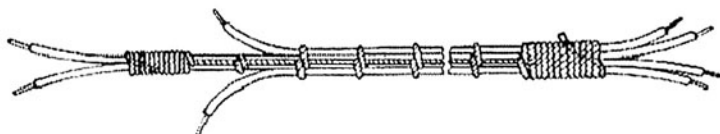
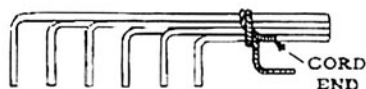


5/8" to 1"	# 9
7/8" and over	# 12

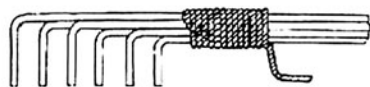
The harness is laced after all wires have been cut to length, stripped, tinned, and placed in position.



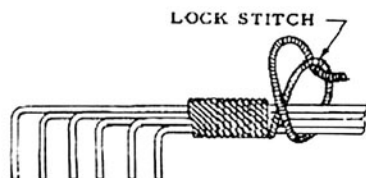
A Finished Harness



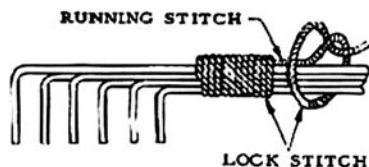
The process of lacing or binding a harness can be started at one end with a *starting tie*. Alternatively, lacing can be started at the center with a *lock stitch*, and a terminating wrap can be used at each end.



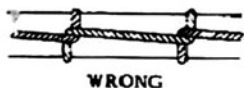
Lacing is started by cutting a length of cord two and one-half times the length of the proposed harness. One end of the cord is laid alongside the principal cable pointing into the harness. The cord end is secured as approximately four turns of cord are wound over it, and wrapping is continued until a total of twelve turns is wound about the principal cable.



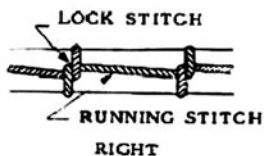
The wrap is secured by a lock stitch. This is made by forming a loop, passing the cord over the loop, then through the loop, and finally pulling the cord tight.



Secure stitches can be formed only by lacing the cord over the loop, never under, to form the so-called *lock stitch*. The cord is thus locked under each loop.



Lock stitches at approximately 1/2-inch intervals thereafter secure other loops in the same fashion.



The foregoing describes the *regulation cableman's knot*, which is self locking.



As lacing is advanced, the wires should be re-formed to insure a neat and firmly bound cable; conductors should be arranged to lie parallel without crossovers except when twisting is required.

Lacing is terminated by the following procedure. Four turns of cord are wrapped adjacent to the last lock stitch. A separate piece of cord is formed into a 2-inch loop and laid