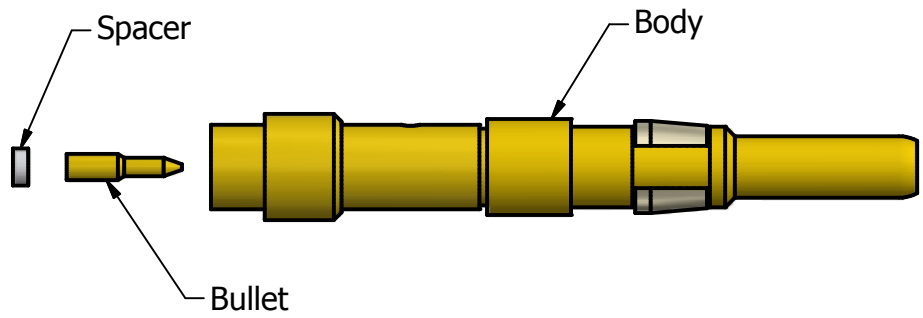


2

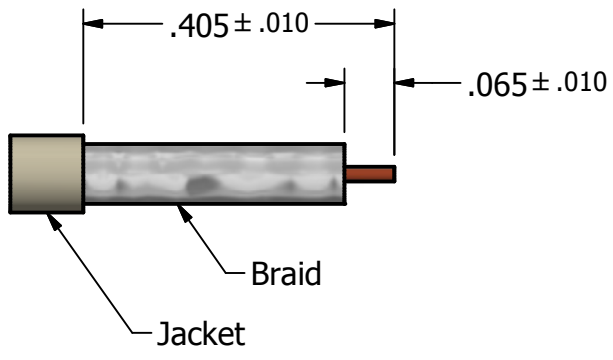
1



B

B

**Step 1**  
 For flex style cables flux end of cable then tin dip into 500°±25°F solder pot for four second maximum. Before trimming cable.

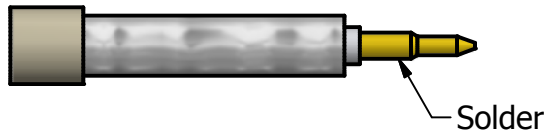


**Step 2**  
 Trim cable to dimensions shown. Tin center conductor.

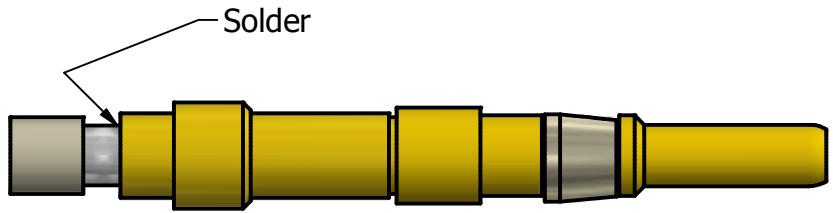
A

A

**Step 3**  
 Install spacer and bullet over center conductor of cable. Solder bullet to center conductor. Clean solder joint.



**Step 4**  
 Insert cable into body until cable bottoms. Solder body to cable jacket. Clean solder joint.



A

A

CAD DRAWING - NO MANUAL REVISIONS  
 filename: \\PALCODC\BigBoy\Drawings from server2\Autodesk Inventor Data Base\Assemblies\156 Series\156-0202-0671-CAP.ipt

**MATERIAL:**

UNLESS OTHERWISE SPECIFIED, PALCO WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR (METRIC)  
 DO NOT SCALE PRINTS  
 TOLERANCES ARE:  
 FRACTIONS: ± 1/64  
 DECIMALS: .XX ± .01  
 .XXX ± .005  
 ANGLES: ± 1/2°

THE INFORMATION IN THIS DOCUMENT IS CONFIDENTIAL AND PROPRIETARY AND MAY NOT BE USED FOR ANY PURPOSE WITHOUT THE WRITTEN CONSENT OF PALCO.

APPROVALS	DATE
DRAWN JEM	02/21/17
CHECKED R.M.B.	02/21/17
QA	
MFG	
ENGINEER JEMaturo	02/21/17
APPROVED R.M.B.	02/21/17

**PALCO CONNECTOR**  
 22 GREAT HILL RD., NAUGATUCK, CT 06770

TITLE  
**Cable Assembly Procedure  
 for 156-0202-0671**

REV.	DESCRIPTION	DATE	APPR.
B	PER ECN 12735	12/5/2017	RMB
A	EL. PER ECN 12429	2/21/2017	RMB

SIZE <b>A</b>	FSCM 58167	DWG NO 156-0202-0671-CAP	REV B	PLATING OPT.
SCALE	F.S.R. #	SHEET 1 OF 1		

2

1