

CABLE ASSEMBLY PROCEDURE

P/N 33-2800-0670

PAGE 1 OF 1 07/14/95

DRAWN: YS APPROVED: JEM

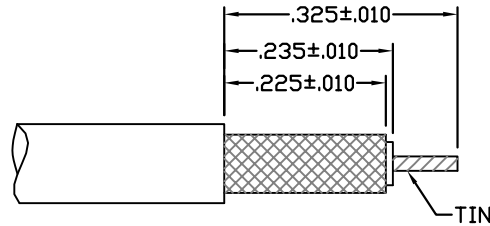
USE WITH M17/113-RG316 CABLE

**PALEO**  
CONNECTOR

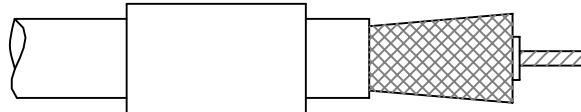
22 GREAT HILL ROAD, NAUGATUCK, CT. 06770  
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
J	PER ECN 7928	04/07/05	JEM
K	PER ECN 8345	01/23/06	JEM
L	PER ECN 9245	1/23/08	JEM
M	PER ECN 12495	04/06/17	JEM

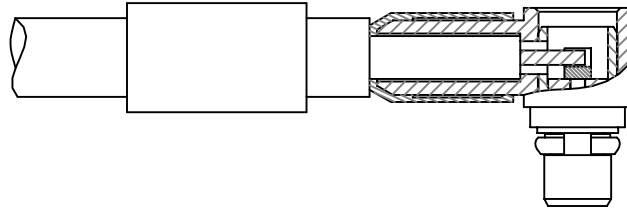
STEP 1  
TRIM CABLE TO DIMENSIONS  
SHOWN AND TIN CENTER CONDUCTOR.



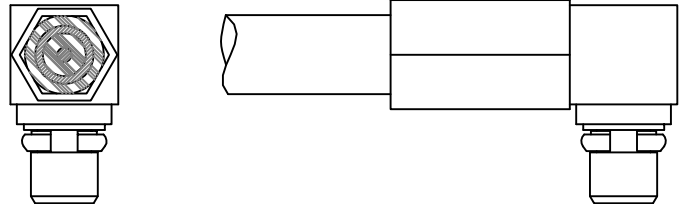
STEP 2  
SLIDE FERRULE OVER CABLE.  
FLAIR BRAID BY ROTATING  
CABLE DIELECTRIC.



STEP 3  
INSERT CONNECTOR BODY BETWEEN  
CABLE DIELECTRIC AND BRAID.



STEP 4  
SLIDE FERRULE OVER BRAID.  
ALIGN CRIMP DIE SO THAT A  
HEX FLAT IS FORMED PARALLEL  
TO THE MATING SURFACE AS SHOWN.  
CRIMP USING .128 HEX DIE (M22520/5-03).



STEP 5  
SOLDER CABLE CENTER CONDUCTOR  
TO CONNECTOR CENTER CONTACT  
THROUGH BACK HOLE. CLEAN.  
PRESS CAP INTO BACK HOLE  
UNTIL FLUSH.

