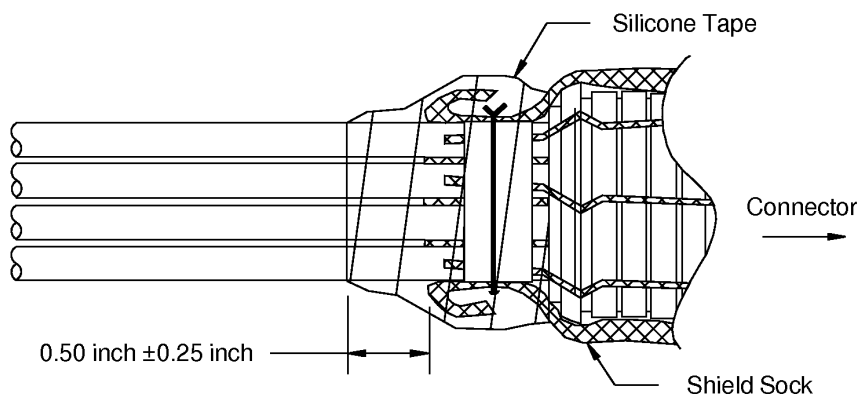
## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- The tape makes approximately a 100 percent overlap at the end.

**NOTE:** If the loose end of the shield sock does not extend farther than the forward edge of the buckle of the shield terminator band, a continuous layer of Type II silicone tape from the folded end of the shield sock to the forward edge of the layer of PTFE tape on the shield terminator band is a satisfactory alternative Refer to Step 4.U.(8).

**NOTE:** If the loose end of the shield sock extends farther than the forward edge of the buckle of the shield terminator band, a continuous layer of Type II silicone tape from the folded end of the shield sock to the forward edge loose end of the shield sock is a satisfactory alternative. Refer to Step 4.U.(8)



2450286 S00061545286\_V1

### SILICONE TAPE AROUND THE WIRE HARNESS WITHOUT A GUARD WIRE, A GROUND CONNECTION WIRE, OR AN EQUIPMENT GROUND WIRE

Figure 84

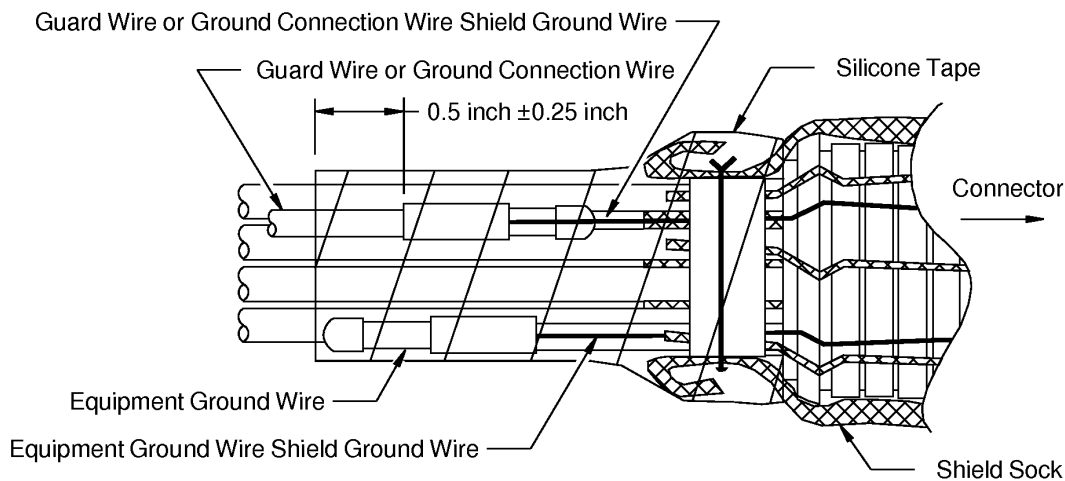
20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448513 S00061545287\_V1

#### SILICONE TAPE AROUND THE WIRE HARNESS WITH A GUARD WIRE, A GROUND CONNECTION WIRE, OR AN EQUIPMENT GROUND WIRE

Figure 85

- (8) Wind 2 to 3 layers of 1 inch wide Type I silicone tape on the shield termination ring at the location of the shield terminator band.

Refer to:

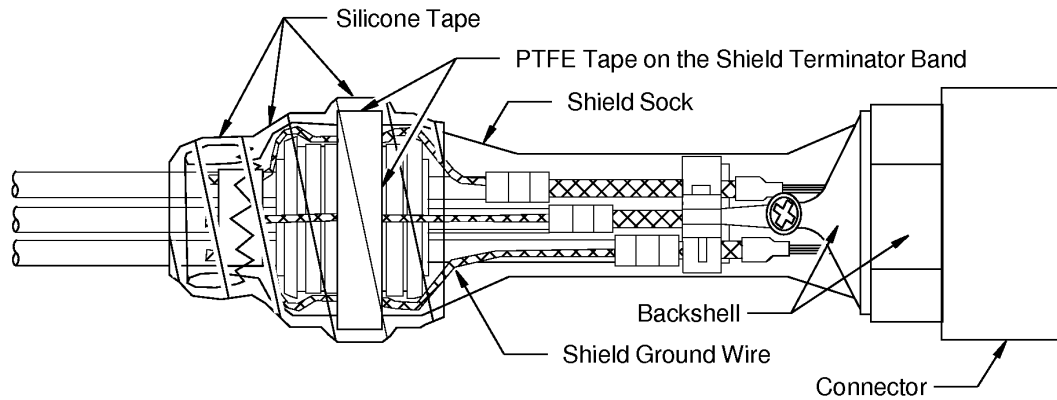
- Figure 86 for the configuration of the silicone tape on the shield terminator band with solder sleeve shield ground wires
- Figure 87 for the configuration of the silicone tape on the shield terminator band with shield pull through shield ground wires.

Make sure that:

- The surface of the band cannot be seen
- The tape makes a 0.25 inch minimum overlap with the loose end of the shield sock.

**20-25-15**

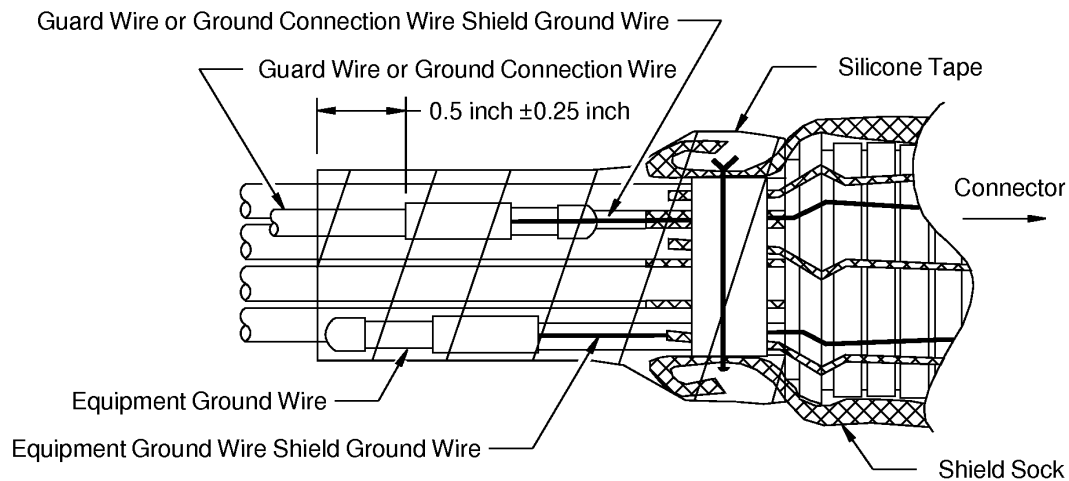
ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE  
A BRAIDED SHIELD SOCK



2448476 S00061545288\_V1

TAPE LAYERS ON THE SHIELD TERMINATOR BAND - SOLDER SLEEVE SHIELD GROUND WIRES

Figure 86



2448513 S00061545287\_V1

TAPE LAYERS ON THE SHIELD TERMINATOR BAND - SHIELD PULL THROUGH SHIELD GROUND  
WIRES

Figure 87



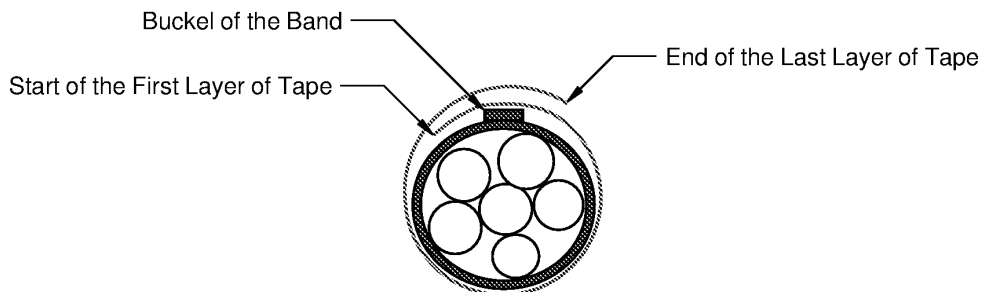
707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

#### V. Shield Sock Termination for a Backshell with a Strain Relief Boot

- (1) Fully extend the shield sock rearward on the shield termination ring and the wire harness.  
Make sure that the shield sock does not have a vertical, horizontal, or diagonal separation of the strands that is larger than 0.13 inch.
- (2) Install a shield terminator band on the shield sock at the center of the shield termination ring. Refer to Subject 20-25-14.
- (3) Wind 1 to 2 layers of 0.5 inch wide PTFE tape on the shield terminator band. Refer to Figure 88  
Make sure that:
  - The center of the tape is aligned with the center of the band
  - The first layer of tape starts approximately 0.25 inch from the buckle of the band
  - The last layer of tape extends approximately 0.25 inch from the buckle of the band
  - The edges of the tape are approximately aligned
  - The surface of the band cannot be seen.



2449897 S00061545283\_V1

#### POSITIONS OF THE LAYERS OF PTFE TAPE

Figure 88

- (4) Assemble a lacing tape wire harness tie on the shield sock at necessary location to fold the shield sock forward 1.0 inch  $\pm$  0.2 inch from the rear end of the shield termination ring.

Refer to:

- Figure 89
- Subject 20-10-11 for the procedure to assemble a lacing tape wire harness tie.

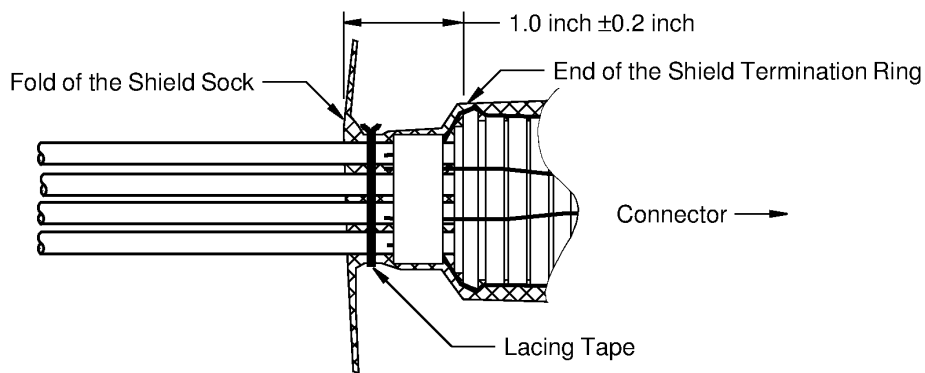
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449898 S00061545284\_V1

#### POSITION OF THE LACING TAPE TIE ON THE WIRE HARNESS

Figure 89

- (5) Fold the loose end of the shield sock forward toward the shield termination ring. Refer to Figure 90

Make sure that:

- The rear end of the fold of the shield sock is not farther than 1.0 inch  $\pm$ 0.2 inch from the rear end of the shield termination ring.
- The end of the folded shield sock is flat against the wire harness or the wire harness and the shield termination ring.

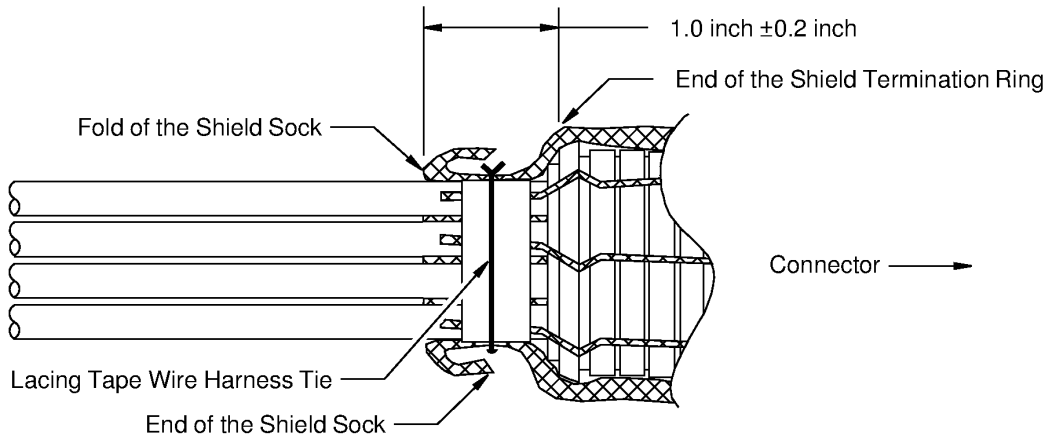
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2449899 S00061545285\_V1

#### FOLD OF THE SHIELD SOCK

Figure 90

- (6) If the loose end of the shield sock does not extend farther than the forward edge of the buckle of the shield terminator band on the shield termination ring, wind 1 to 2 more layers of 0.5 inch wide PTFE tape on the PTFE tape that is on the shield terminator band. Refer to Figure 88.

Make sure that:

- The center of the tape is aligned with the center of the band
- The first layer of the tape starts approximately 0.25 inch from the forward end of the buckle of the band
- The last layer of the tape extends approximately 0.25 inch from the buckle of the band
- The edges of the tape are approximately aligned.

- (7) Wind a layer of Type II silicone tape around the wire harness on the folded end of the shield sock. Refer to Figure 91 for the tape on a wire harness without shield ground wires on the rear end of the fold of the shield sock.

Make sure that:

- The tape extends 0.50 inch  $\pm$ 0.25 inch farther than the end of the shield sock
- The tape makes approximately a 50 percent overlap with itself
- The tape makes approximately a 100 percent overlap at the end.

