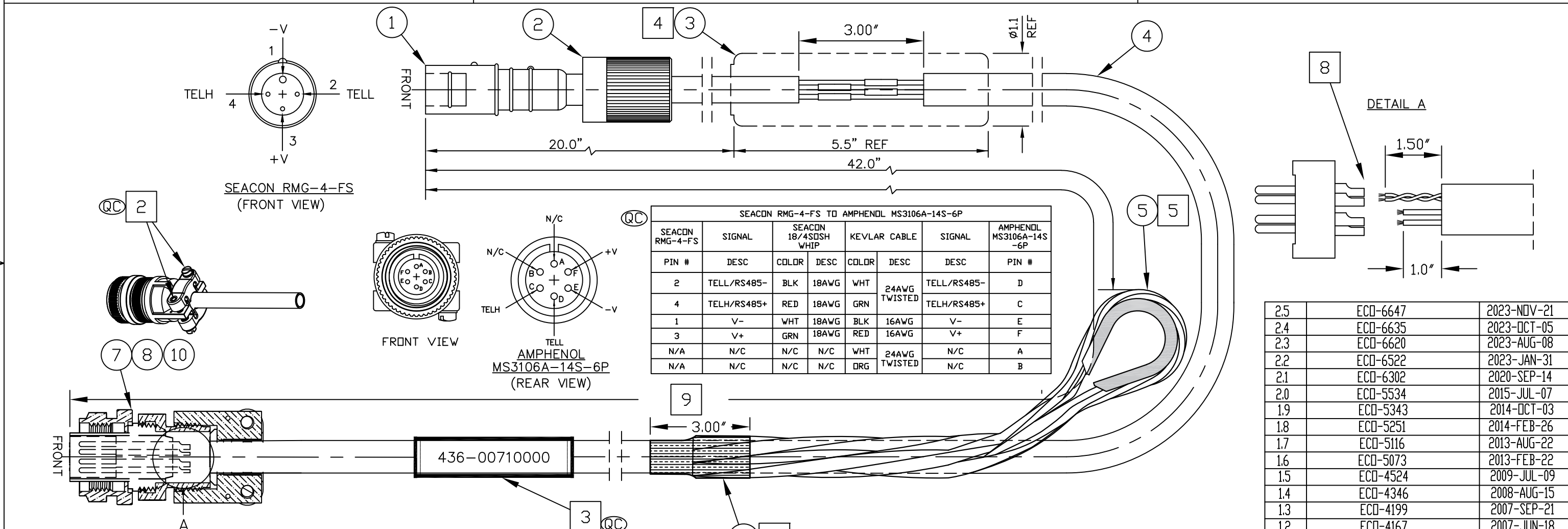
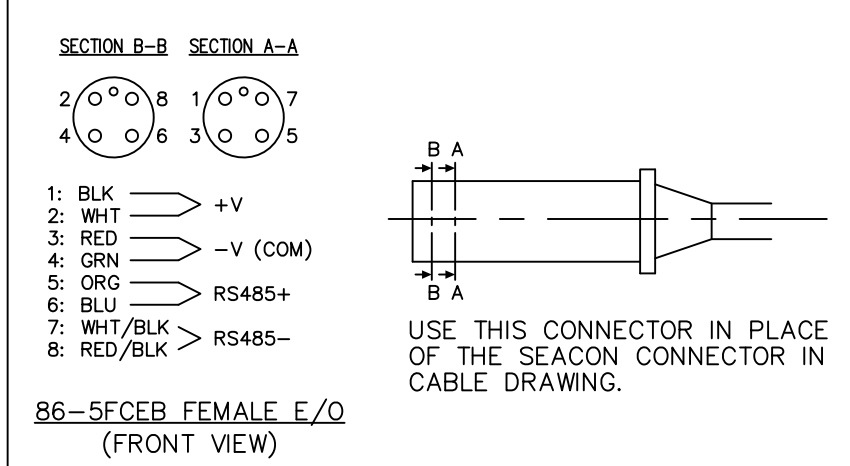
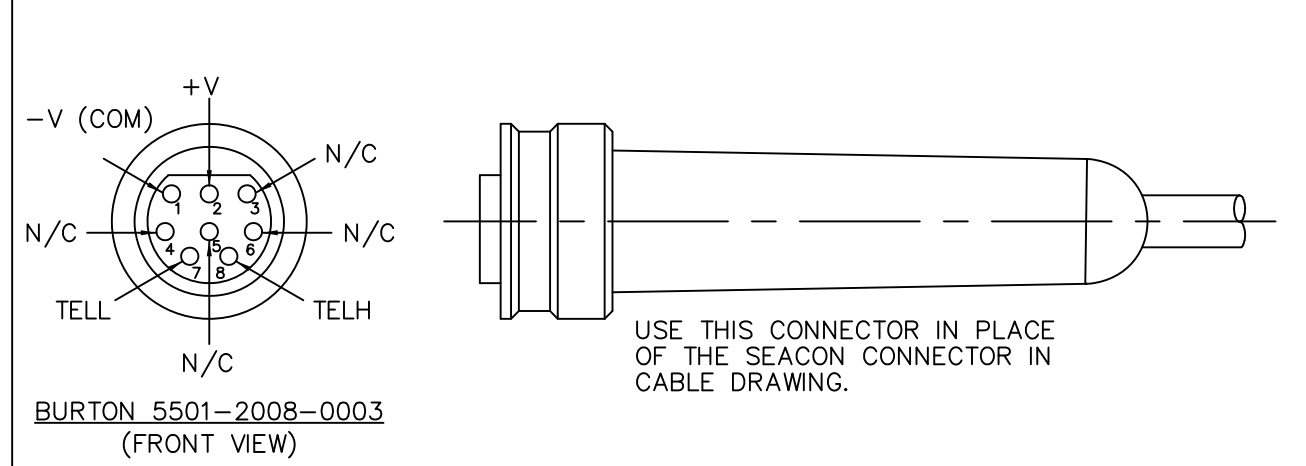
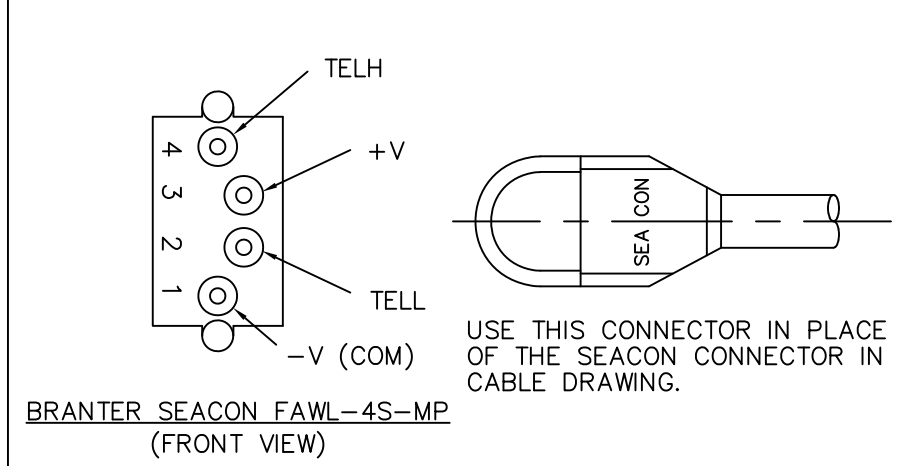


