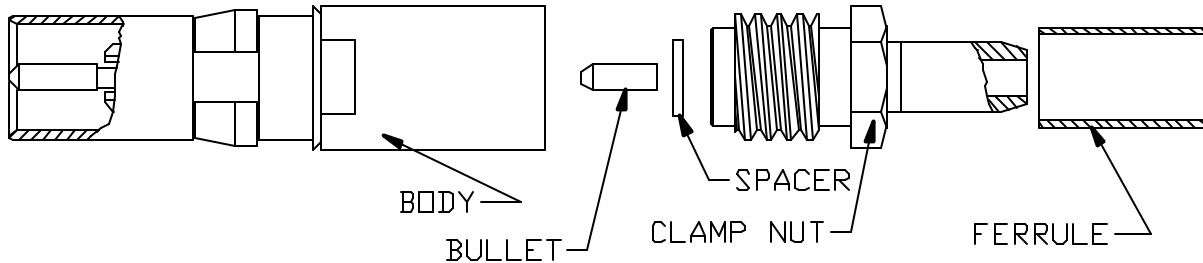


CABLE ASSEMBLY PROCEDURE	
P/N	26-1080-2670
PAGE 1 OF 1	DATE: 04/16/98
DRAWN: EK	APPROVED: HN
FOR USE WITH M17/152-RG 316D.S.CABLE	

PALEO CONNECTOR

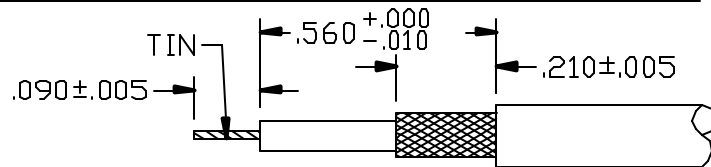
22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
D	PER ECN 7632	09/21/04	JEM
E	PER ECN 9698	12/09/08	JEM
F	PER ECN 10295	04/21/10	JEM
G	PER ECN 10704	11/10/10	JEM



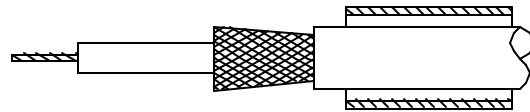
STEP 1

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



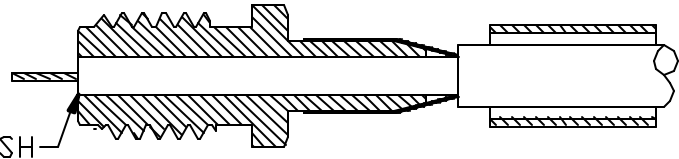
STEP 2

SLIDE FERRULE OVER CABLE. FLARE BRAID BY ROTATING DIELECTRIC.



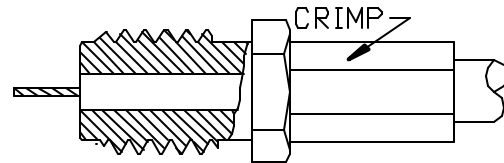
STEP 3

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.



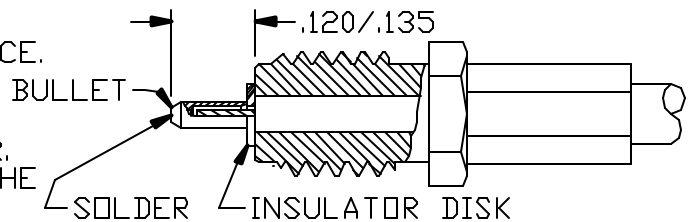
STEP 4

SLIDE FERRULE AGAINST SHOULDER AND CRIMP USING .151 HEX. DIE (M22520/5-37)



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.

