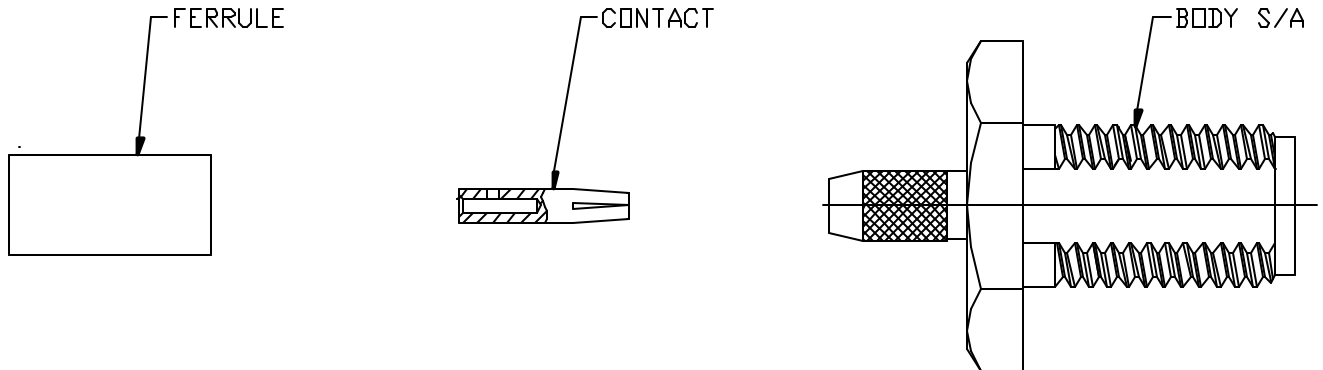


CABLE ASSEMBLY PROCEDURE	
P/N	22-1865-0670
PAGE 1 OF 1	DATE: 05/29/03
DRAWN: YT	APPROVED: HN
FOR USE WITH M17/113-RG316 CABLE	

PALEO
CONNECTOR

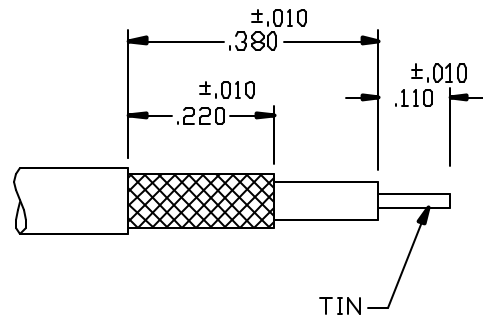
22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
A	REL. ECN 7131	08/06/03	HN
B	PER ECN 9942	06/04/09	JEM



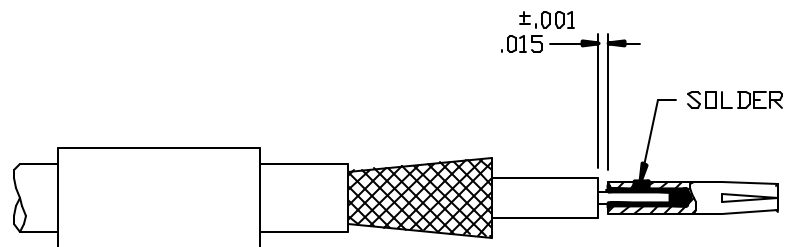
STEP 1

TRIM CABLE TO DIMENSION SHOWN.
TIN CENTER CONDUCTOR.



STEP 2

SLIDE FERRULE OVER CABLE.
FLAIR BRAID BY ROTATING DIELECTRIC.
SOLDER CONTACT AS SHOWN USING .015 SHIM.
CLEAN SOLDER JOINT IF REQUIRED.



STEP 3

SLIDE BODY S/A OVER CABLE AND UNDER THE BRAID.
SLIDE FERRULE UNTILL IT BUTTS BODY SHOULDER.
CRIMP USING Y-196 DIE SET (M22520/5-03) .128 HEX.

