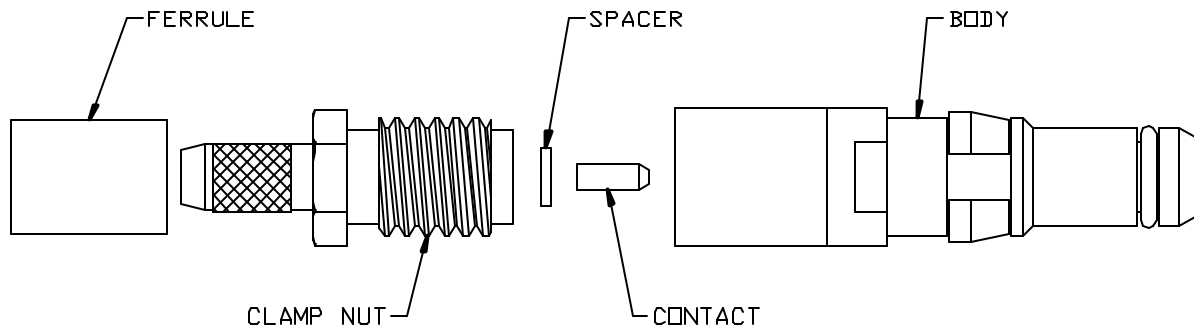


CABLE ASSEMBLY PROCEDURE	
P/N	26-008X-2670
PAGE 1 OF 1	DATE: 11/21/97
DRAWN: JEM	APPROVED: HN
FOR USE WITH M17/152 CABLE	

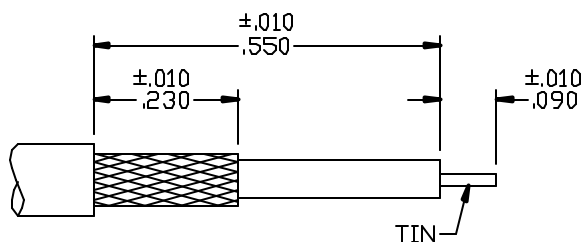
PALEO
CONNECTOR

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

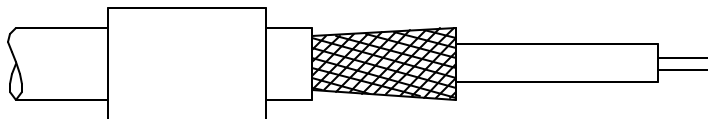
REV	DESCRIPTION	DATE	APPR
C	PER ECN 5256	10/01/99	HN
D	PER ECN 10118	12/09/09	JEM
E	PER ECN 10291	04/20/10	JEM
F	PER ECN 10692	11/09/10	JEM



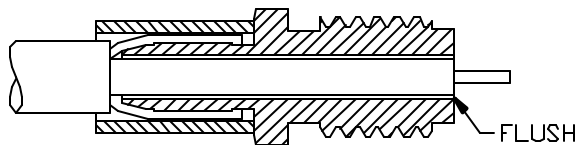
STEP 1
TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR AND CLEAN
SOLDER JOINT.



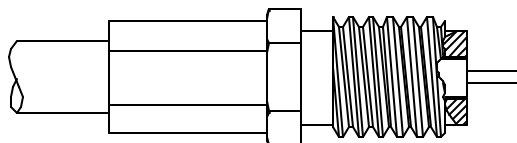
STEP 2
SLIDE FERRULE OVER CABLE
AND FLAIR BRAID BY ROTATING
DIELECTRIC.



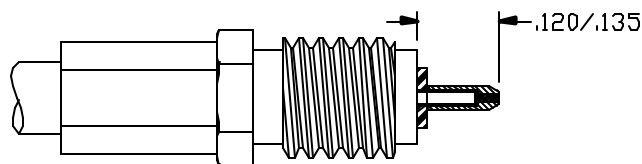
STEP 3
INSERT THE BARREL OF THE CRIMP NUT
BETWEEN THE BRAID AND DIELECTRIC,
POSITIONED SO THAT
THE END OF THE CABLE DIELECTRIC IS FLUSH
WITH THE END OF THE CRIMP NUT.



STEP 4
SLIDE THE FERRULE AGAINST THE SHOULDER
OF THE CRIMP NUT AND CRIMP USING .151 HEX
DIE (M22520/5-37).



STEP 5
PLACE THE SPACER AGAINST THE CRIMP
NUT. SLIDE THE BULLET OVER THE CENTER
CONDUCTOR. USING RESISTANCE SOLDERING
TWEETERS, 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.

