

CABLE ASSEMBLY PROCEDURE	
P/N	15-1580-1201
PAGE 1 OF 1	DATE: 10/23/01
DRAWN: YT	APPROVED: HN
FOR USE WITH 58, 141, 303 CABLE	

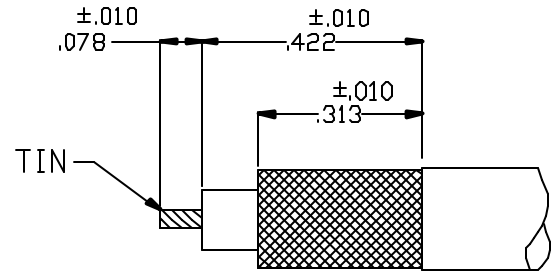
PALEO
CONNECTOR

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

REV	DESCRIPTION	DATE	APPR
A	REL. ECN 5543	10/23/01	HN
B	REL. ECN 6500	03/18/02	HN
C	PER ECN 7776	01/04/05	JEM
D	PER ECN 10581	09/02/10	JEM

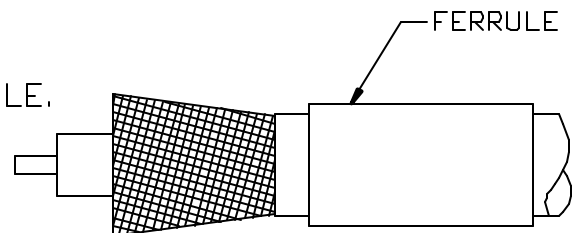
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN
TIN CENTER CONDUCTOR.



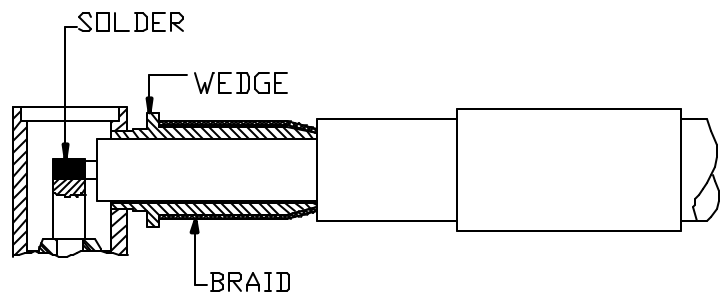
STEP 2

SLIDE FERRULE OVER CABLE.
FLARE BRAID BY ROTATING DIELECTRIC OF CABLE.



STEP 3

INSERT CABLE DIELECTRIC INTO WEDGE AS SHOWN.
SOLDER CENTER CONDUCTOR TO CONTACT.
CLEAN SOLDER JOINT.



STEP 4

SLIDE FERRULE UP AGAINST SHOULDER AS SHOWN.
CRIMP USING .213 HEX DIE (M22520/5-05)
SOLDER CAP INTO BODY
CLEAN SOLDER JOINT

