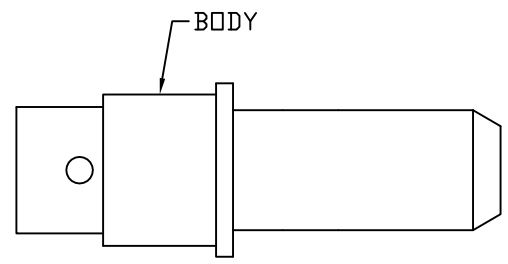
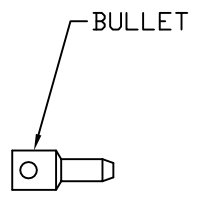


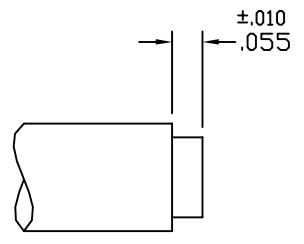
CABLE ASSEMBLY PROCEDURE	
P/N	78-0020-1412
PAGE 1 OF 1	DATE: 07/31/98
DRAWN: JEM	APPROVED: HN
FOR USE WITH HARBOUR LL142 CABLE	

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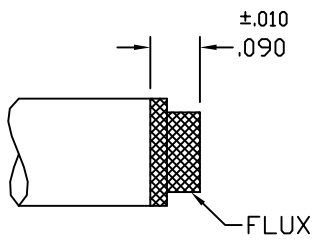
REV	DESCRIPTION	DATE	APPR
A	REL. ECN 4610	07/31/98	HN
B	PER ECN 10123	12/09/09	JEM
C	PER ECN 13492	9/13/19	JEM



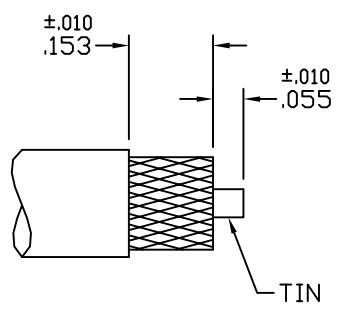
STEP 1
 TRIM OUTER JACKET AND
 BRAID TO DIMENSIONS SHOWN.



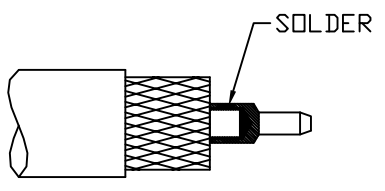
STEP 2
 FLUX AND TIN DIP STRIPPED
 END TO DIMENSION SHOWN.



STEP 3
 STRIP DIELECTRIC TO EXPOSE CENTER
 CONDUCTOR. STRIP JACKET TO EXPOSE
 BRAID. TIN CENTER CONDUCTOR.



STEP 4
 SOLDER BULLET ONTO CENTER
 CONDUCTOR OF CABLE THROUGH
 SIDE HOLE, CLEAN SOLDER JOINT.



INSERT CABLE INTO BACK OF BODY
 AND SOLDER BRAID TO CONNECTOR
 THROUGH SIDE HOLE AND CLEAN
 SOLDER JOINT.