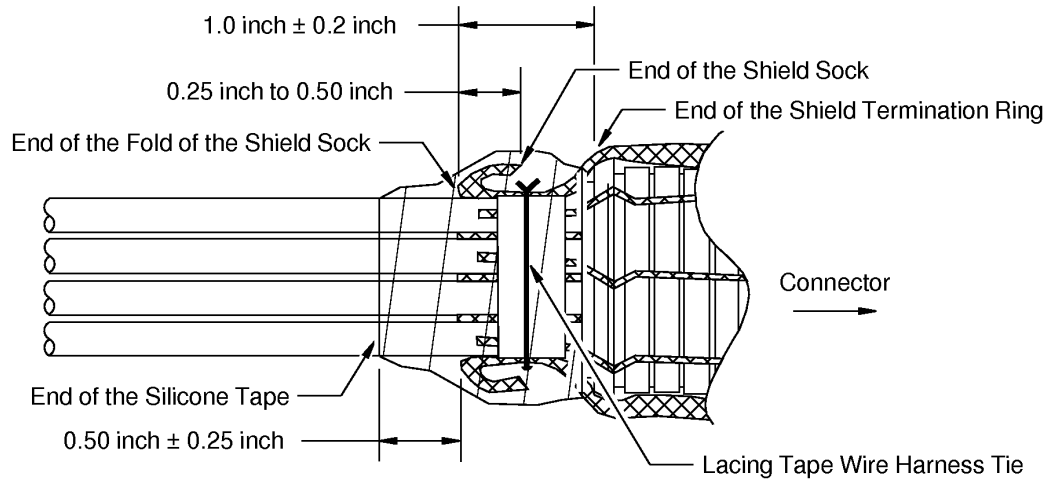
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448518 S00061545289\_V1

#### POSITION OF THE TAPE ON A WIRE HARNESS WITHOUT SHIELD GROUND WIRES FROM THE REAR END OF THE SHIELD SOCK

Figure 91

#### W. Installation of a Heat Shrinkable Strain Relief Boot

- (1) Push the strain relief boot forward until the forward end of the boot is against the rear of the backshell.
- (2) Align the lip of the boot with the slot in backshell. Refer to Figure 92.

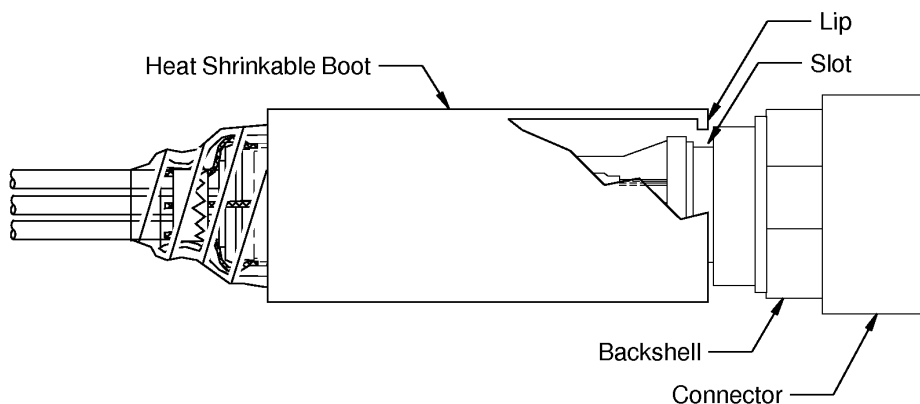
20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448477 S00061545290\_V1

#### POSITION OF THE STRAIN RELIEF BOOT AGAINST THE BACKSHELL

Figure 92

- (3) Put the Master Key or Keyway of the connector in the specified clock position in relation to the 6 o'clock wire harness position. Refer to Figure 93.

**NOTE:** If the clock position is not specified, put the master key or keyway of the connector in the clock position that restores the backshell to its initial orientation.

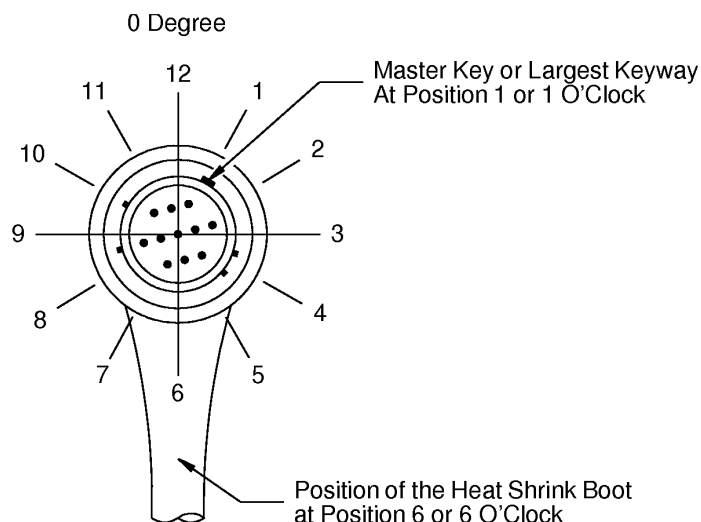
**CAUTION:** DO NOT TURN THE CONNECTOR MORE THAN 180 DEGREES. DAMAGE TO THE WIRE HARNESS CAN OCCUR.

**20-25-15**



## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448478 S00061545291\_V1

#### ONE O'CLOCK POSITION OF THE CONNECTOR AND THE BACKSHELL

Figure 93

- (4) For a backshell with a 45 degree or a 90 degree angle of the strain relief, put the heat shrinkable boot in the 6 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees. Refer to Figure 93.

Make sure that the bump in the boot at the rear of the backshell is in the 12 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees to make the bundle turn down to the 6 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees.

- (5) Shrink the boot into its position.

Make sure the lip of the boot stays in the groove of the backshell.

Refer to:

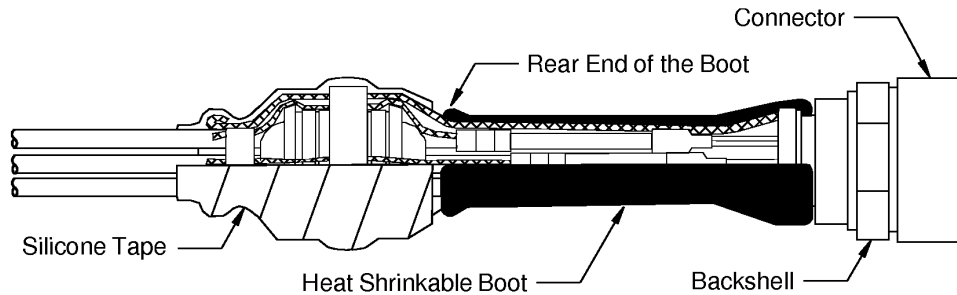
- Figure 94
- Figure 95
- Subject 20-10-14 for the procedure to shrink the boot.

**NOTE:** It is satisfactory if the location of the end of the boot on the shield termination ring assembly is different than the location that is shown in Figure 94 and Figure 95.

**NOTE:** The boot can be turned manually around the backshell and the wire harness.

## STANDARD WIRING PRACTICES MANUAL

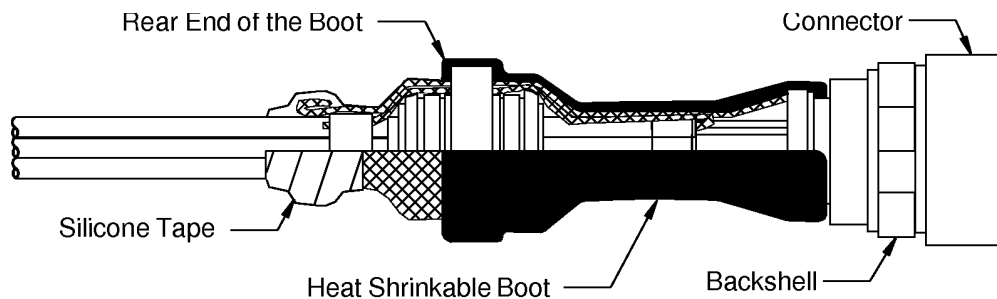
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448479 S00061545292\_V1

#### STRAIN RELIEF BOOT INSTALLATION - SOLDER SLEEVE SHIELD GROUND WIRES

Figure 94



2448480 S00061545293\_V1

#### STRAIN RELIEF BOOT INSTALLATION - SHIELD PULL THROUGH SHIELD GROUND WIRES

Figure 95

- (6) Put a layer of Type II silicone tape on the strain relief boot and the wire harness. Refer to Figure 96.

Make sure that the tape:

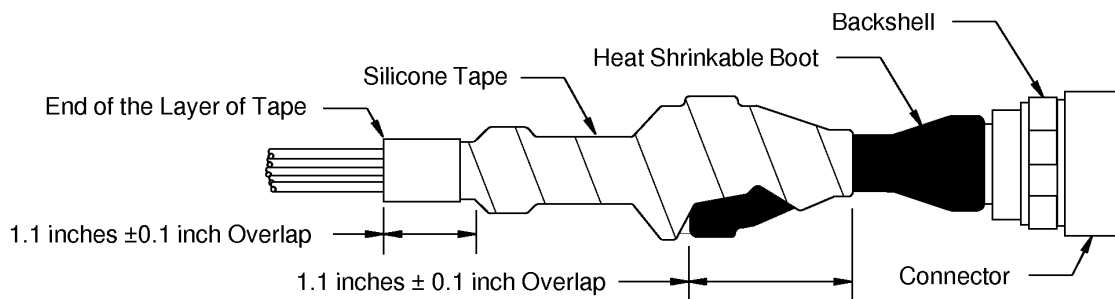
- Starts 1.1 inch  $\pm$  0.1 inch from the end of the strain relief boot
- Stops 1.1 inch  $\pm$  0.1 inch farther than the end of the shield sock
- Makes approximately a 50 percent overlap with itself
- Makes approximately a 100 percent overlap at the end.



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448481 S00061545294\_V1

#### POSITION OF THE SILICONE TAPE ON THE STRAIN RELIEF BOOT

Figure 96

- (7) If a heat shrinkable sleeve is on the wire harness:
- Move the heat shrinkable sleeve forward until it the forward end of the sleeve makes a minimum of 0.75 inch overlap with the rear end of the tape.
  - Shrink the sleeve into its position.

Refer to:

- Figure 97
- Subject 20-10-14 for the procedure to install the sleeve.

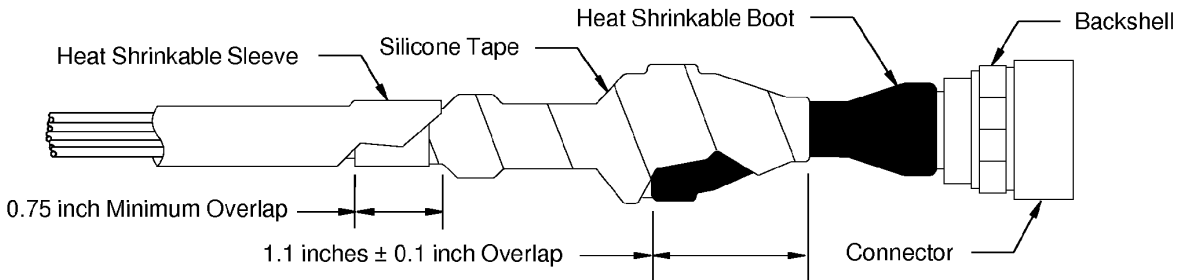
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2448545 S00061545295\_V1

#### POSITION OF THE HEAT SHRINKABLE SLEEVE ON THE SILICONE TAPE ON THE STRAIN RELIEF BOOT

Figure 97

## 5. BACKSHELL INSTALLATION

### A. Backshell Installation with a Connector Adapter

Table 27  
BACKSHELL INSTALLATION TORQUE VALUES

Shell Size	Torque (inch-pounds)	
	Minimum	Maximum
8	35	40
9	35	40
10	35	40
11	35	40
12	40	45
13	40	45
14	40	45
15	40	45
16	40	45
17	40	45
18	40	45

20-25-15



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

Table 27 BACKSHELL INSTALLATION TORQUE VALUES (Continued)

Shell Size	Torque (inch-pounds)	
	Minimum	Maximum
19	40	45
20	80	85
21	80	85
22	80	85
23	80	85
24	80	85
25	80	85
28	80	85
32	115	120

- (1) Make a selection of a hex coupling nut tool from Table 5.

**CAUTION:** DO NOT USE A STRAP WRENCH TO APPLY TORQUE TO A COMPOSITE COUPLING NUT. ONLY USE A BACKSHELL HEX NUT TOOL TO APPLY TORQUE TO A COMPOSITE COUPLING NUT. FAILURE TO USE THE SPECIFIED BACKSHELL HEX NUT TOOL CAN CAUSE DAMAGE TO THE COUPLING NUT AND UNSATISFACTORY PERFORMANCE OF THE BACKSHELL.

- (2) Make a selection of a torque tool from Table 6.
- (3) Make a selection of a connector adapter tool set from Table 7.
- (4) Set the necessary torque of the torque tool. Refer to Table 27.
- (5) Put the holder on the square drive of the torque tool.
- (6) Fully engage the threads of the backshell and the connector.
- (7) Tighten the backshell coupling nut with the hand.
- (8) If the backshell has an inspection hole, examine the teeth of the backshell and the connector through the inspection hole. Refer to Figure 98.

Make sure that the backshell teeth are fully engaged with the connector teeth.

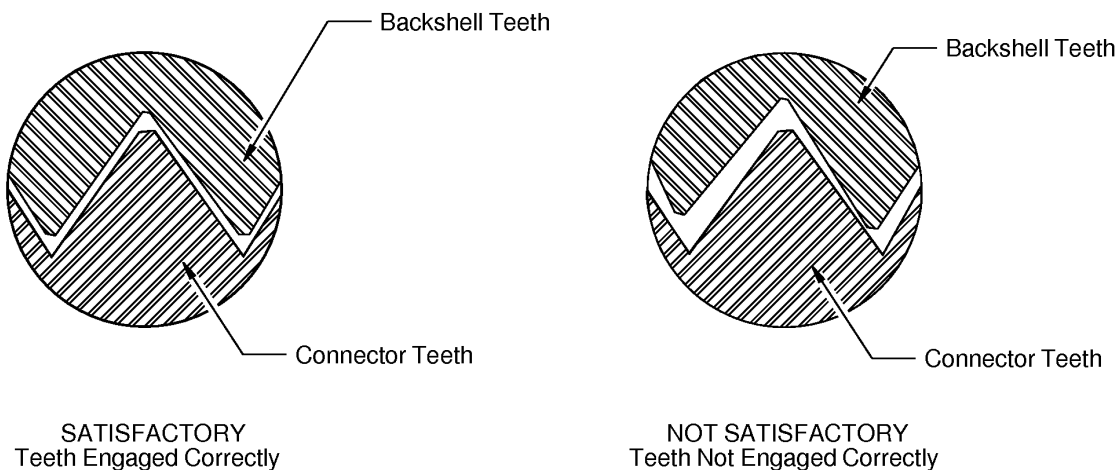
**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



2445710 S00061544292\_V1

#### ENGAGEMENT OF THE BACKSHELL TEETH AND THE CONNECTOR TEETH

Figure 98

- (9) Fully engage the connector adapter and the connector.
- (10) Tighten the backshell coupling nut with a hex coupling nut holding tool, a torque tool, and a connector adapter.

