

CABLE ASSEMBLY PROCEDURE

P/N 15-1580-1080

PAGE 1 OF 1 DATE: 03/16/00

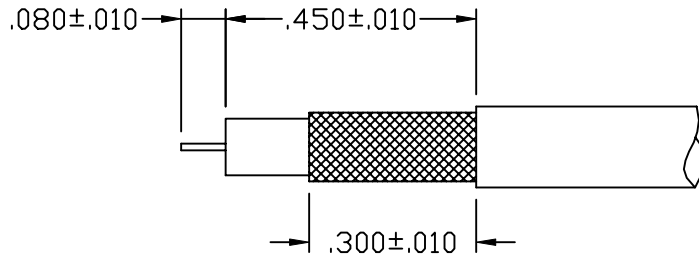
DRAWN: MY APPROVED: HN

FOR USE WITH 180,195 CABLES

PALEO CONNECTOR

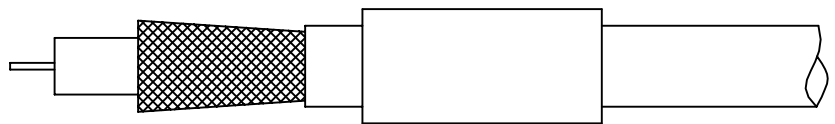
22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
C	REL. PER ECN 5415	03/16/00	HN
D	PER ECN 7090	06/10/03	HN



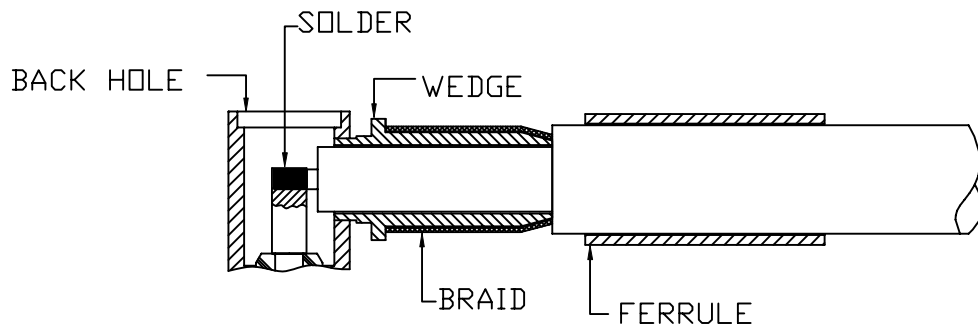
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN
TIN CENTER CONDUCTOR.



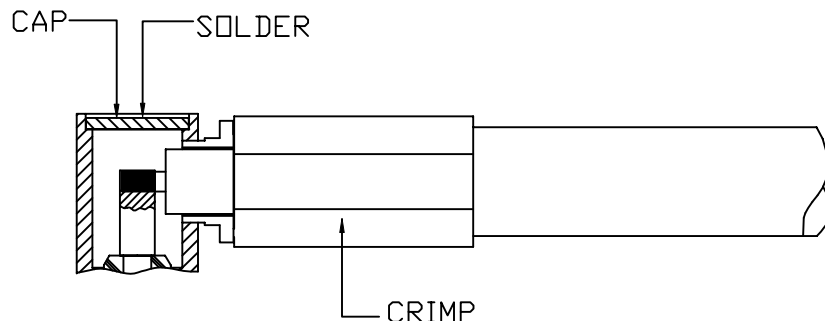
STEP 2

SLIDE FERRULE OVER JACKET. FLAIR BRAID BY ROTATING
DIELECTRIC.



STEP 3

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



STEP 4

BUTT FERRULE AGAINST SHOULDER. CRIMP FERRULE WITH
DANIELS Y-197 USING .178 CRIMP DIE OVER BRAID TO
RETAIN CABLE. SOLDER CAP INTO BODY. CLEAN.