

CABLE ASSEMBLY PROCEDURE

P/N 22-2800-0400J

PAGE 1 OF 1 DATE: 12/12/17

DRAWN: BH APPROVED: JEM

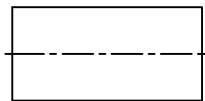
FOR USE WITH RD-316 CABLE

PALEO
CONNECTOR

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

REV	DESCRIPTION	DATE	APPR
A	PER ECN 12740	12/12/17	JEM

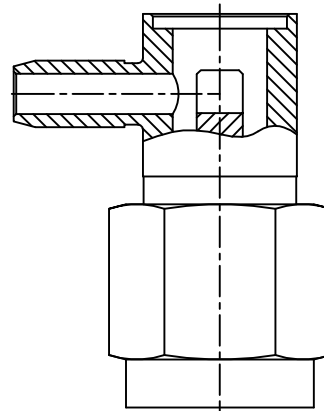
FERRULE



CAP

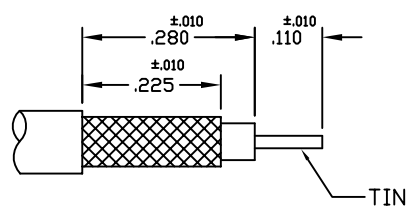


BODY SUB-ASSEMBLY



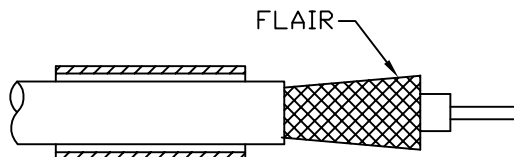
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR.



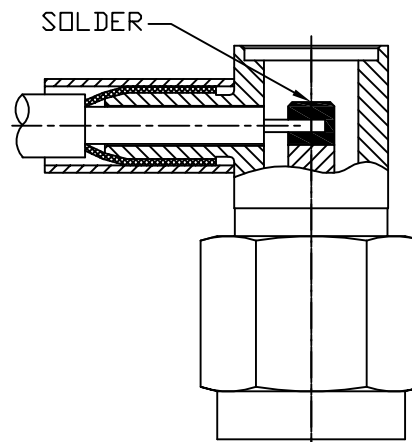
STEP 2

SLIDE FERRULE OVER CABLE.
FLAIR CABLE BRAID AS SHOWN.



STEP 3

INSERT CABLE INTO BODY SUB-ASS'Y UNTIL END OF
DIELECTRIC IS FLUSH WITH INSIDE OF CONNECTOR CAVITY.
SOLDER CENTER CONDUCTOR TO CENTER CONTACT.
CLEAN SOLDER JOINT AS NEEDED.
SLIDE FERRULE OVER BRAID AS SHOWN.
CRIMP FERRULE USING .105 HEX DIE (M22520/5-03)



STEP 4

PRESS CAP INTO BODY WITH PUNCH T650-031P.
PLUG SHOULD BE DRIVEN SQUARE TO THE HOLE.
THE SHOULDER OF THE PUNCH SHOULD BOTTOM OUT
ON THE BODY.