Refer to:

- Table 5 for a hex coupling nut tool
- Table 6 for a torque tool
- Table 7 for a connector adapter tool
- Figure 99 for a hand torque tool
- Figure 100 for a bench torque tool.

**CAUTION:** DO NOT USE A STRAP WRENCH TO APPLY TORQUE TO A COMPOSITE COUPLING NUT. ONLY USE A BACKSHELL HEX NUT TOOL TO APPLY TORQUE TO A COMPOSITE COUPLING NUT. FAILURE TO USE THE SPECIFIED BACKSHELL HEX NUT TOOL CAN CAUSE DAMAGE TO THE COUPLING NUT AND UNSATISFACTORY PERFORMANCE OF THE BACKSHELL.

**CAUTION:** DO NOT HOLD THE HANDLES TOO TIGHTLY.

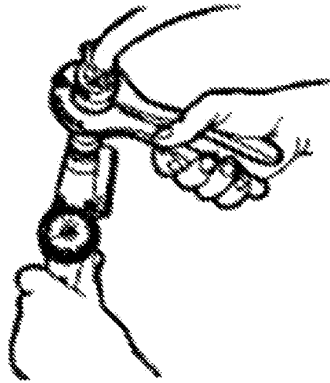
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707, 727-787

## STANDARD WIRING PRACTICES MANUAL

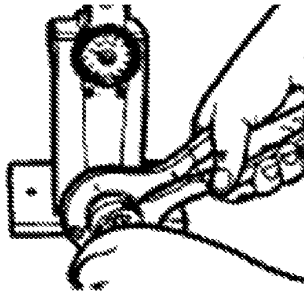
### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



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POSITION OF THE HAND TORQUE TOOL

Figure 99



2449216 S00061545299\_V1

POSITION OF THE BENCH TORQUE TOOL

Figure 100

- (11) When the coupling nut starts to tighten:

**20-25-15**



707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK

- (a) Open the hex coupling nut holding tool and rotate it back 90 degrees.
- (b) Continue to tighten the coupling nut.
- (c) Do Step a and Step b again until the specified torque is applied.

**CAUTION:** DO NOT APPLY TOO MUCH TORQUE. DAMAGE TO THE COUPLING NUT CAN OCCUR.

**CAUTION:** FOR AN ELECTRONIC TORQUE TOOL, DO NOT APPLY MORE TORQUE THAN THE INITIAL SETTING. TOO MUCH TORQUE CAN RESET THE INITIAL SETTING WHICH CAN CAUSE AN INCORRECT TORQUE INDICATION.

#### B. Backshell Installation with a Mating Connector

**Table 28**  
**BACKSHELL INSTALLATION TOOLS**

Tool	Type	Supplier
Pliers	Soft Jaws	An available source
Wrench, Strap	Torque Driver Adapter	An available source

- (1) Make a selection of a strap wrench and pliers from Table 28.
- (2) Make a selection of a torque tool from Table 6.
- (3) Set the necessary torque of the torque tool. Refer to Table 27.
- (4) Fully engage the threads of the backshell and the connector.
- (5) Tighten the backshell coupling nut with the hand.
- (6) Lightly turn the body of the backshell a small amount in each direction.  
Make sure that the clock position of the connector and backshell assembly stays the same as the specified clock position.
- (7) Do Step 5 and Step 6 again until the body of the backshell does not move against the connector.
- (8) If a backshell has an inspection hole, examine the teeth of the backshell and the connector through the inspection hole. Refer to Figure 101.

**20-25-15**

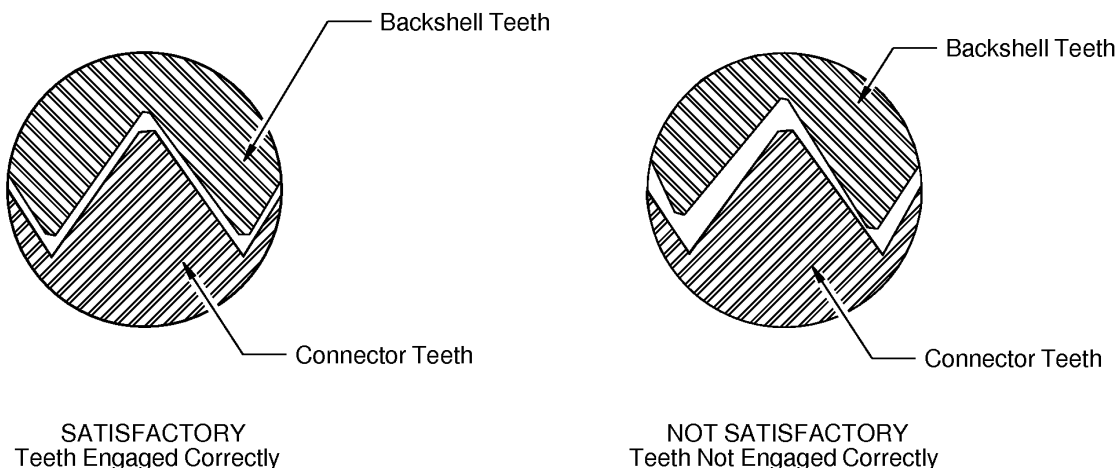




707, 727-787

## STANDARD WIRING PRACTICES MANUAL

### ASSEMBLY OF COMPOSITE HEX COUPLING NUT BACKSHELLS THAT HAVE OR DO NOT HAVE A BRAIDED SHIELD SOCK



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#### ENGAGEMENT IF THE BACKSHELL TEETH AND THE CONNECTOR THEETH

Figure 101

- (9) Fully engage the connector with a mating connector.
- (10) Hold the connector and the mating connector with the pliers.
- (11) Put the strap wrench on the backshell coupling nut
- (12) Put the torque driver on the square drive of the strap wrench.
- (13) Tighten the backshell coupling nut until the specified torque is applied.

**CAUTION:** DO NOT APPLY TOO MUCH TORQUE. DAMAGE TO THE COUPLING NUT CAN OCCUR.

**CAUTION:** FOR AN ELECTRONIC TORQUE TOOL, DO NOT APPLY MORE TORQUE THAN THE INITIAL SETTING. TOO MUCH TORQUE CAN RESET THE INITIAL SETTING WHICH CAN CAUSE AN INCORRECT TORQUE INDICATION.

#### C. Assembly of the Strain Relief Cable Clamp on a Backshell that does not have a Braided Shield Sock

Refer to Subject 20-60-09 for the assembly of the strain relief cable clamps on backshells that do not have a braided shield sock.

**20-25-15**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

**TABLE OF CONTENTS**

<b><u>PARAGRAPH</u></b>		<b><u>PAGE</u></b>
<b>1.</b>	<b><u>PART NUMBERS AND DESCRIPTION</u></b>	<b>2</b>
	A. MISTY Insert Part Numbers	2
	B. Backshell Part Numbers	3
	C. Wiring Assembly Components	4
	D. Heat Shrinkable Boot Part Numbers	4
<b>2.</b>	<b><u>WIRE HARNESS DISASSEMBLY</u></b>	<b>4</b>
	A. Wire Harness Disassembly	4
<b>3.</b>	<b><u>SHIELD TERMINATION WITH A MISTY INSERT</u></b>	<b>6</b>
	A. Backshell or Conduit Assembly Installation Preparation	6
	B. Cable Preparation - Solder Sleeve Shield Termination	8
	C. Cable Preparation - Shield Pull Through Shield Termination	11
	D. Cable Preparation - Shield Pull Through Shield Termination, Isolated Shields	12
	E. Shield Termination Assembly	14
	F. Conduit Adapter Installation	23
	G. Backshell Installation	25

**20-25-16**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS

1. PART NUMBERS AND DESCRIPTION

A. MISTY Insert Part Numbers

MISTY Insert Family 330-331 -17 Shell Size

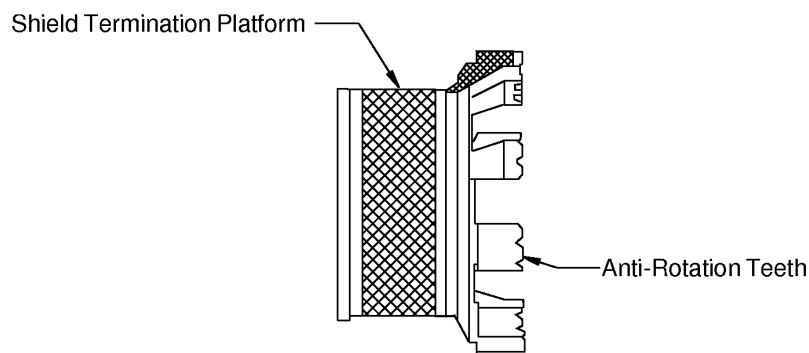
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ICORE 330-331 MISTY BACKSHELL INSERT PART NUMBER STRUCTURE

Figure 1

Table 1  
SUPPLIERS FOR MISTY INSERTS

Description	Part Number	Supplier
MISTY Backshell Insert	330-331()	Icore International Inc..



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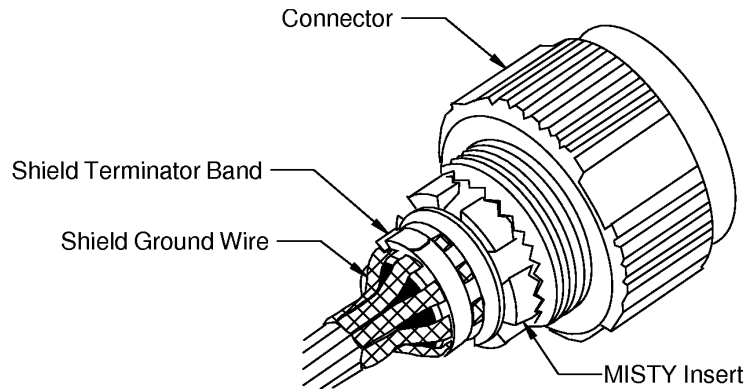
MISTY INSERT

Figure 2

20-25-16



**707, 727-787**  
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**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

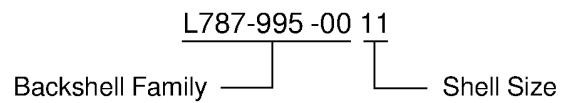


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**SHIELD TERMINATION WITH A MISTY INSERT**

**Figure 3**

**B. Backshell Part Numbers**



2448809 S00061545306\_V1

**ICORE L787-995 BACKSHELL PART NUMBER STRUCTURE**

**Figure 4**

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

**Table 2**  
**SUPPLIERS FOR MISTY BACKSHELLS**

Description	Part Number	Supplier
MISTY Connector Adapter Backshell	L787-995-()	Icore International Inc..

**C. Wiring Assembly Components**

**Table 3**  
**WIRING ASSEMBLY COMPONENTS**

Component	Type	Specification
Tape	PTFE	A-A-59474

**D. Heat Shrinkable Boot Part Numbers**

**Table 4**  
**HEAT SHRINKABLE BOOT PART NUMBERS**

Part Number	Strain Relief Type
202D121-3/86-0	Straight
292D142-3/86-0	Straight
202D153-3/86-0	Straight
222D121-3/86	90 Degree
222D152-3/86	90 Degree
243D012-3/86	45 Degree
264W012-3/86	30 Degree

**2. WIRE HARNESS DISASSEMBLY**

**A. Wire Harness Disassembly**

**Table 5**  
**WIRE HARNESS DISASSEMBLY TOOLS**

Tool	Supplier
Knife	An available source
Diagonal Cutters	An available source
Open End Wrench	An available source

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

**Table 6**  
**CONDUIT ADAPTER DISASSEMBLY TOOL SIZE**

Shell Size	Tool Size (inch)
9	5/8
11	3/4
13	13/16
15	1
17	1-1/8
19	1-3/16
21	1-5/16
23	1-7/16
25	1-9/16

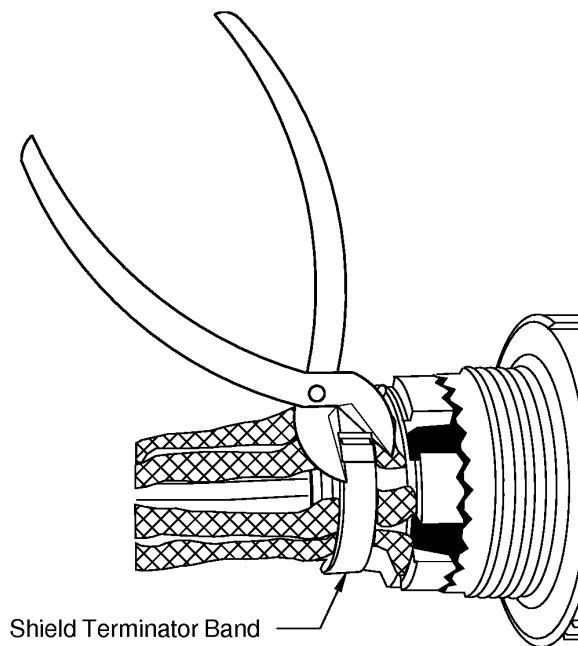
- (1) If the wire harness to be disassembled has a backshell:
- Make a selection of a knife from Table 5.
  - Carefully make a longitudinal cut from one end of the strain relief boot to the other end of the boot.
- CAUTION:** DO NOT FULLY CUT THROUGH THE STRAIN RELIEF BOOT. DAMAGE TO THE SHIELD GROUND WIRES, WIRES, CABLES, OR OTHER COMPONENTS OF THE WIRE HARNESS CAN OCCUR.
- Remove the strain relief boot.
  - Examine the shield ground wires.  
Make sure that the shield ground wires do not have damage.
  - Make a selection of an open end wrench.  
Make sure that the size of the wrench is applicable for the shell size. Refer to Table 6.
  - Use the open end wrench to loosen the backshell coupling ring.
  - Disengage the threads of the backshell coupling ring from the connector.
- (2) If the wire harness to be disassembled has a conduit adapter:
- Make a selection of an open end wrench.  
Make sure that the size of the wrench is applicable for the shell size. Refer to Table 6.
  - Use the open end wrench to loosen the conduit adapter coupling nut.
  - Disengage the threads of the conduit adapter coupling ring from the connector.
- (3) If the wire harness to be disassembled has a MISTY insert shield termination:
- Remove the tape that is
    - Around the shield ground wires
    - Around the shield terminator band.

