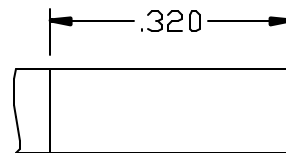
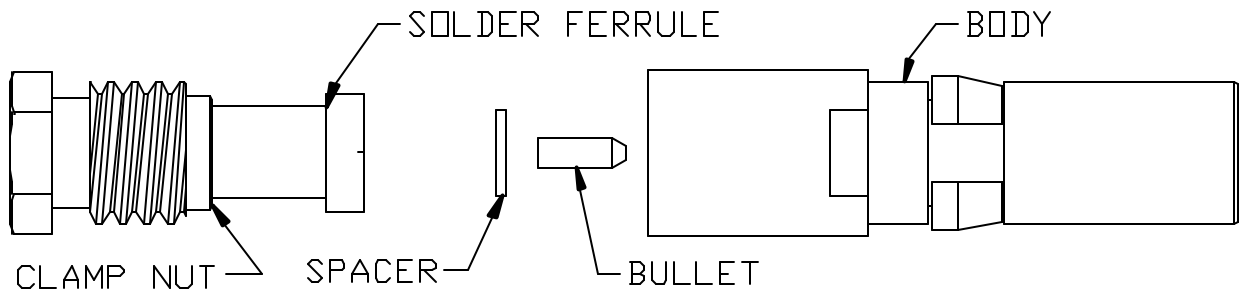


CABLE ASSEMBLY PROCEDURE	
P/N	26-1030-2670
PAGE 1 OF 1	DATE: 07/06/98
DRAWN: EK	APPROVED: JEM
FOR RD-316 D/S (M17/152) CABLE	

PALEO
CONNECTOR

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

REV	DESCRIPTION	DATE	APPR
E	PER ECN 9707	12/10/08	JEM
F	PER ECN 10281	04/14/10	JEM
G	PER ECN 10700	11/10/10	JEM
H	PER ECN 11012	06/27/11	JEM

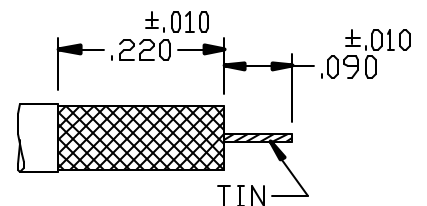


STEP 1

FLUX AND TIN DIP FOR 10 SEC. TO DIMENSION SHOWN.

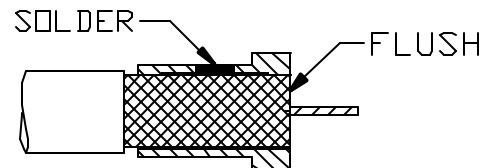
STEP 2

STRIP DIELECTIC TO EXPOSE CENTER CONDUCTOR.
STRIP JACKET TO EXPOSE DOUBLE BRAID.
TIN CENTER CONDUCTOR.



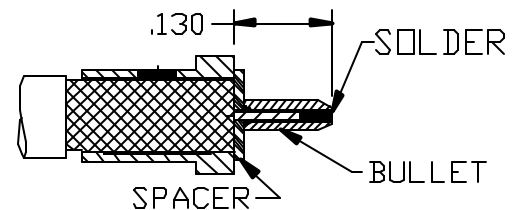
STEP 3

SLIDE CLAMP NUT AND SOLDER FERRULE ONTO CABLE (SLIGHTLY TWISTING). SET FRONT SHOULDER OF SOLDER FERRULE FLUSH WITH CABLE AND SOLDER. CLEAN SOLDER JOINT.



STEP 4

SLIDE SPACER AND BULLET OVER CENTER CONDUCTOR OF CABLE. SOLDER BULLET TO CABLE. CLEAN SOLDER JOINT.



STEP 5

INSERT CABLE ASSEMBLY INTO BODY AND TIGHTEN CLAMP NUT TO 90-100 IN-OZS.

