

CABLE ASSEMBLY PROCEDURE	
P/N	15-0090-2202
PAGE 1 OF 1	DATE: 12/28/99
DRAWN: MY	APPROVED: HN
FOR USE WITH S86208 & TFLEX130-100 CABLES	

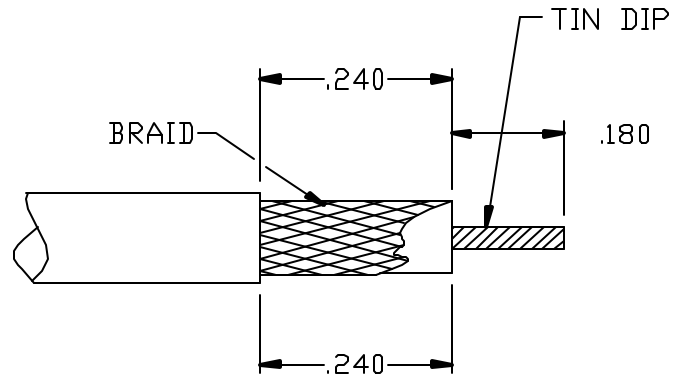
PALCO
CONNECTOR

22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
A	REL. ECN 5320	12/28/99	HN

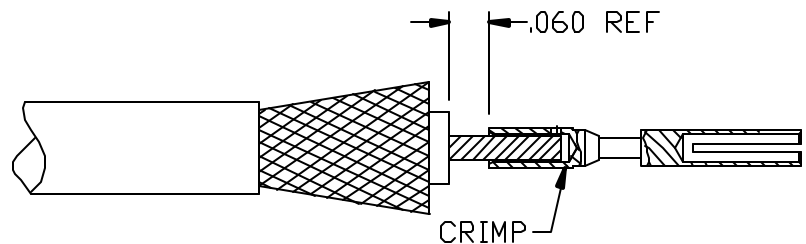
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR TO ϕ .038 MAX.
SLIDE FERRULE OVER CABLE.



STEP 2

PLACE CONTACT ONTO CENTER CONDUCTOR OF CABLE LOCATED AS SHOWN AND CRIMP INTO POSITION USING DANIELS FT8 CRIMPER, SETTING 3 FOR S86208 AND SETTING 2 FOR TFLX130-100 CABLES. PALCO POSITIONER T 0753. ROTATE DIELECTRIC TO FLAIR BRAID.



STEP 3

SLIDE BODY ONTO PREPARED CABLE, OVER DIELECTRIC AND UNDER THE BRAID. TEST SNAP FIT. SLIDE FERRULE UP AGAINST SHOULDER OF BODY AND CRIMP USING .178 HEX DIE. (M22520/5-05).