**20-25-16**

**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

- (b) Remove the shield terminator band from the shield termination platform. Refer to Figure 5.



2448849 S00061545308\_V1

**REMOVAL OF THE SHIELD TERMINATOR BAND**

**Figure 5**

- (c) Hold the buckle of the shield terminator band with the cutters.  
(d) Rotate the cutters and lift the buckle of the band away from the shield termination platform until the buckle releases or the band breaks.  
(e) Remove the shield terminator band.  
(f) Remove the MISTY insert from the connector.

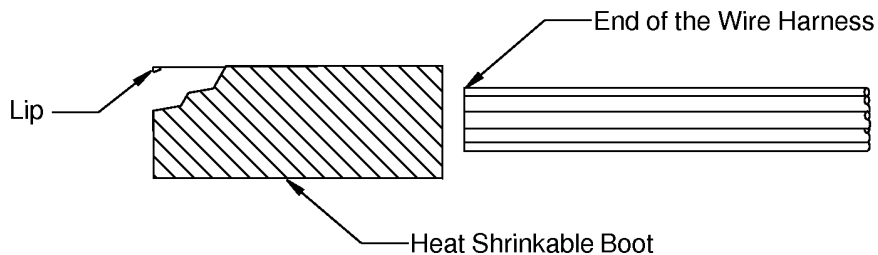
**3. SHIELD TERMINATION WITH A MISTY INSERT**

**A. Backshell or Conduit Assembly Installation Preparation**

- (1) If a heat shrinkable boot is specified, put the boot on the wire harness.  
Make sure that the end of the boot with the lip is pointed forward toward the end of the wire harness. Refer to Figure 6.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448810 S00061545309\_V1

**POSITION OF THE LIP ON THE END OF THE STRAIN RELIEF BOOT**

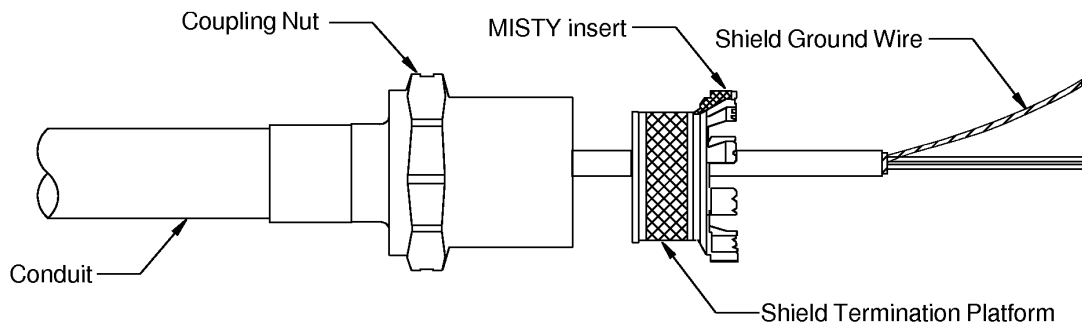
**Figure 6**

- (2) Put the shield termination components on the wire harness.

Refer to:

- Figure 7 for the MISTY insert with a conduit assembly
- Figure 7 for the MISTY insert with a backshell.

Make sure that the end of the MISTY insert with the shield termination platform is pointed away from the end of the cable.



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**POSITION OF THE MISTY INSERT AND THE CONDUIT ASSEMBLY ON THE WIRE HARNESS**

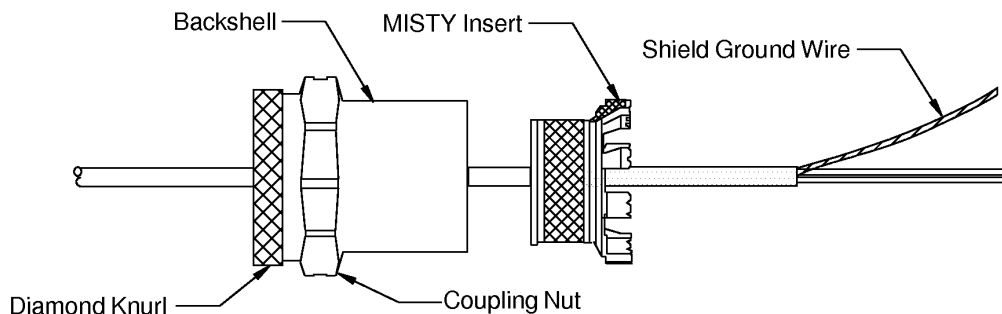
**Figure 7**

**20-25-16**





**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448826 S00061545311\_V1

**POSITION OF THE MISTY INSERT AND THE BACKSHELL ON THE WIRE HARNESS**

**Figure 8**

**B. Cable Preparation - Solder Sleeve Shield Termination**

- (1) Remove the necessary length of the jacket from the end of the cable.

Refer to:

- Figure 9 and Figure 10 for the standard shield terminations
- Figure 11 and Figure 12 for the end strip shield terminations
- Figure 13 for the standard and end strip shield terminations
- Subject 20-00-15 for the procedure to remove the cable jacket.

**NOTE:** The termination of a shield to the rear of the conduit adapter is permitted only when the End Strip shield termination is specified by Engineering.

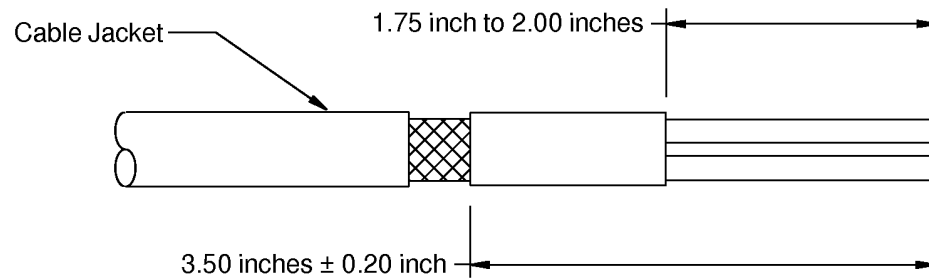
**CAUTION:** A SHIELD TERMINATION TO THE REAR OF THE CONDUIT ADAPTER ON A CABLE THAT IS NOT SPECIFIED BY ENGINEERING CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

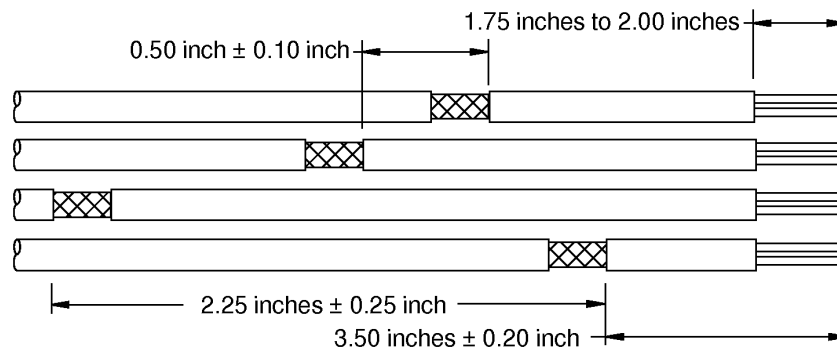
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



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**STANDARD CABLE PREPARATION - 3 OR LESS CABLES**

**Figure 9**



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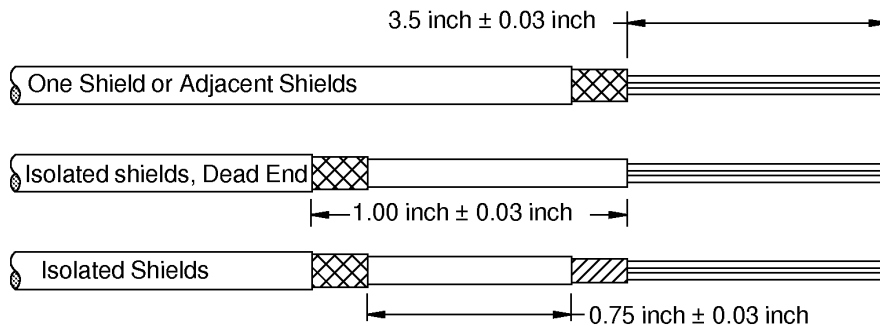
**STANDARD CABLE PREPARATION - 4 OR MORE CABLES**

**Figure 10**

**20-25-16**

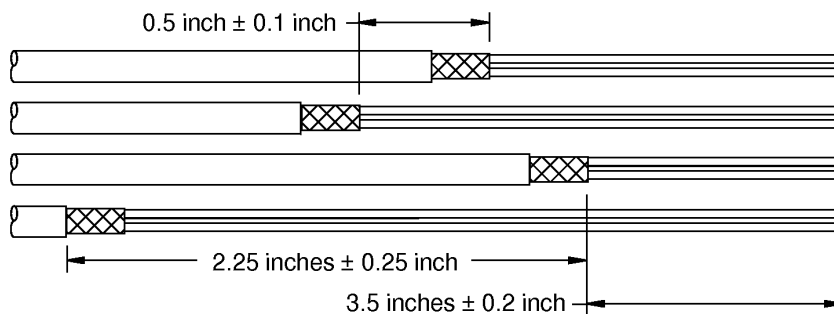


**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



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**END STRIP CABLE PREPARATION - 3 OR LESS CABLES**  
**Figure 11**



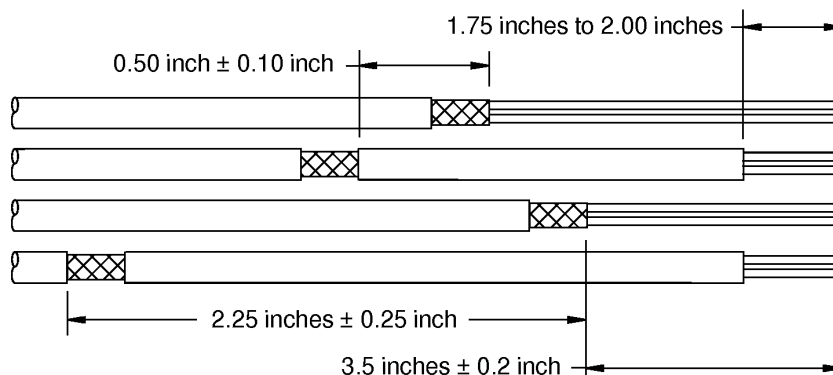
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**END STRIP CABLE PREPARATION - 4 OR MORE CABLES**  
**Figure 12**

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448815 S00061545317\_V1

**STANDARD END STRIP STANDARD CABLE PREPARATION - 4 OR MORE CABLES**

**Figure 13**

- (2) Assemble a shield dead end on each cable where the shield termination is not at the end of the cable jacket. Refer to Subject 20-10-15.
- (3) Assemble each shield ground wire. Refer to Subject 20-10-15.

Make sure that:

- Each shield ground wire is pointed rearward away from the end of the cable
- When the wire harness has 4 or more cables, the solder sleeves must be assembled at equal distances in the 2.25 inch length of the cables of the wire harness.

**NOTE:** An overlap of the solder sleeves is permitted when the wire harness has 3 cables or less.

**C. Cable Preparation - Shield Pull Through Shield Termination**

This section gives the procedure to assemble a shield pull through shield ground wire for cables with:

- One round conductor shield
- Two adjacent round conductor shields.

- (1) Remove 2.75 inches to 3.00 inches of the jacket from the end of the cable.

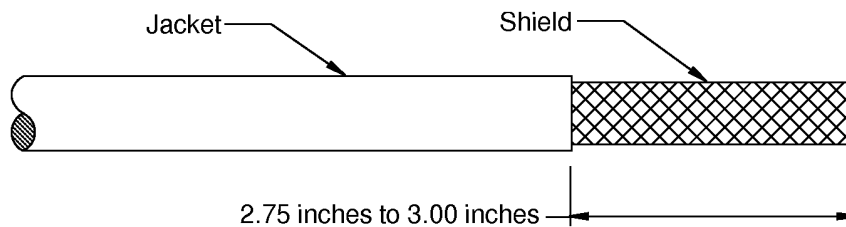
Refer to:

- Figure 14.
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

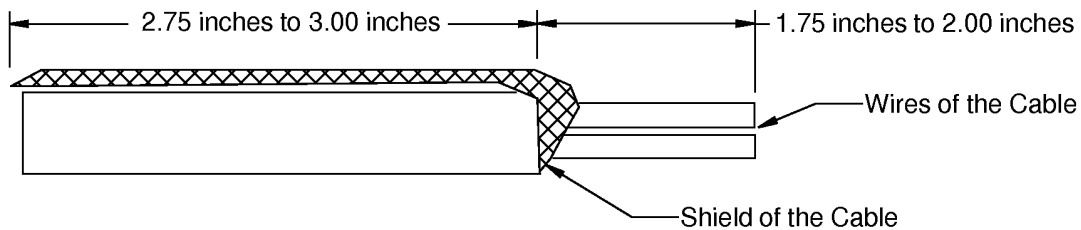


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**CABLE JACKET REMOVAL LENGTH**

**Figure 14**

- (2) Assemble the shield ground wire. Refer to Subject 20-10-15.
- (3) Remove the necessary length from the end of the wires of the cable to make the distance from the end of the jacket to the end of the wires equal to 1.75 inches to 2.00 inches. Refer to Figure 15.



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**LENGTH OF THE WIRES OF THE CABLE**

**Figure 15**

**D. Cable Preparation - Shield Pull Through Shield Termination, Isolated Shields**

- (1) Remove 3.75 inches  $\pm 0.06$  inch of outer jacket from the end of the cable.

