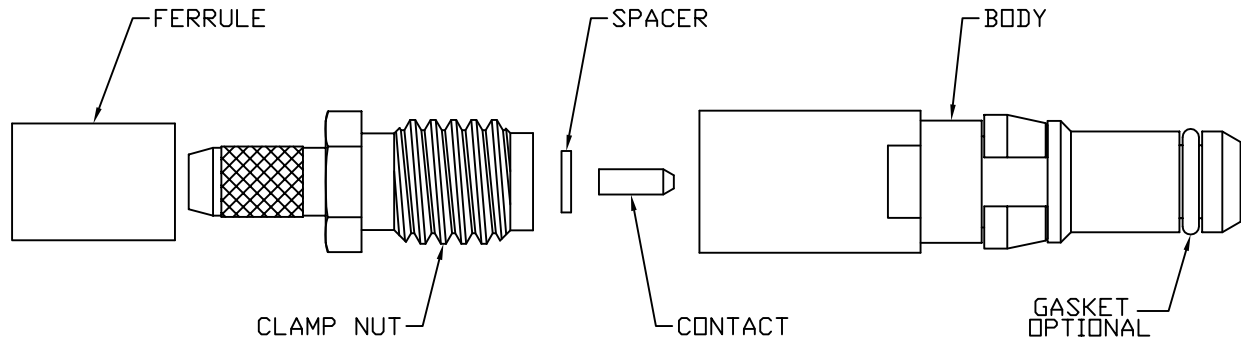


CABLE ASSEMBLY PROCEDURE	
P/N	26-008X-0670
PAGE 1 OF 1	DATE: 08/18/99
DRAWN: EK	APPROVED: JEM
FOR USE WITH RG-316 CABLE	

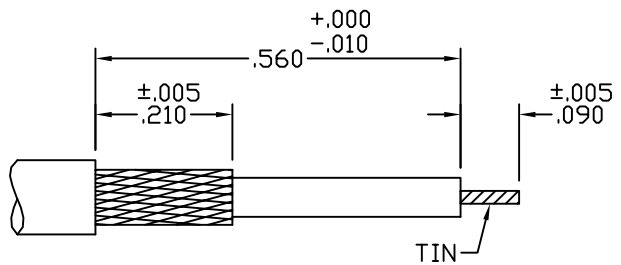
PALEO
CONNECTOR

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

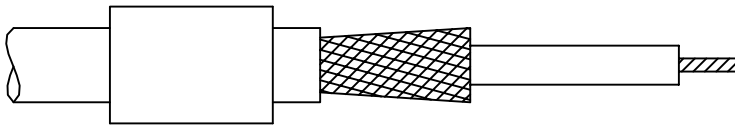
REV	DESCRIPTION	DATE	APPR
0	PER ECN 10128	12/15/09	JEM
P	PER ECN 10292	04/20/10	JEM
R	PER ECN 10690	11/08/10	JEM
S	PER ECN 11706	07/09/13	JEM



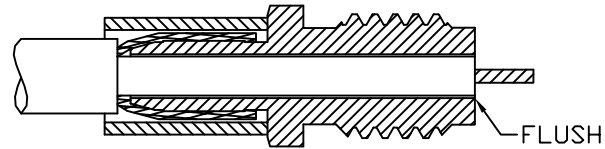
STEP 1
TRIM CABLE TO DIMENSIONS SHOWN. TIN CENTER CONDUCTOR AND CLEAN SOLDER JOINT.



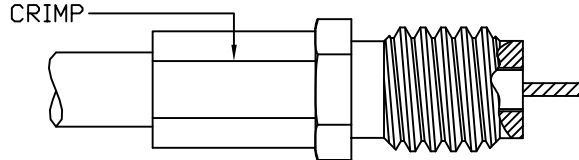
STEP 2
SLIDE FERRULE OVER CABLE AND FLAIR BRAID BY ROTATING DIELECTRIC.



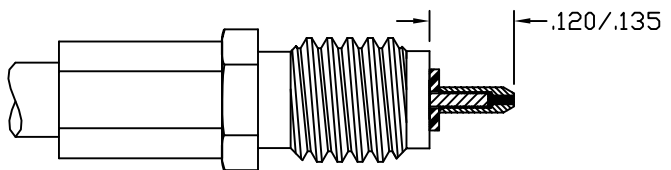
STEP 3
INSERT THE BARREL OF THE CRIMP NUT BETWEEN THE BRAID AND DIELECTRIC, POSITIONED SO THAT THE END OF THE CABLE DIELECTRIC IS FLUSH WITH THE END OF THE CRIMP NUT.



STEP 4
SLIDE THE FERRULE AGAINST THE SHOULDER OF THE CRIMP NUT AND CRIMP USING .128 HEX DIE (M22520/5-03).



STEP 5
PLACE THE SPACER AGAINST THE CRIMP NUT. SLIDE THE BULLET OVER THE CENTER CONDUCTOR. USING RESISTANCE SOLDERING TWEEZERS, APPLY HEAT TO THE BULLET TO REFLOW THE SOLDER, CLEAN SOLDER JOINT.



STEP 6
THREAD CONNECTOR BODY ONTO THE CRIMP NUT ASSEMBLY, TIGHTEN TO 7-10 IN-LBS.

