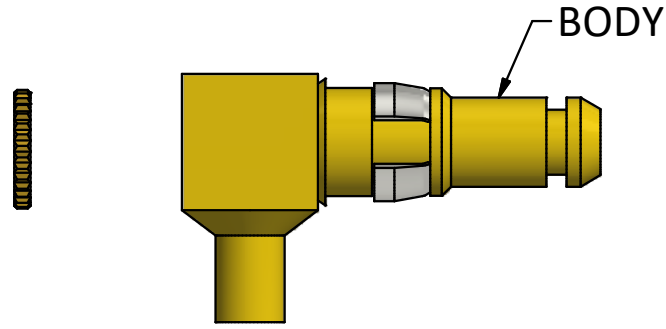


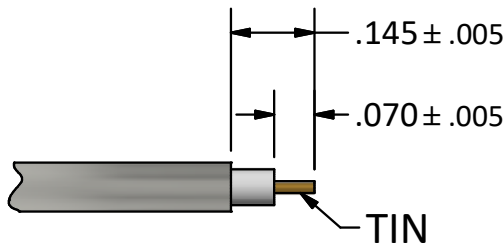
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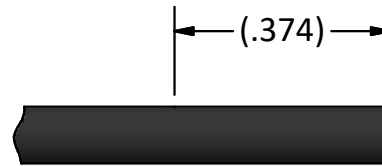


CABLE ASSEMBLY PROCESS

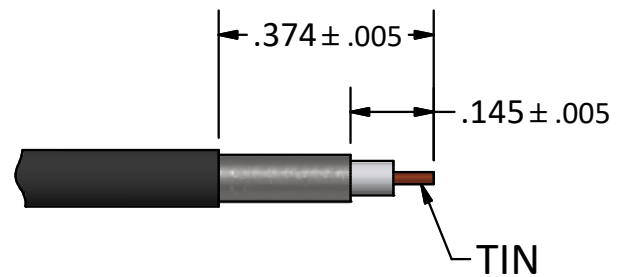
Step 1
Trim semi-rigid cable
to dimensions shown.
Tin center conductor.



Step 1a
Flux & tin dip flex cable
to dimension shown.



Step 1b
Trim flex cable
to dimensions shown.
Tin center conductor.



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				DRAWN	MY	8/17/89	CABLE ASSEMBLY PROCESS FOR: PKZ® RIGHT ANGLE PLUG, DIRECT SOLDER TERMINATION				
CHECKED	HN	8/17/89	SIZE	FSCM	DWG NO	REV					PLATING OPT.
QA			A	58167	26-0520-0860	K					
MFG			SCALE		F.S.R. #						SHEET 1 OF 2
ENGINEER	YT	8/17/89									
APPROVED	HN	8/17/89									
REV.	DESCRIPTION	DATE	BY								

2

1

2

1

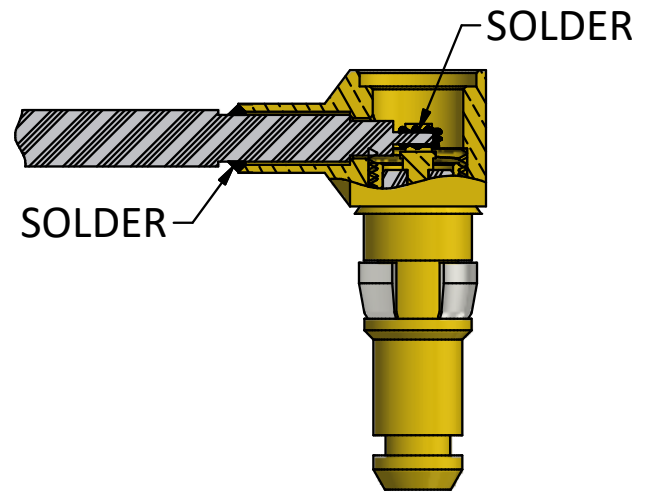
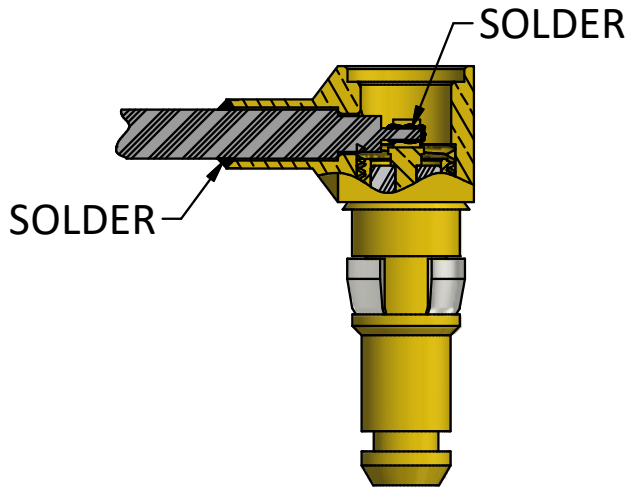
Step 2

Insert semi-rigid cable into body until cable bottoms in body. Solder cable jacket into body. Then solder center conductor to center contact of connector.

Step 2

Insert flex cable into body until cable bottoms in body. Solder body to cable braid. Then solder center conductor to center contact of connector.

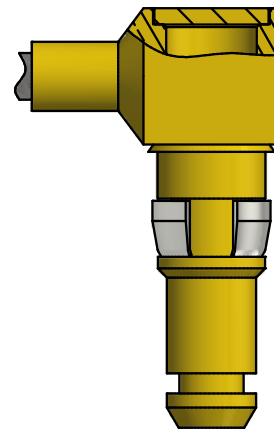
B



B

Step 3

Clean and inspect the solder joints. Fixture body into a small arbor press. Press cap into body being careful not to damage connector.



A

A

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.XXX ± .003
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APPROVALS		DATE
DRAWN	MY	8/17/89
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MFG		
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APPROVED	HN	8/17/89

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TITLE						CABLE ASSEMBLY PROCESS FOR: PkZ® RIGHT ANGLE PLUG, DIRECT SOLDER TERMINATION		
SIZE	FSCM	DWG NO	REV	PLATING OPT.				
A	58167	26-0520-0860	K					
SCALE		F.S.R. #	SHEET 2		OF 2			

2

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