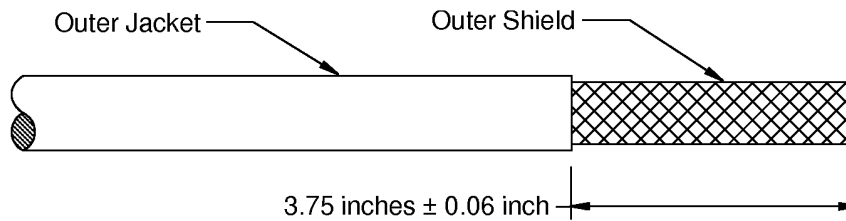
Refer to:

- Figure 16.
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



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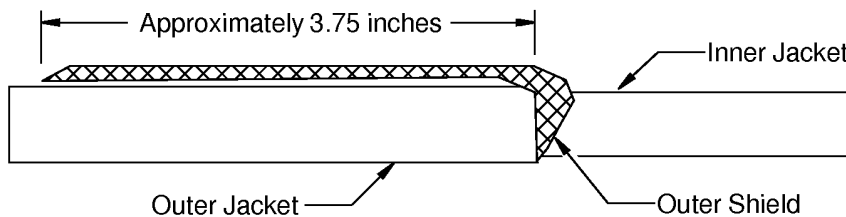
**OUTER JACKET REMOVAL LENGTH**

**Figure 16**

- (2) Assemble the shield pull through shield ground wire of the outer shield.

Refer to:

- Figure 17
- Subject 20-10-15 for the procedure to assemble the shield ground wire.



2448819 S00061545321\_V1

**OUTER SHIELD SHIELD GROUND WIRE**

**Figure 17**

- (3) Remove the necessary length of inner jacket to make the distance from the end of the outer jacket to the end of the inner jacket equal to 0.75 inch to 0.50 inch.

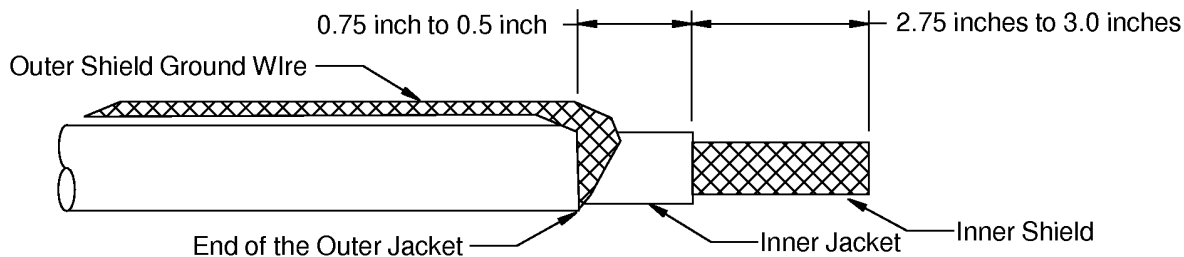
Refer to:

- Figure 18
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-16**

**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

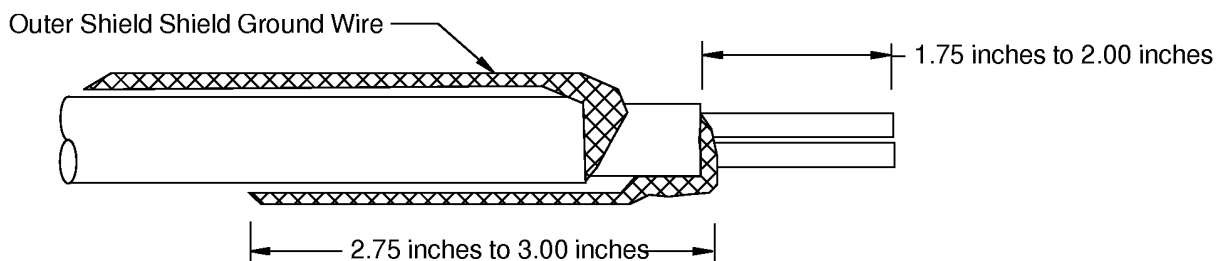


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**INNER JACKET REMOVAL LENGTH**

**Figure 18**

- (4) Assemble the shield pull through shield ground wire of the inner shield. Refer to Subject 20-10-15.
- (5) Remove the necessary length from the end of the wires of the cable to make the distance from the end of the jacket to the end of the wires equal to 1.75 inches to 2.0 inches. Refer to Figure 19.



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**LENGTH OF THE WIRES OF THE CABLE**

**Figure 19**

**E. Shield Termination Assembly**

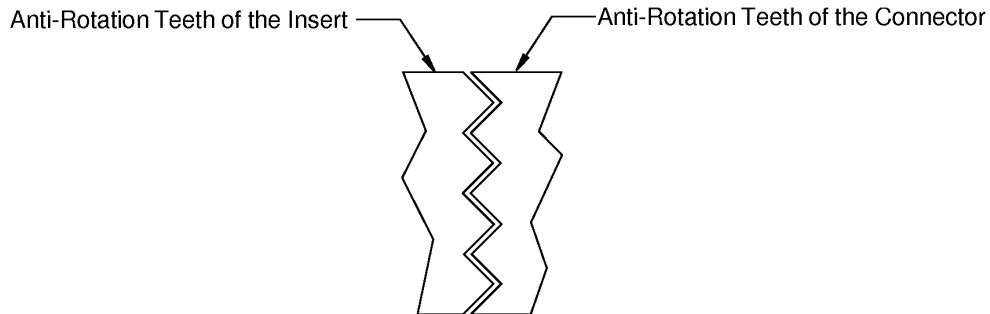
**NOTE:** If a MISTY insert shield termination is specified for each end of the wire harness, the connector on one end of the harness can be assembled before the wiring is put into the conduit to make the assembly of the connector easier.

**NOTE:** The contact assemblies must be installed in the connector before the assembly of the shield terminations.

- (1) If the wire harness has shield pull through shield ground wires, make them flat.
- (2) Fold the shield ground wires rearward away from the connector.
- (3) Push the insert forward on top of the shield ground wires.
- (4) Align the anti-rotation teeth of the insert and the connector. Refer to Figure 20.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448822 S00061545324\_V1

**ALIGNMENT OF THE ANTI-ROTATION TEETH OF THE INSERT AND THE CONNECTOR**

**Figure 20**

- (5) Put 2 to 3 layers of the PTFE tape on the wires of the cables. Refer to Figure 21.

Make sure that:

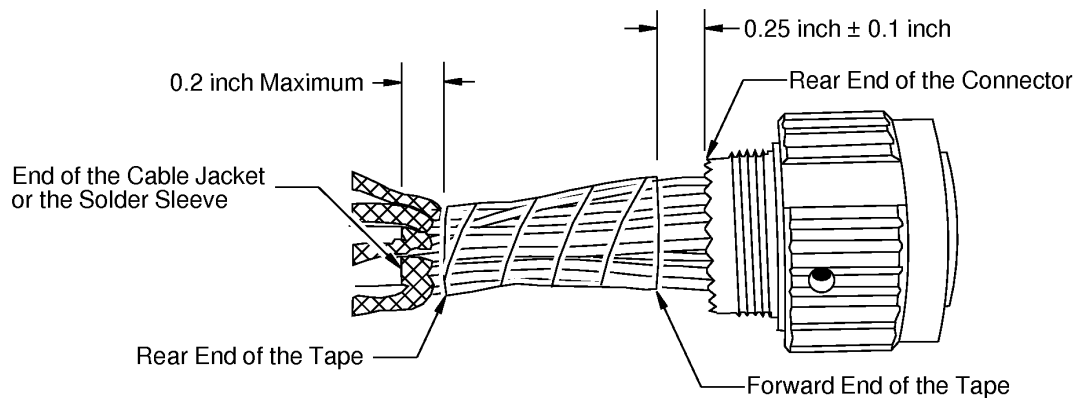
- The wires are axially aligned with the connector
- The wires do not have too much tension that pulls the seal webs of the grommet out of their shape.

**20-25-16**





**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



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**POSITION OF THE TAPE ON THE WIRES**

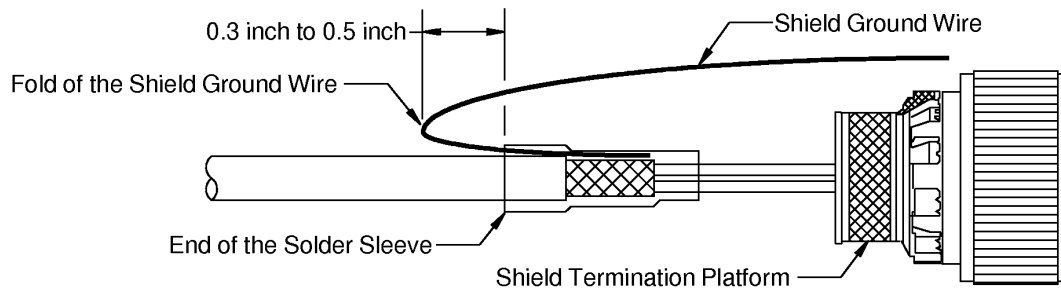
**Figure 21**

- (6) For the solder sleeve shield ground wires, fold each shield ground wire forward across the shield termination platform. Refer to Figure 22.

Make sure that the distance between the rear edge of the solder sleeve and the fold of the shield ground wire is between 0.3 inch and 0.5 inch.



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



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**FOLD OF THE SOLDER SLEEVE SHIELD GROUND WIRE**

**Figure 22**

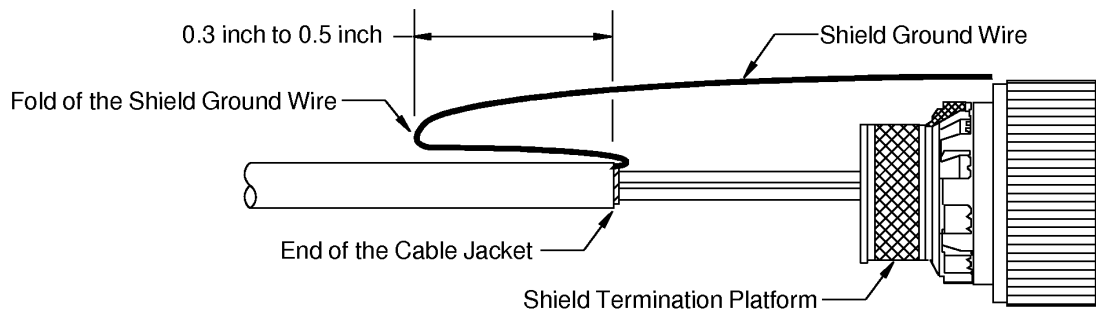
- (7) For the shield pull through shield ground wires, fold each shield ground wire across the shield termination platform. Refer to Figure 23.

Make sure that the distance between the end of the cable jacket and the fold of the shield ground wire is between 0.3 inch and 0.5 inch.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448829 S00061545327\_V1

**FOLD OF THE SHIELD PULL THROUGH SHIELD GROUND WIRE**

**Figure 23**

- (8) Install a shield terminator band on the shield ground wires on the shield termination platform.

Refer to:

- Figure 24
- Subject 20-25-14 for the procedure to install the band.

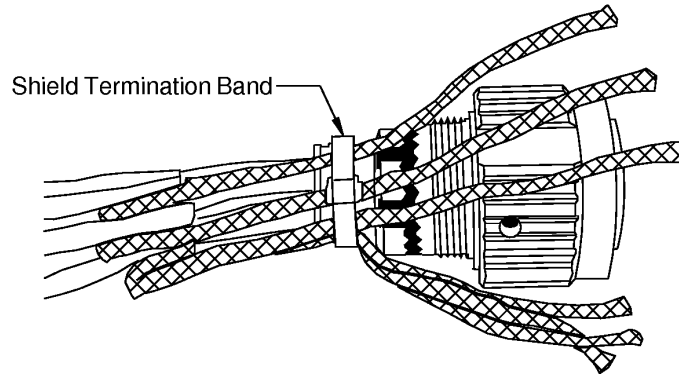
Make sure that:

- The shield ground wires are even and symmetrical around the circumference of the platform
- A shield ground wire does not make an overlap with a different shield ground wire
- The buckle of the band is flat against the platform
- The buckle of the band does not make an overlap with the shield ground wires
- The buckle of the band does not make an overlap with the collar of the platform
- The shield ground wires are tight against the platform.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448830 S00061545328\_V1

**POSITION OF THE SHIELD TERMINATION BAND ON THE SHIELD TERMINATION PLATFORM**

**Figure 24**

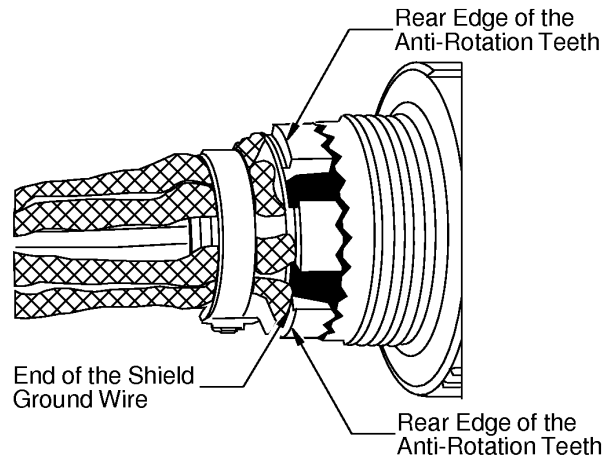
- (9) Cut the end of each shield ground wire  $0.10 \text{ inch} \pm 0.05 \text{ inch}$  from the forward edge of the shield termination platform. Refer to Figure 25.

Make sure that the end of each shield ground wire does not extend farther than the rear edge of the anti-rotation teeth.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448831 S00061545329\_V1

**POSITION OF THE SHIELD GROUND WIRES AGAINST THE SHIELD TERMINATION PLATFORM**

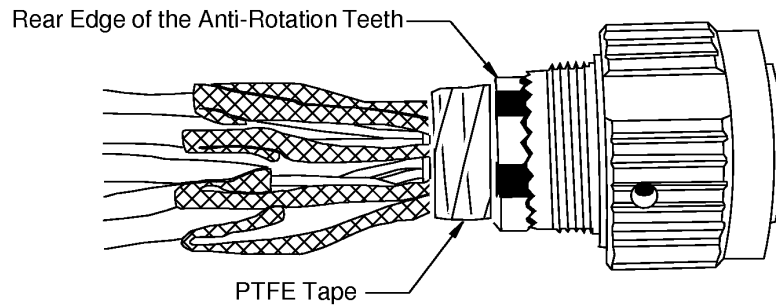
**Figure 25**

- (10) Put 2 to 3 layers of PTFE tape on the shield terminator band. Refer to Figure 26.  
Make sure that the forward edge of the tape does not extend farther than the rear edge of the anti-rotation teeth.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448832 S00061545330\_V1

**POSITION OF THE PTFE TAPE ON THE SHIELD TERMINATOR BAND**

**Figure 26**

- (11) Put 2 layers of PTFE tape on the shield ground wires. Refer to Figure 27.

