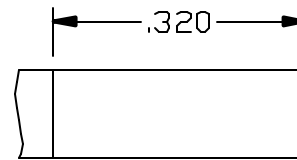
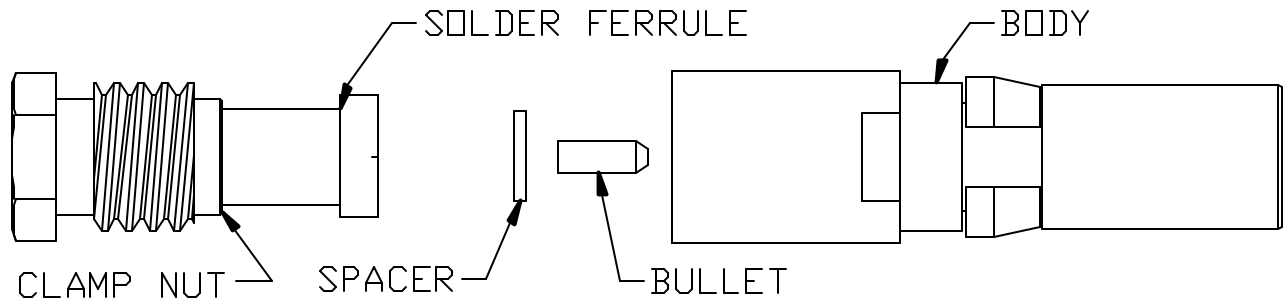


CABLE ASSEMBLY PROCEDURE	
P/N	26D-1030-2670
PAGE 1 OF 1	DATE: 07/06/98
DRAWN: YS	APPROVED: JEM
FOR M17/152 (RG-316 D/S) CABLE	

**PALEO**  
**CONNECTOR**

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

REV	DESCRIPTION	DATE	APPR
E	PER ECN 9530	09/25/08	JEM
F	PER ECN 9652	11/21/08	JEM
G	PER ECN 10701	11/10/10	JEM
H	PER ECN 11001	06/22/11	JEM

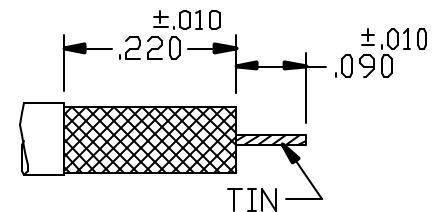


STEP 1

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

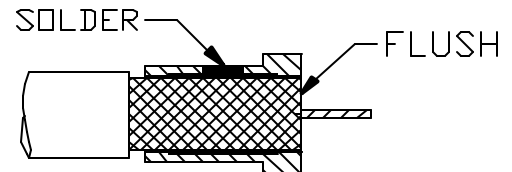
STEP 2

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



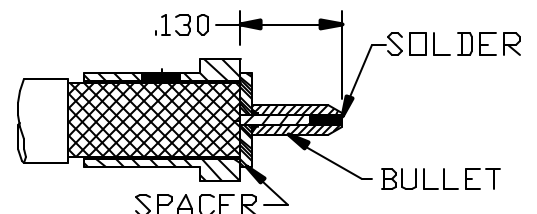
STEP 3

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 ASSEMBY INTO BODY AND TIGHTEN CLAMP NUT TO 7-10 IN-LBS.

