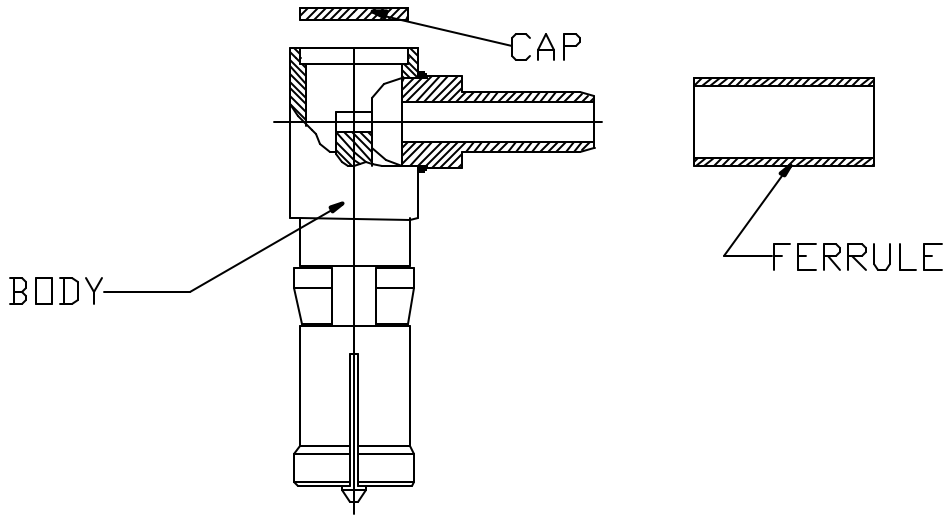


CABLE ASSEMBLY PROCEDURE	
P/N	15-1580-0670
PAGE 1 OF 1	DATE: 12/30/02
DRAWN: RVR	APPROVED: HN
FDR RG	316 CABLE

PALEO
CONNECTOR

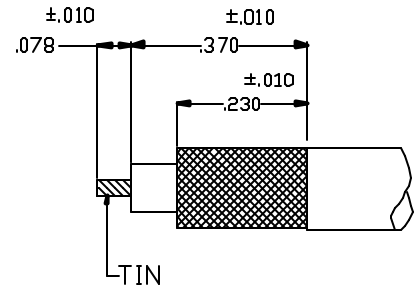
22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
A	PER ECN 6838	12/30/02	HN
D	PER ECN 9169	11/30/07	JM
E	PER ECN 10580	08/31/10	JEM
F	PER ECN 11301	03/15/12	JEM



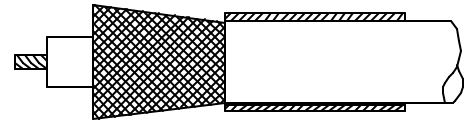
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN
TIN CENTER CONDUCTOR.



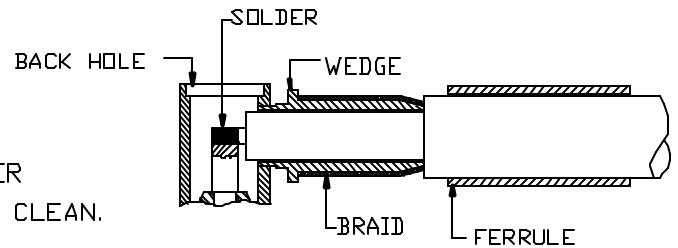
STEP 2

SLIDE FERRULE OVER JACKET. FLAIR BRAID BY ROTATING DIELECTRIC.



STEP 3

INSERT CABLE DIELECTRIC INTO WEDGE AND CENTER CONDUCTOR TO THE SLOT OF CONTACT. SOLDER CENTER CONDUCTOR INTO CONTACT SLOT THROUGH BACK HOLE. CLEAN.



STEP 4

BUTT FERRULE AGAINST SHOULDER. CRIMP FERRULE WITH HEX. .128 DIE SET Y-196 (M22520/5-03). SOLDER CAP INTO BODY. CLEAN.