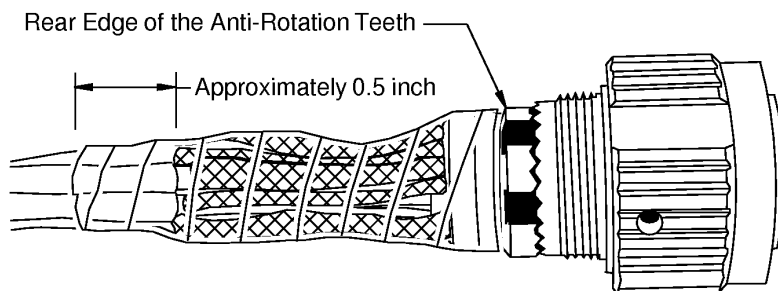
Make sure that the tape:

- Starts approximately 0.5 inch from the rear of the folded end of the longest shield ground wire
- Ends on the shield termination platform
- Makes a 50 percent overlap with itself
- Does not make an overlap with the rear edge of the anti-rotation teeth.

**20-25-16**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS



2448833 S00061545331\_V1

POSITION OF THE PTFE TAPE ON THE SHIELD GROUND WIRES

Figure 27

(12) If a pull cord is specified:

(a) Put the pull cord in its position.

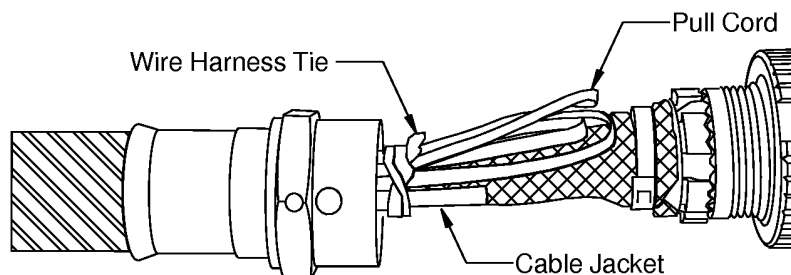
Make sure that the pull cord does not make an overlap with the shield termination platform.

**NOTE:** The folded lengths of the pull cord can be put at approximately equal intervals around the wire harness.

(b) Assemble a wire harness tie on the pull cord and the jackets of the cable.

Refer to:

- Figure 28
- Subject 20-10-11 for the procedure to assemble the wire harness tie.



2448834 S00061545332\_V1

POSITION OF THE WIRE HARNESS TIE ON THE PULL CORD

Figure 28

20-25-16



707, 727-787  
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS

F. Conduit Adapter Installation

Table 7  
CONDUIT ADAPTER INSTALLATION TOOL SIZE

Shell Size	Tool Size (inch)
9	5/8
11	3/4
13	13/16
15	1
17	1-1/8
19	1-3/16
21	1-5/16
23	1-7/16
25	1-9/16

Table 8  
CONDUIT ADAPTER INSTALLATION TORQUE VALUES

Shell Size	Torque Value (inch-pounds)	
	Target	Tolerance
9	50	±5
11	50	±5
13	75	±5
15	75	±5
17	75	±5
19	100	±5
21	100	±5
23	125	±5
25	125	±5

- (1) Carefully push the adapter forward until it is against the connector.  
Make sure that the keys of the adapter and the keyways of the MISTY insert are aligned.
- (2) Engage the threads of the adapter and the connector.
- (3) Put the Master Key or Keyway of the connector in the specified clock position. Refer to Figure 29  
**NOTE:** If the clock position is not specified, put the Master Key or Keyway in clock position 12.

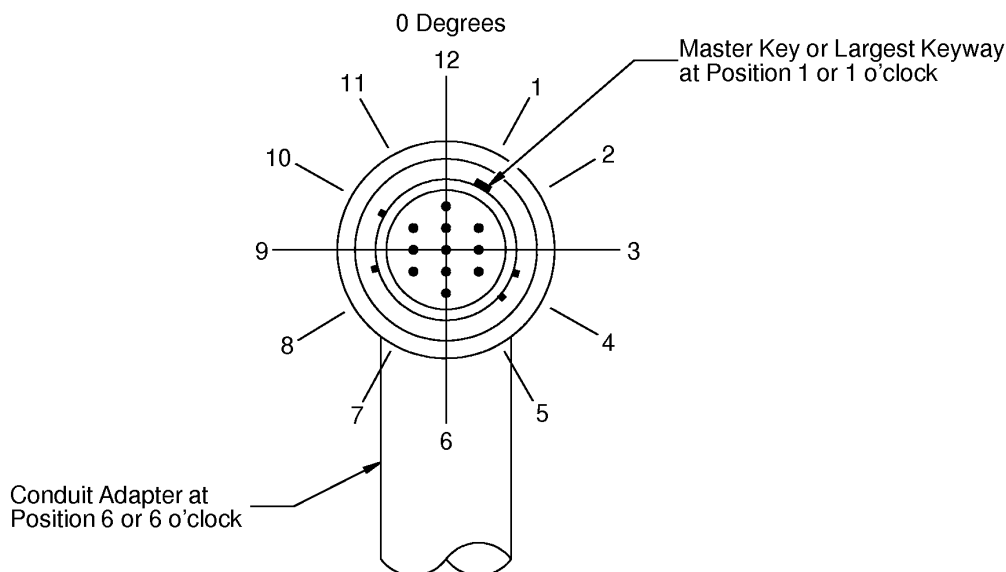
20-25-16





707, 727-787  
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ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS



2448823 S00061545333\_V1

ONE O'CLOCK POSITION OF THE CONNECTOR AND THE CONDUIT ADAPTER

Figure 29

- (4) For a conduit with a 45 degree or a 90 degree angle, put the conduit in the 6 o'clock position and the specified tolerance. Refer to Figure 29.

**NOTE:** If the tolerance is not specified, put the strain relief arm in the 6 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees.

- (5) Tighten the coupling nut manually. Refer to Figure 30.

Make sure that:

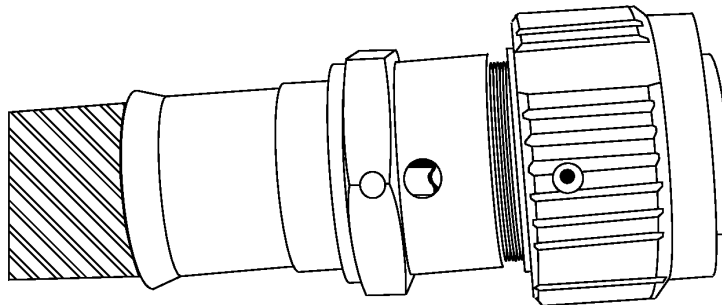
- The conduit adapter is in the specified clock position; refer to Figure 29..
- The conduit and the connector are held together while the coupling nut is tightened.
- The anti-rotation teeth of the insert and the connector stay aligned.

**CAUTION:** IF THE CONDUIT AND THE CONNECTOR ARE NOT HELD TOGETHER WHILE THE COUPLING NUT IS TIGHTENED, DAMAGE TO THE WIRE HARNESS OR THE SHIELD GROUND WIRES CAN OCCUR.

20-25-16



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448835 S00061545335\_V1

**POSITION OF THE CONDUIT ADAPTER ON THE CONNECTOR**

**Figure 30**

- (6) Make a selection of an open end wrench.  
Make sure that the size of the wrench is applicable for the shell size. Refer to Table 7.
- (7) Tighten the coupling nut to the specified torque value. Refer to Table 8.  
Make sure that the anti-rotation teeth of the insert and the connector stay aligned.
- (8) Release the coupling nut.
- (9) If the coupling nut moves, do Step 7 and Step 8 again.

**CAUTION:** IF THE COUPLING NUT MOVES BACK FROM THE SPECIFIED TORQUE POSITION, UNSATISFACTORY PERFORMANCE OF THE CONDUIT ADAPTER OCCURS.

**G. Backshell Installation**

**Table 9**  
**BACKSHELL INSTALLATION TOOL SIZE**

Shell Size	Tool Size (inch)
9	5/8
11	3/4
13	13/16
15	1

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

**Table 9 BACKSHELL INSTALLATION TOOL SIZE (Continued)**

Shell Size	Tool Size (inch)
17	1-1/8
19	1-3/16
21	1-5/16
23	1-7/16
25	1-9/16

**Table 10**  
**BACKSHELL INSTALLATION TORQUE VALUES**

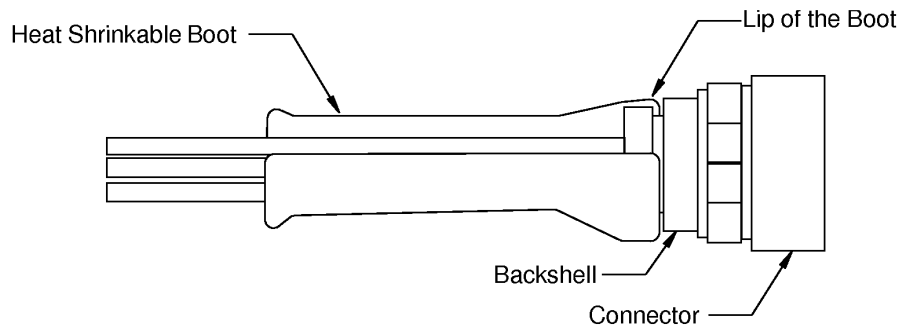
Shell Size	Initial Torque (inch-pounds)	
	Target	Tolerance
9	50	±5
11	50	±5
13	75	±5
15	75	±5
17	75	±5
19	100	±5
21	100	±5
23	125	±5
25	125	±5

- (1) Carefully push the backshell forward until it is against the connector.  
Make sure that the keys of the backshell and the keyways of the MISTY insert are aligned.
- (2) Engage the threads of the backshell and the connector.
- (3) Push the heat shrinkable boot forward until the forward end of the boot is against the rear of the backshell.
- (4) Align the lip of the boot in the slot in the backshell. Refer to Figure 31.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**



2448824 S00061545337\_V1

**POSITION OF THE HEAT SHRINKABLE BOOT ON THE BACKSHELL**

**Figure 31**

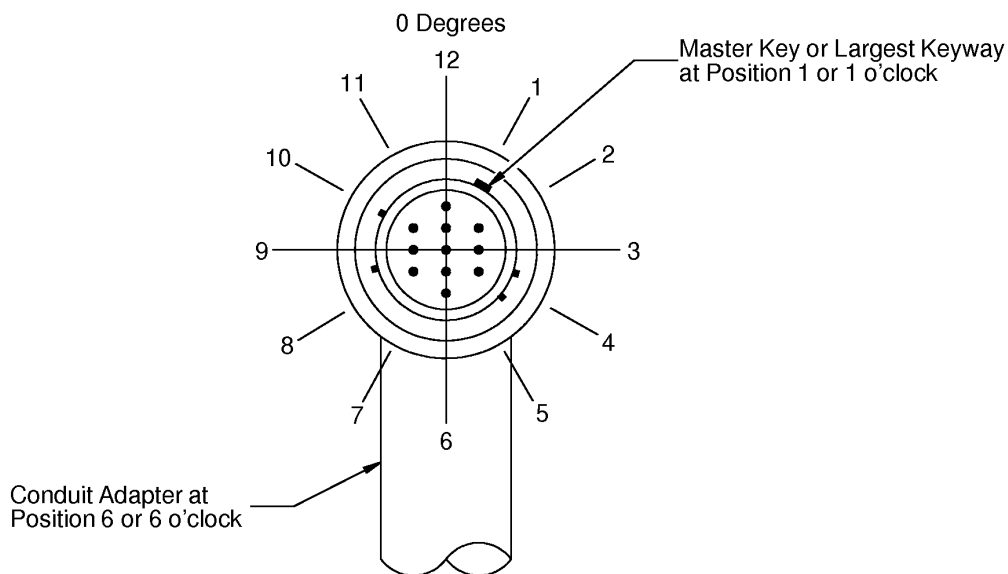
- (5) Put the Master Key or Keyway of the connector in the specified clock position. Refer to Figure 32.

**NOTE:** If the clock position is not specified, put the Master Key or Keyway in clock position 12.



707, 727-787  
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS



2448823 S00061545333\_V1

CLOCK POSITIONS OF THE HEAT SHRINKABLE BOOT

Figure 32

- (6) For a boot with a 45 degree or a 90 degree angle, put the boot in the 6 o'clock position and the specified tolerance. Refer to Figure 32.

**NOTE:** If the tolerance is not specified, put the strain relief arm in the 6 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees.

- (7) Tighten the coupling nut manually.

Make sure that:

- The backshell is in the specified clock position; refer to Figure 32
- The body of the backshell and the connector are held together while the coupling nut is tightened
- The anti-rotation teeth of the insert and the connector stay aligned.

**CAUTION:** IF THE BODY OF THE BACKSHELL AND THE CONNECTOR ARE NOT HELD TOGETHER WHILE THE COUPLING NUT IS TIGHTENED, DAMAGE TO THE WIRE HARNESS AND SHIELD GROUND WIRES CAN OCCUR.

- (8) Make a selection of an open end wrench.  
Make sure that the size of the wrench is applicable for the shell size. Refer to Table 9.
- (9) Tighten the coupling nut to the specified torque value. Refer to Table 10.  
Make sure that the anti-rotation teeth of the insert and the connector stay aligned.
- (10) Release the coupling nut.
- (11) If the coupling nut moves, do Step 9 and Step 10 again.

20-25-16



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF ICORE MISTY INSERT SHIELD TERMINATIONS**

**CAUTION:** IF THE COUPLING NUT MOVES BACK FROM THE FINAL TORQUE POSITION,  
UNSATISFACTORY PERFORMANCE OF THE BACKSHELL CAN OCCUR.

- (12) Shrink the boot into its position. Refer to Figure 31.  
Make sure that the lip of the boot stays in the groove of the backshell.

