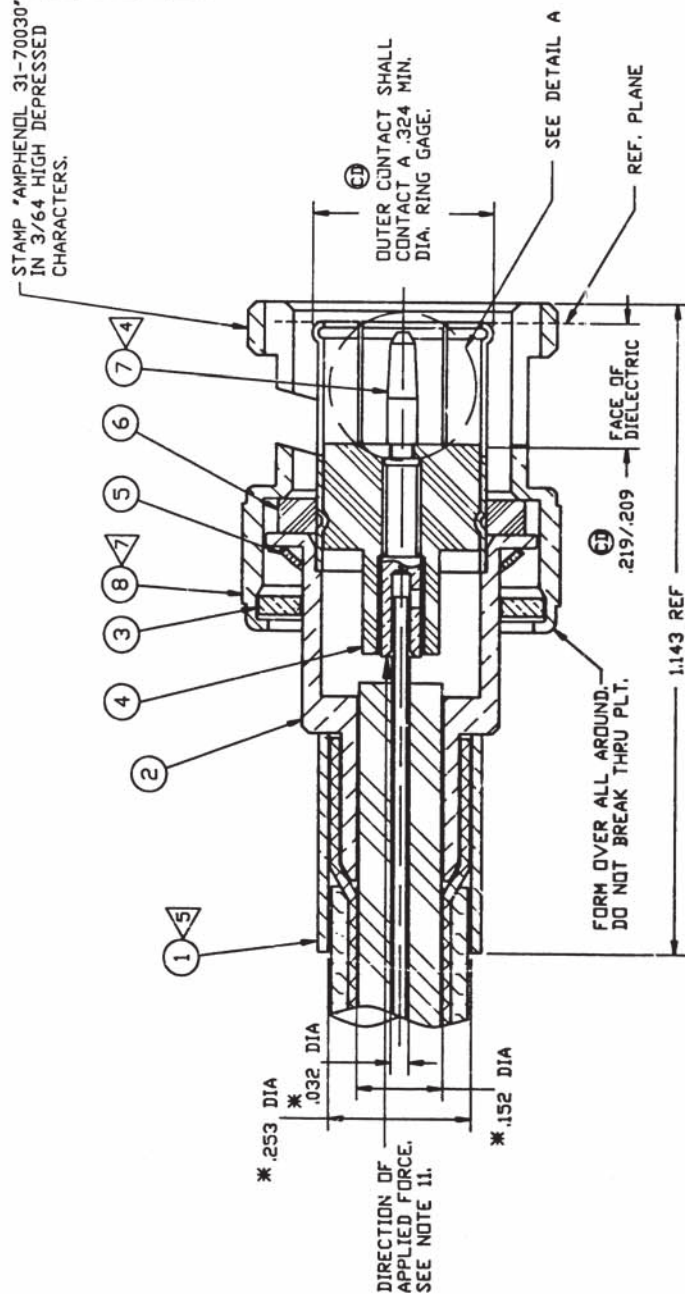


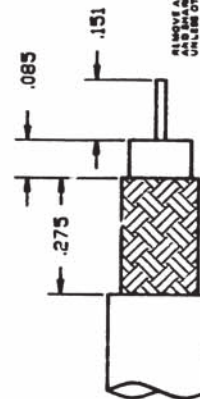
REVISIONS

SYM	DESCRIPTION	DATE	E.C.O. NO.	APPR.
A	OFFICIAL ENG. RELEASE TO MFG.	1/13/89	36077	RM
G	ITEM 7 WAS 31-11245-2	2/15/91	37967	DR
H	TRIMMED 446 FROM DIELECTRIC IN CABLE STOPPING DIM	3-21-91	38025	JIL
J	'ALCATEL' WAS 'RODYSWELL' REV ON ALCATEL WAS BF	2-12-92	38734	DR
K	ADDED CRITICAL DIMENSION TO NOTE 6 & 11	3/6/92	38654	DR
L	DELETED ALCATEL REV; ADDED 349-50559	7/2/92	39044	JM/
M	ADDED NOTE 12 & 13 - CABLE ENTRY DIM - PLATE LETTERS CHANGED NOTE 11 REMOVED NOTE 2 & 3	10/1/92	39185	OR



31-70030	DRAWING NUMBER	ISSUE	M
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1. PLATING MUST CONFORM TO AMPHENOL SPEC. 349-50560. CONTACT IS GOLD PLATED, ALL OTHER METAL PARTS ARE ASTROPLATED (REF).
2. 4 CUSTOMER NOTE: WHEN SOLDERING CONTACT TO CABLE, ROSIN CORE SOFT SOLDER PER QQ-N-571 Sn60 IS RECOMMENDED.
3. WHEN CRIMPING USE AMPHENOL TOOL 227-944 (M2520/5-01) AND DIE SET 227-980-1, CAVITY 'B' (M2520/5-01).
4. CRIMP WITH AMPHENOL TOOL 227-944 (M2520/5-01) AND DIE SET 227-980-1, CAVITY 'A' (M2520/5-01).
5. INSULATOR (ITEM 4) SHALL WITHSTAND AN 8 LB AXIAL FORCE APPLIED IN DIRECTION SHOWN WITH NO EVIDENCE OF MOVEMENT. .219/.209 DIA MUST BE MET.
6. COUPLING NUT (ITEM 8) SHALL WITHSTAND A PULL OF 100 LBS WHEN MATED WITH A RIGIDLY HELD JACK.
7. PACKAGE THIS CONNECTOR IN ANTI-STATIC BAG, PER ROCKWELL SPEC 580-6051 PARA 4.2.
8. CABLES ROCKWELL 425-0893-000, 425-0221-010 AND ROCKWELL 425-1680-030.
9. 10 - INDICATES CRITICAL DIMENSIONS, REQUIRING OPERATOR(SPC) VERIFICATION.
10. MAX CONTACT (ITEM 7) SHALL WITHSTAND A 6 LB. MIN AXIAL FORCE WHEN APPLIED FROM THE REAR OF THE CONNECTOR.
11. ITEMS 1 & 7 WILL BE PACKAGED LOOSE.
12. ASTERISK (*) INDICATES CABLE ENTRY DIM'S.



DETAIL A		A 6 LB. REAR	
PART NO.	QUAN	UOM	DESCRIPTION
31-1357-94G	1	1	FERRULE
31-12040-H	1	1	BODY/OUTER CONTACT S/A
31-914 H	1	3	WASHER
31-12244	1	4	INSULATOR
95631	1	5	SPRING WASHER
82-1535-3	1	6	GASKET
31-12245-2S	1	7	CONTACT, MALE
31-1500 G	1	8	COUPLING NUT

[illegible]