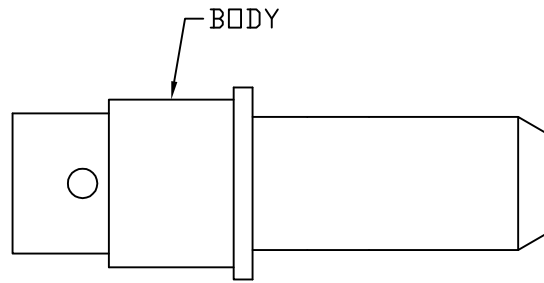


CABLE ASSEMBLY PROCEDURE	
P/N	78-0020-2202
PAGE 1 OF 1	DATE: 08/03/10
DRAWN: MS	APPROVED: JEM
FOR USE WITH TIMES SFT-142B CABLE	

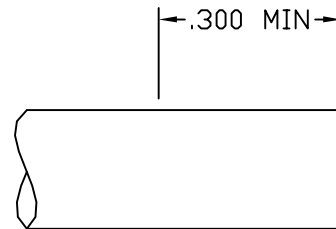
PALCO
CONNECTOR

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

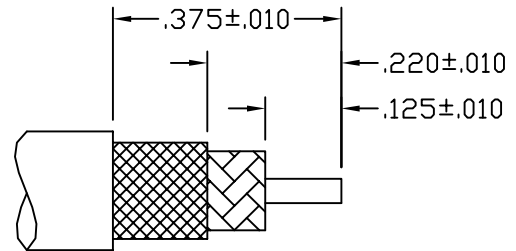
REV	DESCRIPTION	DATE	APPR
A	PER ECN 12353	08/27/16	JEM
B	PER ECN 12953	05/23/18	JEM
C	PER ECN 12979	06/06/18	JEM
D	PER ECN 13449	8/12/19	JEM



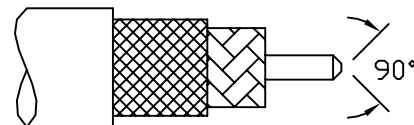
STEP 1
FLUX AND TIN DIP TO DIMENSION SHOWN.



STEP 2
TRIM CABLE TO DIMENSIONS SHOWN



STEP 3
CHAMFER CENTER CONDUCTOR



STEP 4
INSERT CABLE INTO BACK OF BODY
AND SOLDER BRAIDS TO CONNECTOR
THROUGH SIDE HOLE AND CLEAN
SOLDER JOINT.