**20-25-16**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

**TABLE OF CONTENTS**

<u><b>PARAGRAPH</b></u>	<u><b>PAGE</b></u>
<b>1.    <u>PART NUMBERS AND DESCRIPTION</u></b>	<b>2</b>
A.   Backshell Part Numbers	2
B.   Wiring Assembly Components	2
<b>2.    <u>BACKSHELL DISASSEMBLY</u></b>	<b>2</b>
A.   Backshell Disassembly	2
<b>3.    <u>BACKSHELL ASSEMBLY</u></b>	<b>3</b>
A.   Backshell Installation Preparation	3
B.   Cable Preparation - Shield Pull Through Shield Termination	4
C.   Cable Preparation - Shield Pull Through Shield Termination, End Strip Configuration	4
D.   Cable Preparation - Shield Pull Through Shield Termination, Adjacent Shields	5
E.   Cable Preparation - Shield Pull Through Termination, Adjacent Shields, End Strip Configuration	6
F.   Shield Termination Assembly	7
G.   Backshell Installation	11

**20-25-17**

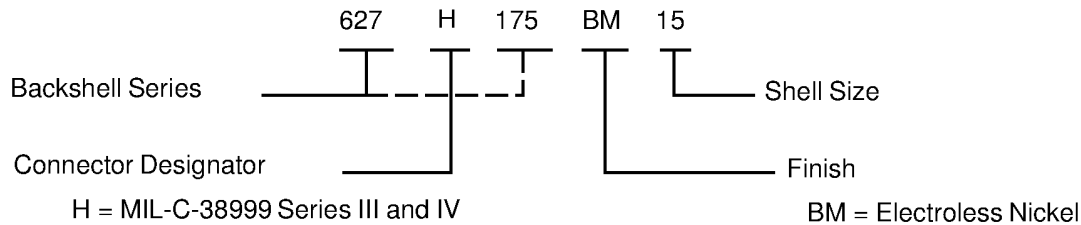


**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

**1. PART NUMBERS AND DESCRIPTION**

**A. Backshell Part Numbers**



2449968 S00061545341\_V1

**GLENAIR 627-175 BACKSHELL PART NUMBER STRUCTURE**  
**Figure 1**

**B. Wiring Assembly Components**

**Table 1**  
**WIRING ASSEMBLY COMPONENTS**

Component	Type	Specification
Tape	PTFE	A-A-59474
	Silicone, Type I	A-A-59163
	Silicone, Type II	A-A-59163

**2. BACKSHELL DISASSEMBLY**

**A. Backshell Disassembly**

**Table 2**  
**BACKSHELL DISASSEMBLY TOOLS**

Tool	Supplier
Screwdriver Bit	An available source
Torque Driver	An available source
Diagonal Cutters	An available source

- (1) Make a selection of these tools from Table 2
  - A screwdriver bit
  - A torque tool.
- (2) Remove the bars of the saddle clamp.
- (3) Remove the silicone tape from the wire harness.
- (4) Remove the backshell from the connector shell. Refer to Subject 20-25-15.
- (5) Fully disengage the threads of the backshell and the connector.

**20-25-17**





707, 727-787  
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS

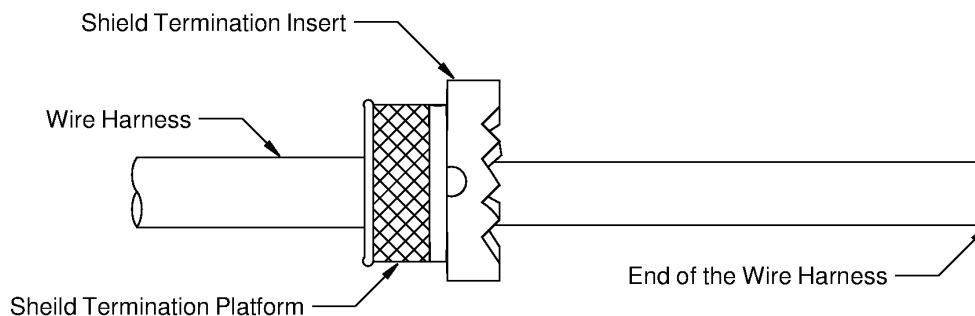
- (6) Move the backshell away from the connector.
- (7) Make a selection of Diagonal Cutter from Table 2.
- (8) Remove the shield terminator band.

3. **BACKSHELL ASSEMBLY**

A. **Backshell Installation Preparation**

- (1) Put the backshell on the wire harness.  
Make sure that the engaging end of the backshell is pointed forward toward the end of the wire harness.
- (2) Move the backshell rearward away from the end of the wire harness.
- (3) Put the shield termination insert on the wire harness.  
Make sure that the end of the insert with the shield termination platform is put on the wire harness first.

**NOTE:** If the shield termination insert does not go on to the wire harness, the end of the cables must be prepared first.



2449969 S00061545342\_V1

POSITION OF THE SHIELD TERMINATION INSERT ON THE WIRE HARNESS

Figure 2

20-25-17

# 707, 727-787 STANDARD WIRING PRACTICES MANUAL

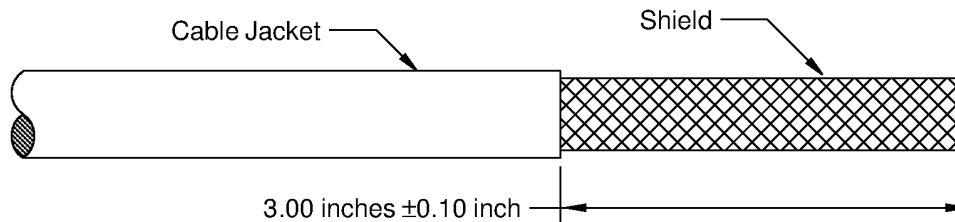
## ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS

### B. Cable Preparation - Shield Pull Through Shield Termination

- (1) Remove the necessary length of the jacket from the end of the cable.

Refer to:

- Figure 3
- Subject 20-00-15 for the procedure to remove the cable jacket.

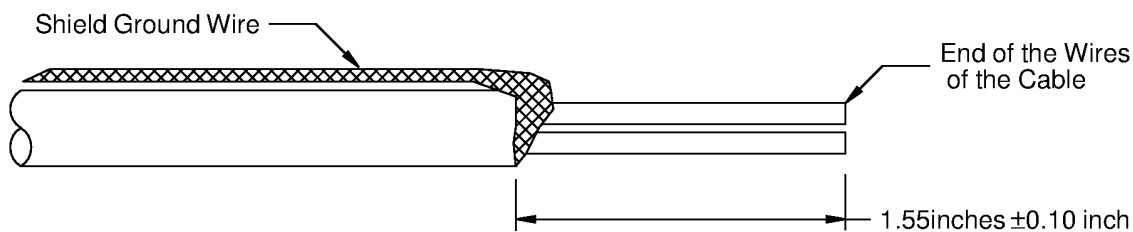


2449970 S00061545343\_V1

### CABLE PREPARATION DIMENSIONS

Figure 3

- (2) Assemble the shield ground wire. Refer to Subject 20-10-15.
- (3) Remove the necessary length from the end of each wire of the cable to make the distance from the end of the cable jacket to the end of the wire equal to 1.55 inches  $\pm 0.10$  inch. Refer to Figure 4



2449971 S00061545344\_V1

### LENGTH OF THE WIRES OF THE CABLE

Figure 4

### C. Cable Preparation - Shield Pull Through Shield Termination, End Strip Configuration

- (1) Remove 3.25 inches of the jacket from the end of the cable.

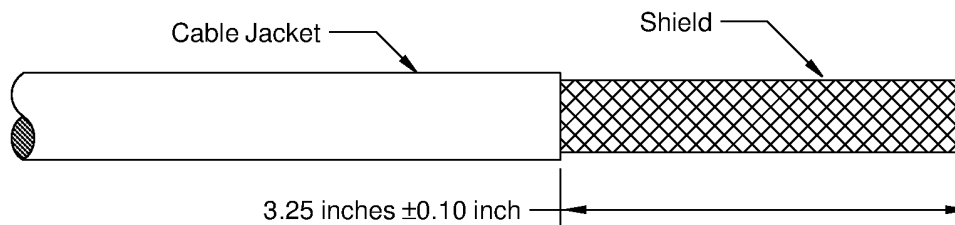
Refer to:

- Figure 5.
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

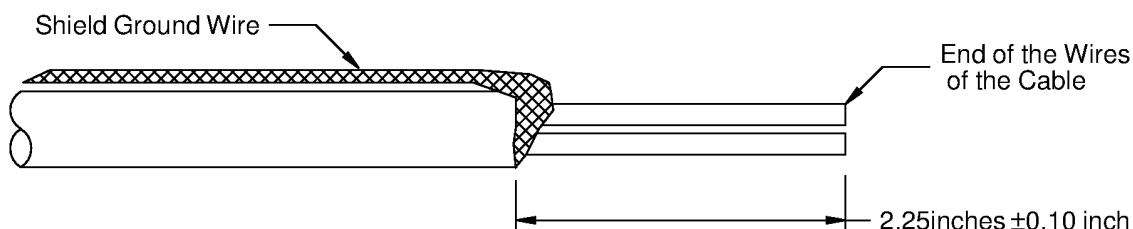


2449972 S00061545345\_V1

**CABLE PREPARATION DIMENSIONS**

**Figure 5**

- (2) Assemble the shield ground wire. Refer to Subject 20-10-15.
- (3) Remove the necessary length from the end of the wires of the cable to make the distance from the end of the jacket to the end of the wires equal to 1.75 inches to 2.00 inches. Refer to Figure 6.



2449973 S00061545346\_V1

**LENGTH OF THE WIRES OF THE CABLE**

**Figure 6**

**D. Cable Preparation - Shield Pull Through Shield Termination, Adjacent Shields**

- (1) Remove 3.00 inches of outer jacket from the end of the cable.

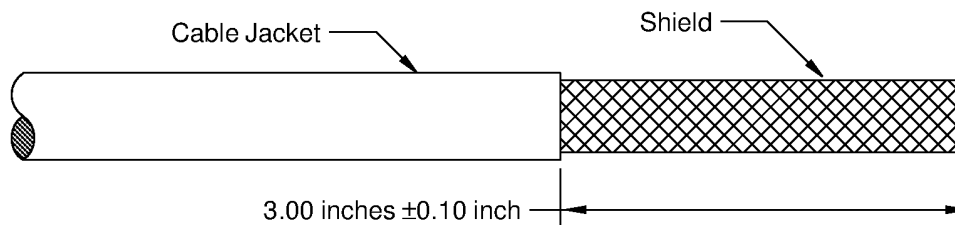
Refer to:

- Figure 7.
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

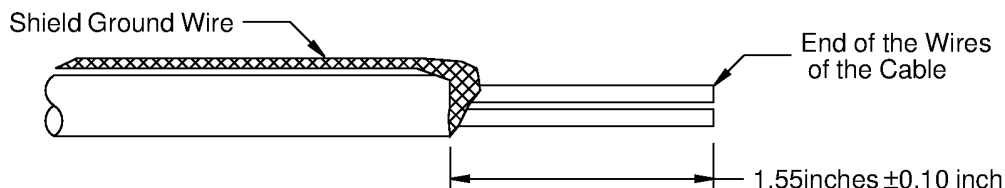


2449974 S00061545347\_V1

**CABLE PREPARATION DIMENSIONS**

**Figure 7**

- (2) Assemble the shield pull through shield ground wire of the outer shield.  
Refer to Subject 20-10-15 for the procedure to assemble the shield ground wire.
- (3) Remove the necessary length of the adjacent flat shield to align the end of the flat shield with the end of the cable jacket.
- (4) Remove the necessary length from the end of each wire of the cable to make the distance from the end of the cable jacket to the end of the wire equal to 1.55 inches  $\pm 0.10$  inch. Refer to Figure 8.



2449975 S00061545348\_V1

**LENGTH OF THE WIRES OF THE CABLE**

**Figure 8**

**E. Cable Preparation - Shield Pull Through Termination, Adjacent Shields, End Strip Configuration**

- (1) Remove 3.25 inches of the cable jacket from the end of the cable.

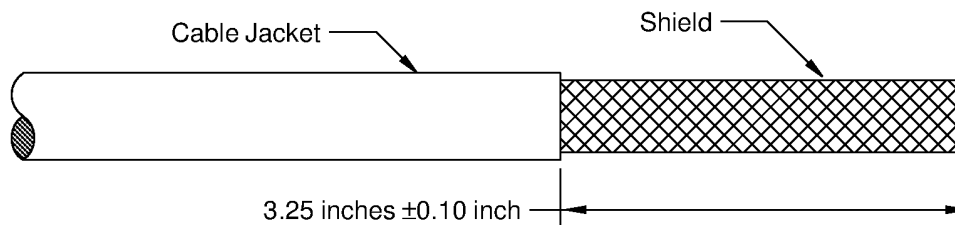
Refer to:

- Figure 9
- Subject 20-00-15 for the procedure to remove the cable jacket.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

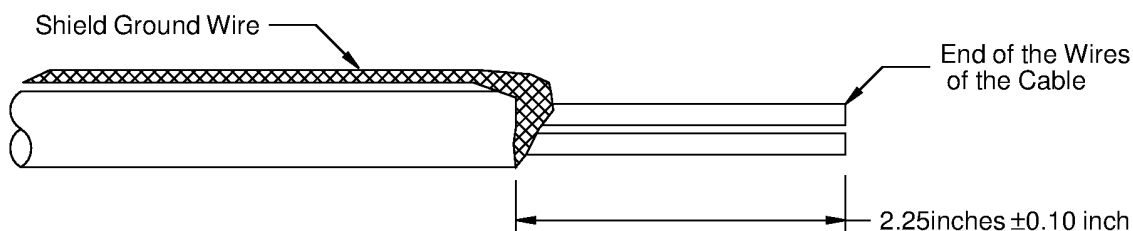


2449976 S00061545349\_V1

**CABLE PREPARATION DIMENSIONS**

**Figure 9**

- (2) Assemble the shield pull through shield ground wire of the outer shield. Refer to Subject 20-10-15.
- (3) Remove the necessary length of the adjacent flat shield to align the end of the flat shield with the end of the cable jacket.
- (4) Remove the necessary length from the end of each wire of the cable to make the distance from the end of the cable jacket to the end of the wire equal to 2.25 inches  $\pm 0.10$  inch. Refer to Figure 10.



