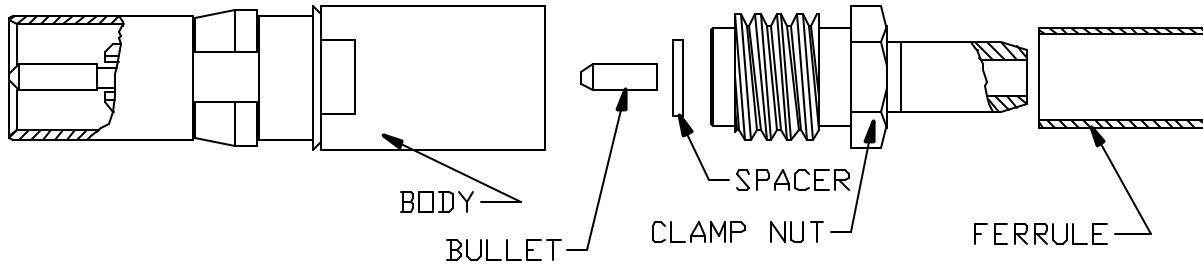
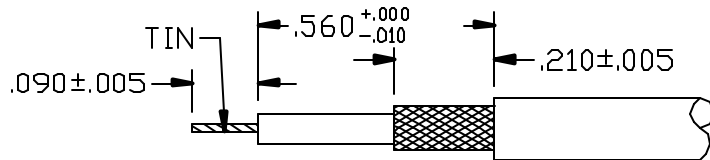


| | | | | | | |
|-----------------------------------|----------------|---|-----|---------------|----------|------|
| CABLE ASSEMBLY PROCEDURE | | <p style="text-align: center;">PALEO</p> <p style="text-align: center;">CONNECTOR</p> <p>22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794</p> | REV | DESCRIPTION | DATE | APPR |
| P/N | 26-1080-0670 | | P | PER ECN 9273 | 2/25/08 | JEM |
| PAGE 1 OF 1 | DATE: 02/14/96 | | Q | PER ECN 9706 | 12/10/08 | JEM |
| DRAWN: MY | APPROVED: HN | | R | PER ECN 10294 | 04/20/10 | JEM |
| FOR USE WITH M17/152-RG 316 CABLE | | | S | PER ECN 10702 | 11/10/10 | JEM |



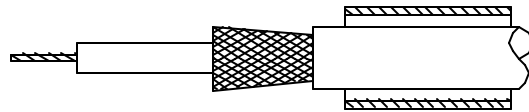
STEP 1

STRIP CABLE TO DIMENSIONS SHOWN. FLUX AND TIN CENTER CONDUCTOR. CLEAN.



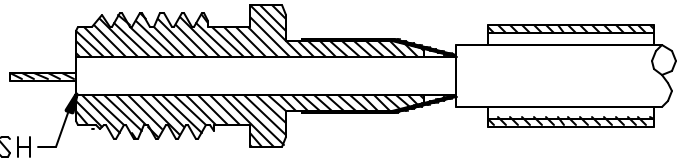
STEP 2

SLIDE FERRULE OVER CABLE. FLARE BRAID BY ROTATING DIELECTRIC.



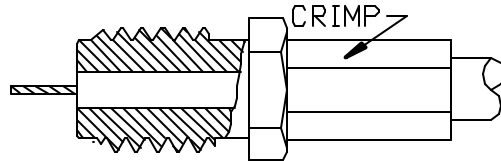
STEP 3

INSERT THE BARREL OF THE CRIMP NUT BETWEEN THE CABLE BRAID AND DIELECTRIC. POSITION SO THE END OF THE CABLE DIELECTRIC IS FLUSH WITH THE END OF CRIMP NUT.



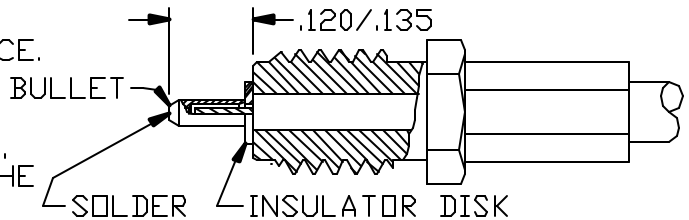
STEP 4

SLIDE FERRULE AGAINST SHOULDER AND CRIMP USING .128 HEX. DIE (M22520/5-03)



STEP 5

PLACE INSULATOR DISK AGAINST NUT SURFACE. SLIDE BULLET OVER CENTER CONDUCTOR. USING RESISTANCE SOLDERING TWEEZERS, APPLY HEAT TO BULLET TO REFLOW SOLDER. INSURE THAT BULLET IS BUTTED AGAINST THE DISK. CLEAN. INSPECT SOLDER JOINT.



STEP 6

THREAD CONNECTOR BODY ONTO CRIMP NUT ASSEMBLY. TIGHTEN TO 7- 10 IN-LBS.

