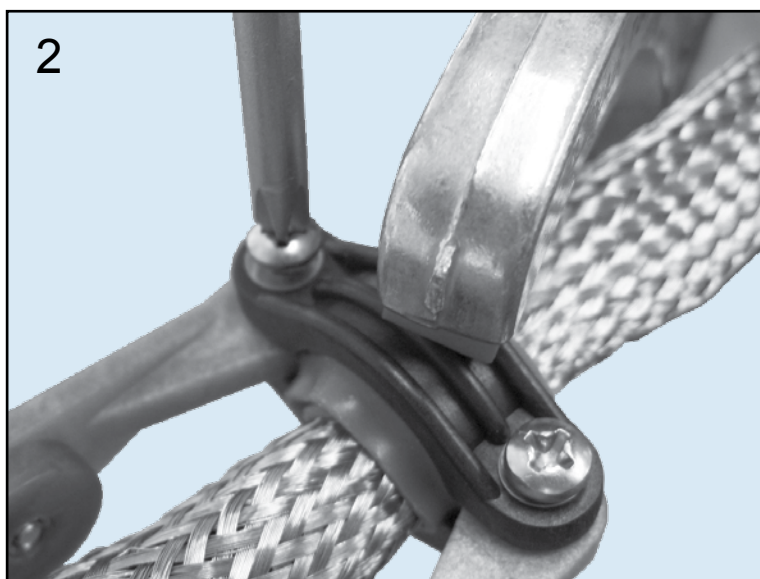
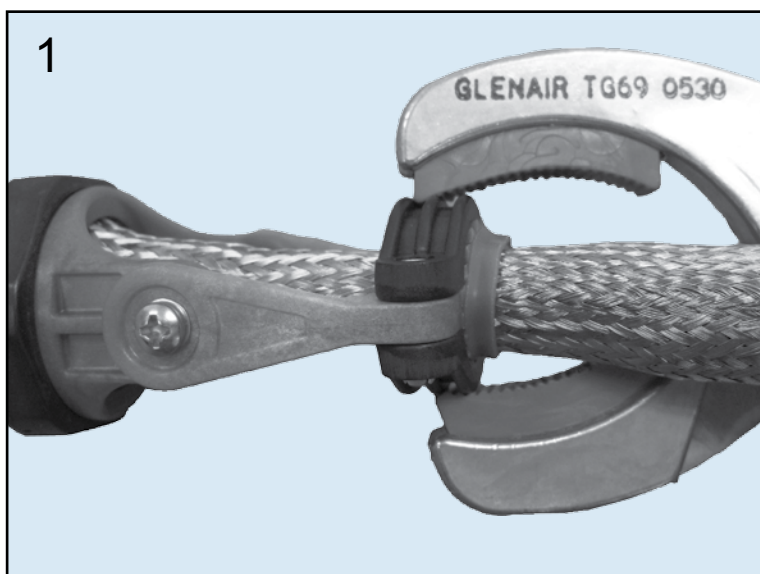


Composite Saddle Clamp Assembly Procedure

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1. After terminating shields, tighten the backshell to the connector and build-up the outside diameter of the wire bundle with AS85049/127 bushing strip to achieve a moderately snug fit against the saddle-bars.
2. Position the saddle-bars on the built-up wire bundle. Then, using Glenair TG69 Soft Jaw pliers, hold the saddle-bars down firmly and evenly against the wire bundle. (See figure 1)
3. Continuing to hold down the saddle bars, tighten clamp screws. Alternate between insertion of both screws so that the saddle bars compress against the cable evenly. Stop when the saddle-bars bottom against the arms of the clamp assembly. (See figure 2)
4. Tighten screws to correct torque values



Saddle Clamp Torque Specifications

Saddle Screw Size	Installation Torque (In/Lbs)
4	4
6	6
10	10