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**LENGTH OF THE WIRES OF THE CABLE**

**Figure 10**

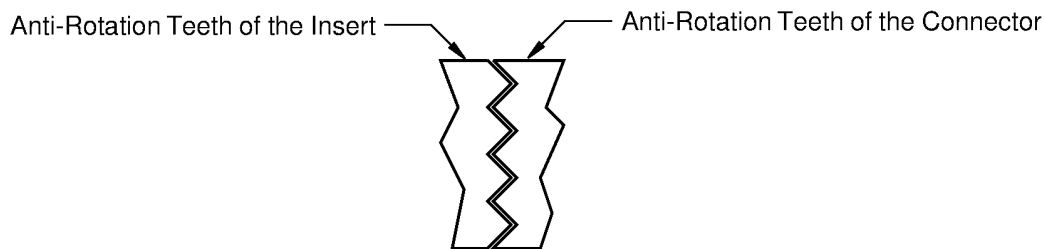
**F. Shield Termination Assembly**

- (1) Make the shield ground wires flat.
- (2) Fold the shield ground wires back rearward away from the connector.
- (3) If the shield termination insert is on the wire harness, move the insert forward beyond the shield ground wires.
- (4) If the shield termination insert is not on the wire harness, put the insert on the wires of the cables. Make sure that the end of the insert with the shield termination platform is put on the wires first.
- (5) Align the anti-rotation teeth of the shield termination insert and the connector. Refer to Figure 11.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

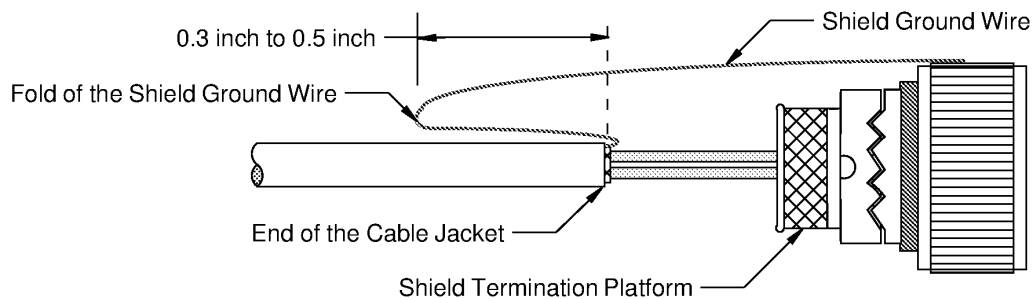


2449978 S00061545351\_V1

**ALIGNMENT OF THE ANTI-ROTATION TEETH OF THE INSERT AND THE CONNECTOR**

**Figure 11**

- (6) Fold each shield ground wire across the shield termination platform. Refer to Figure 12.
- Make sure that the distance between the end of the cable jacket and the fold of the shield ground wire is between 0.3 inch and 0.5 inch.



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**FOLD OF THE SHIELD PULL THROUGH SHIELD GROUND WIRE**

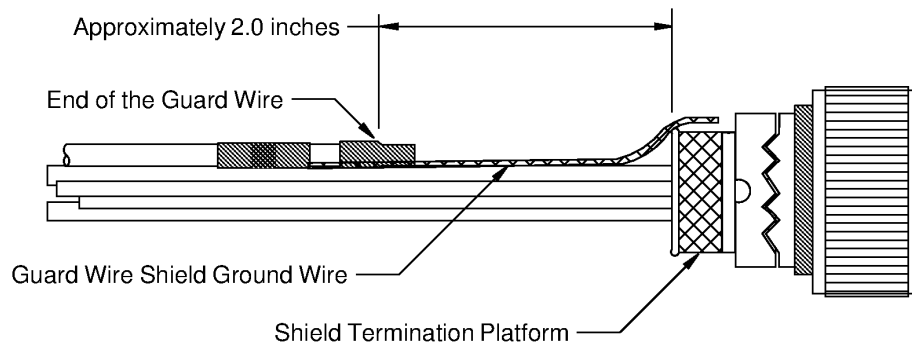
**Figure 12**

- (7) For a wire harness with one or more guard wires, put each guard wire shield ground wire on the shield termination platform. Refer to Figure 13.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**



2449980 S00061545353\_V1

**POSITION OF THE GUARD WIRE SHIELD GROUND WIRE ON THE WIRE HARNESS**

**Figure 13**

- (8) Install a shield terminator band on the shield ground wires on the shield termination platform.

Refer to:

- Figure 14.
- Subject 20-25-14 for the procedure to install the band.

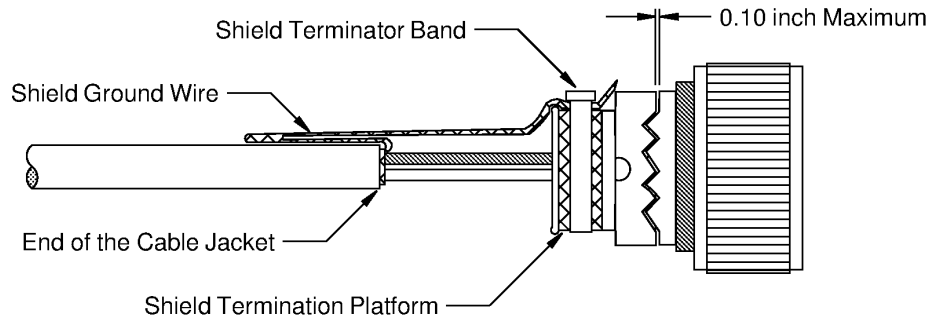
Make sure that:

- - The shield ground wires are even and symmetrical around the circumference of the platform
- - A shield ground wire does not make an overlap with a different shield ground wire
- - The buckle of the band is flat against the platform
- - The buckle of the band does not make an overlap with the shield ground wires
- - The buckle of the band does not make an overlap with the collar of the platform
- - The shield ground wires are tight against the platform
- - The distance between the shield termination platform and the connector is not more than 0.10 inch.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

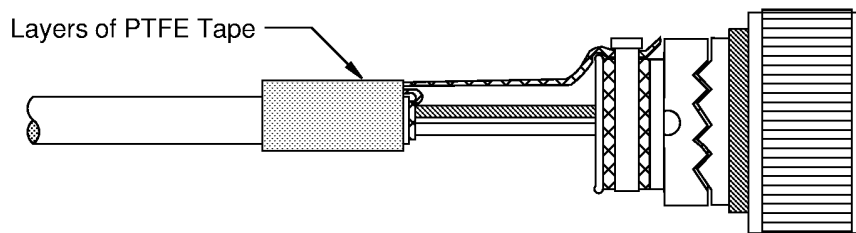


2449981 S00061545354\_V1

**POSITION OF THE SHIELD TERMINATION BAND ON THE SHIELD TERMINATION PLATFORM**

**Figure 14**

- (9) Cut the end of each shield ground wire 0.10 inch  $\pm$  0.05 inch from the forward edge of the shield termination platform.  
Make sure that the end of the each shield ground wire does not extend farther than the rear edge of the anti-rotation teeth.
- (10) Wind 2 to 3 layers of PTFE tape on the folded shield ground wires and the wire harness. Refer Figure 15.



2449982 S00061545355\_V1

**POSITION OF THE LAYERS OF PTFE TAPE**

**Figure 15**

**20-25-17**





707, 727-787  
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS

G. Backshell Installation

Table 3  
BACKSHELL INSTALLATION TOOLS

Tool	Supplier
Screwdriver Bit	An available source
Torque Driver	An available source

Table 4  
STRAIN RELIEF CLAMP SCREW TORQUE VALUES

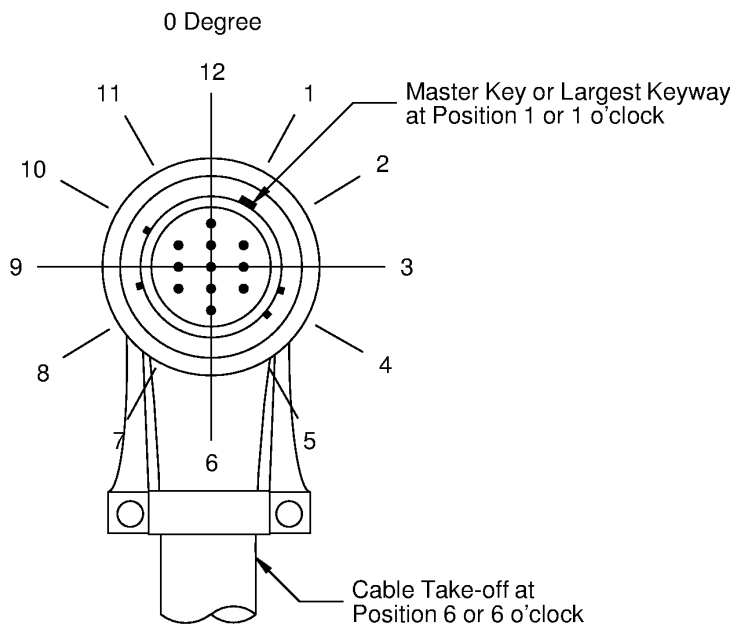
Shell Size		Screw Size	Torque (inch-pounds)		
Minimum	Maximum		Minimum Capability	Driver	Screw Bit
8	11	4	4 inch pounds	Screw Bit	#1
12	28	6	6 inch pounds	Screw Bit	#2

- (1) Make a selection of these tools from Table 3.
    - A screwdriver bit
    - A torque tool.
  - (2) Push the backshell forward until it is against the rear of the connector.
  - (3) Put the master key or keyway of the connector in the specified clock position. Refer to Figure 16.
- NOTE:** If the clock position is not specified, put the master key or keyway in the clock position 12.

20-25-17



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**  
**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**



2449983 S00061545356\_V1

**CLOCK POSITIONS OF THE CONNECTOR AND THE BACKSHELL**

**Figure 16**

- (4) For a backshell that has an angle, put the strain relief legs in the 6 o'clock position  $\pm 1$  hour or  $\pm 30$  degrees. Refer to Figure 16.
- (5) Engage the threads of the backshell and the connector.
- (6) Install the backshell.

Refer to:

- Figure 1
- Subject 20-25-15 for the procedure to install the backshell.

- (7) For a wire harness with one or more guard wires, put one layer of Type II silicone tape on the wire harness and the guard wire. Refer to Figure 17

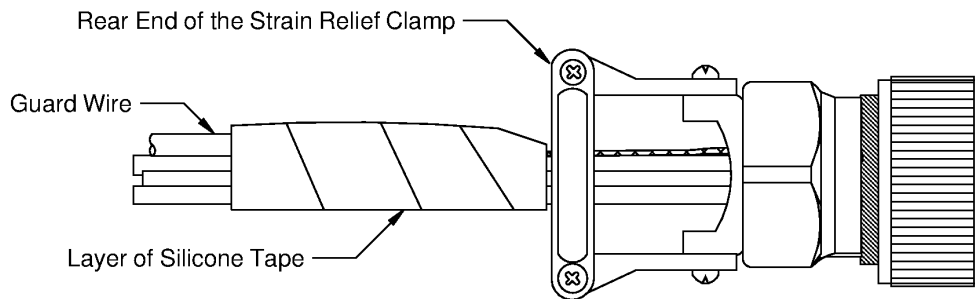
Make sure that:

- Starts at the rear end of the solder sleeve
- Ends at the location of the strain relief clamp
- Makes a 50 percent overlap.

**20-25-17**



707, 727-787  
STANDARD WIRING PRACTICES MANUAL  
ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS



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**POSITION OF THE TAPE ON THE WIRE HARNESS AND THE GUARD WIRE**

**Figure 17**

- (8) Put the necessary layers of Type I silicone tape on the wire harness where the strain relief clamp holds the wire harness.

Refer to:

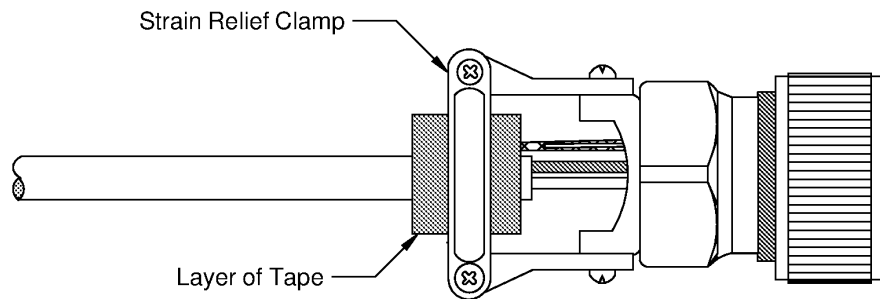
- Figure 18 for a wire harness without a guard wire
- Figure 19 for a wire harness with one or more guard wires.

**NOTE:** The diameter of the wire harness and tape must be sufficient for the clamp to hold the wire harness tightly and not crush the wires or cables.

**20-25-17**

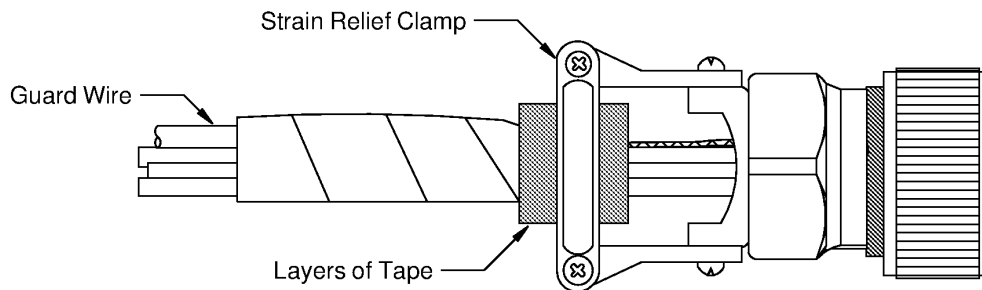


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**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**



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**POSITION OF THE TAPE ON THE WIRE HARNESS**  
**Figure 18**



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**POSITION OF THE TAPE ON THE WIRE HARNESS WITH A GUARD WIRE**  
**Figure 19**

- (9) Assemble the strain relief clamp.

**20-25-17**



**707, 727-787**  
**STANDARD WIRING PRACTICES MANUAL**

**ASSEMBLY OF GLENAIR 627-175 CIRCULAR BACKSHELLS**

- (a) Align the screw holes of the saddle bars with the screw holes in the strain relief legs of the backshell.
- (b) Engage the threads of each installation screw and the applicable screw holes.

Make sure that head of each screw is put in the position that force is applied to the leg of the backshell in a clockwise direction when the screw is tightened.

- (c) Tighten a screw on one side of the clamp with the hand.

**CAUTION:** DO NOT FULLY TIGHTEN ONE SCREW IF THE OTHER SCREW IS NOT INSTALLED. DAMAGE TO THE SADDLE BARS OF THE CLAMP CAN OCCUR.

- (d) Tighten the screw on the other side of the clamp with the hand.
- (e) Torque the screws. Refer to Table 4.

Make sure that:

- The inner surface of the saddle bars are against the outer surface of the legs on the backshell
- The wire harness does not move in the clamp
- Each screw extends a minimum of one thread from the captive fastener
- The clamp holds the wire harness tightly but does not crush the wires or cables.

**20-25-17**