

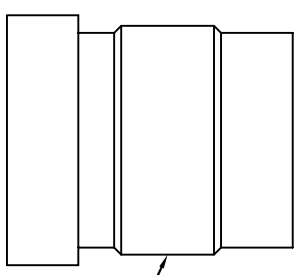
CABLE ASSEMBLY PROCEDURE	
P/N	68-002X-0861
PAGE 1 OF 2	DATE: 10/06/97
DRAWN: EK	APPROVED: JEM
FOR USE WITH RG-405 CABLE	

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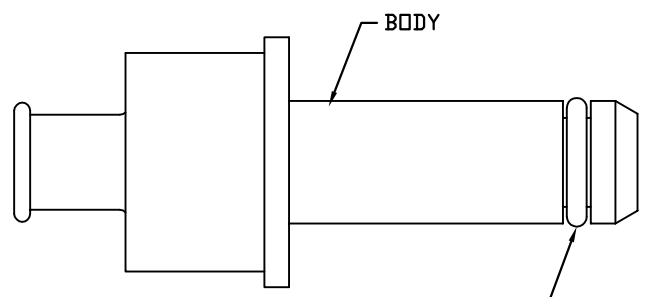
REV	DESCRIPTION	DATE	APPR
I	PER ECN 12694	11/14/17	JEM
J	PER ECN 13062	08/03/18	JEM
K	PER ECN 13383	07/02/19	JEM

NOTES: 1) DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].

RG-405 CABLE



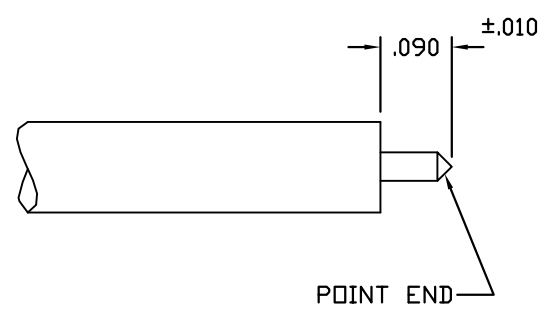
STABILIZING RING
(68-0022-0861 ONLY)



BODY

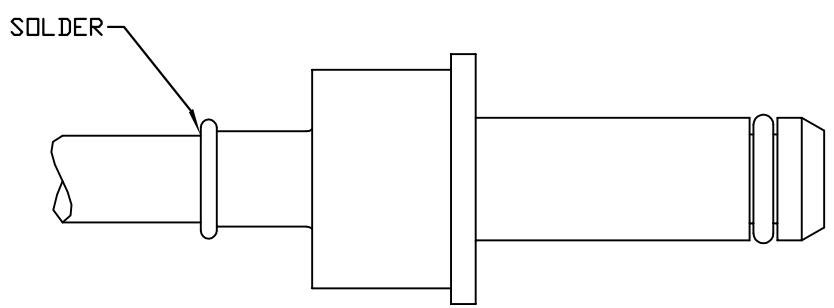
GASKET
(OPTIONAL)

STEP 1
 *STRIP CABLE TO DIMENSION SHOWN.
 POINT END 90°.



*NOTE: ON 68-0022-0861 SLIDE STABILIZING RING ON FIRST.

STEP 2
 SLIDE PREPARED CABLE INTO CONNECTOR
 BODY AND SOLDER, CLEAN SOLDER JOINT.



CABLE ASSEMBLY PROCEDURE	
P/N	68-002X-0861
PAGE 2 OF 2	DATE: 10/06/97
DRAWN: EK	APPROVED: JEM
FOR USE WITH TFLEX 405 CABLE	

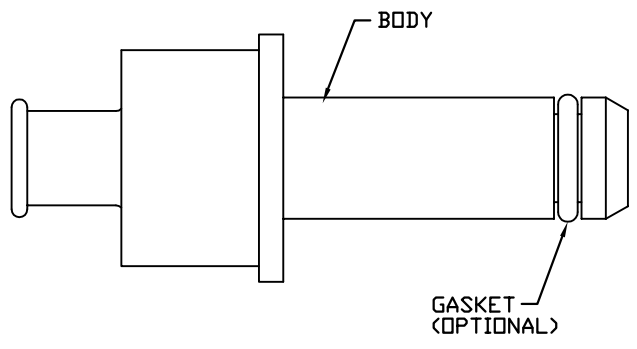
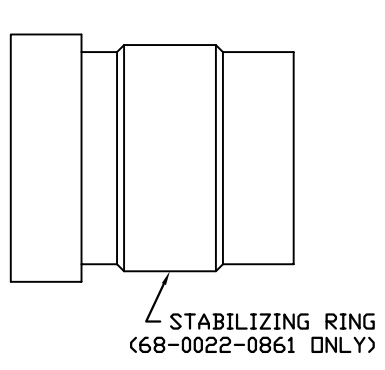
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REV	DESCRIPTION	DATE	APPR
H	PER ECN 11766	09/12/13	JEM
I	PER ECN 12694	11/14/17	JEM
J	PER ECN 13062	08/03/18	JEM
K	PER ECN 13391	07/02/19	JEM

NOTES: 1) DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].

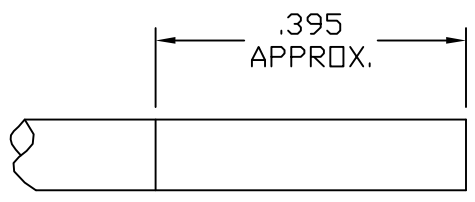
TFLEX 405 CABLE

USE SHRINK TUBING.



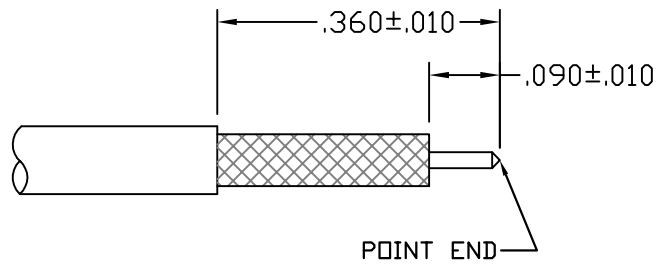
STEP 1

DIP END OF CABLE INTO FLUX EF-6100 AND THEN TIN DIP CABLE TO DIMENSION SHOWN USING KESTER 60/40 SOLDER @ 500° F FOR SIX SECONDS MAX.



STEP 2

TRIM CABLE TO DIMENSIONS SHOWN. POINT TIP OF INNER CONDUCTOR AS SHOWN.



*NOTE: ON 68-0022-0861 SLIDE STABILIZING RING ON FIRST.

STEP 3

SLIDE PREPARED CABLE INTO CONNECTOR BODY AND SOLDER, CLEAN SOLDER JOINT.

