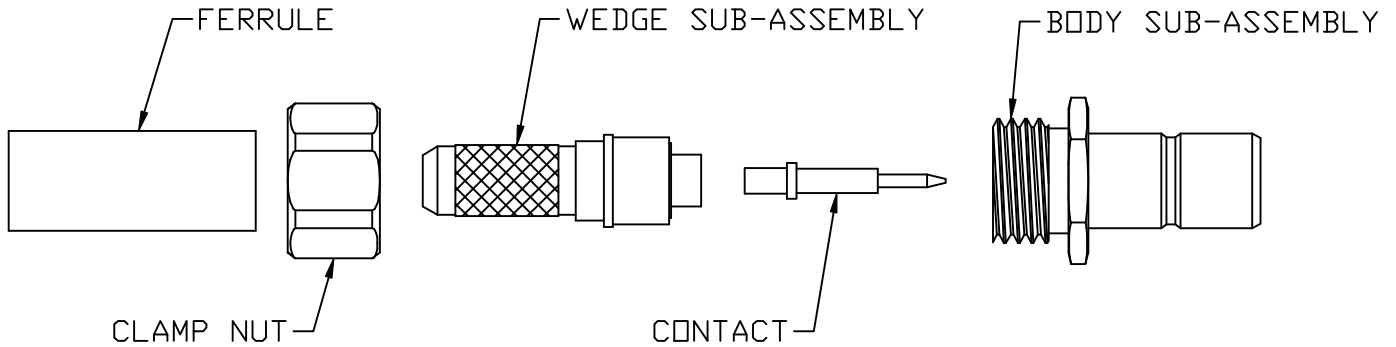
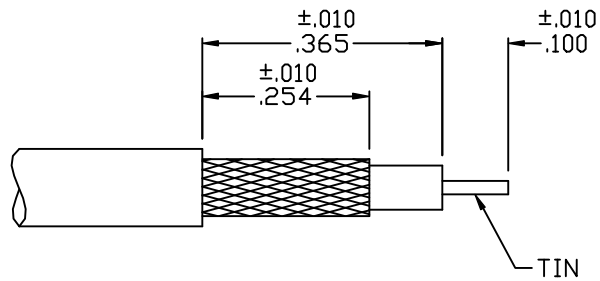


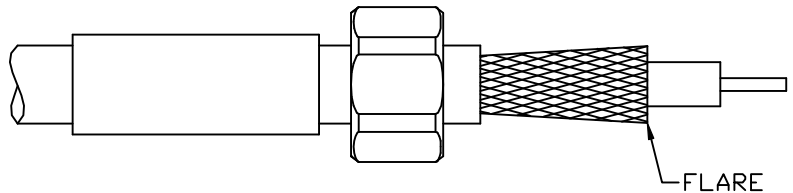
CABLE ASSEMBLY PROCEDURE		 <p>22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794</p>	REV	DESCRIPTION	DATE	APPR
P/N	09-1800-0670		A	PER ECN 1706	3/91	PP
PAGE 1 OF 1	DATE: 3/91		B	PER ECN 8619	08/16/06	JM
DRAWN: YT	APPROVED: JM					
FOR USE WITH RG-174; 188; 179; 316 CABLES						



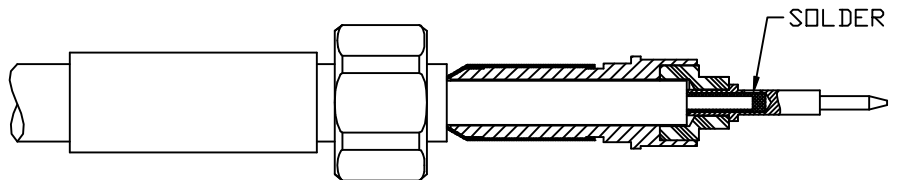
STEP 1  
TRIM CABLE PER DIMENSION  
SHOWN. TIN CENTER CONDUCTOR.



STEP 2  
SLIDE FERRULE AND CLAMP NUT  
ONTO CABLE, FLAIR BRAID BY  
ROTATING DIELECTRIC.



STEP 3  
INSERT WEDGE SUB-ASSEMBLY  
ONTO CABLE, UNDER BRAID  
AND OVER INSULATOR. ASSEMBLE  
CONTACT ONTO CABLE AND  
SOLDER, CLEAN SOLDER JOINT.



STEP 4  
INSERT CABLE SUB-ASSEMBLY INTO BODY  
SUB-ASSEMBLY. SLIDE CLAMP NUT UP  
ONTO BODY AND TIGHTEN NUT (5 TO 7  
IN-LBS.). SLIDE FERRULE OVER  
BRAID, CRIMP FERRULE  
USING .128 HEX DIE (M22520/5-03).