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ISS	DESCRIPTION	DATE
2.5	ECD-6647	2023-NOV-21
2.4	ECD-6635	2023-OCT-05
2.3	ECD-6620	2023-AUG-08
2.2	ECD-6522	2023-JAN-31
2.1	ECD-6302	2020-SEP-14
2.0	ECD-5534	2015-JUL-07
1.9	ECD-5343	2014-OCT-03
1.8	ECD-5251	2014-FEB-26
1.7	ECD-5116	2013-AUG-22
1.6	ECD-5073	2013-FEB-22
1.5	ECD-4524	2009-JUL-09
1.4	ECD-4346	2008-AUG-15
1.3	ECD-4199	2007-SEP-21
1.2	ECD-4167	2007-JUN-18
1.1	ECD-2218	1998-SEP-15

- NOTES:**
- ALL PARTS AND PROCESSES USED ON THIS ASSEMBLY MUST COMPLY WITH THE RoHS DIRECTIVE
  - FOR TOLERANCES PLEASE REFER TO THE TABLE.
  - TIGHTEN THE SCREWS WITH TORQUE SCREW DRIVER SET AT 5Nm
  - BEFORE INSTALLING THE CONNECTOR: PRINT PART# USING 1/8" BLACK TEXT ON WHITE, THEN COVER WITH CLEAR HEATSHRINK.
  - BEFORE MOLDING: INSERT HEATSHRINK FIRST, THEN KELLEMS GRIP STRAIN RELIEF AND THEN SOLDER WIRES. MOLDING DETAILS:
    - ABRADE CABLE JACKET WITH 240 WET/DRY PAPER.
    - POSITION MOLD ALONG CABLE PER ABOVE AND POT WITH 3M SCOTCHCAST 2131 (ITEM3).
  - ORIENT KELLEMS GRIP STRAIN RELIEF ATTACHMENT HOOK (ITEM 5) TOWARDS PIGTAIL (ITEM 1).
  - WRAP 1.50" OF WHIPPING USING BLUE THROW/TYING LINE AND COVER WITH HEATSHRINK, REFER TO ASSEMBLY PROCEDURE LISTED IN THE BOM.
  - USE TWO SHELLS (ITEM 8) WHEN TERMINATING CABLE END. DISCARD SLEEVE, AND LOCKNUT AS NOTED ON BOM.
  - COVER EACH SOLDER JOINT WITH HEATSHRINK.
  - LENGTH IN FT= XXXX IN PART# 436-OPPP0000-XXXX.
  - IMPORTANT TO CHECK.

CABLE AND WIRE LENGTH	TOLERANCE	APPROVALS	NAME	DATE
≤1 FT	+1 IN -0 IN	DRAWN	BMS	1996-NOV-05
>1 FT-5 FT	+2 IN -0 IN	REVISED	DM	2023-NOV-21
>5 FT-10 FT	+4 IN -0 IN	ENGR		
>10 FT-25 FT	+6 IN -0 IN	CHECKED		
>25 FT	+5% -0%	PROD		
		QA		
		ISSUED		

**REVISIONS**

ISS	DESCRIPTION	DATE
2.5	ECD-6647	2023-NOV-21

**Kongsberg Discovery Canada Ltd.**

**CABLE ASSEMBLY  
MODEL 1171 SONAR TO PROCESSOR**

SIZE	DWG. NO.	ISS
B	436-00711000	2.5
SCALE: NTS	W.D. NO.	SHEET 1 OF 1

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