

CABLE ASSEMBLY PROCEDURE

P/N 78-0080-0670

PAGE 1 OF 1 DATE: 08/17/98

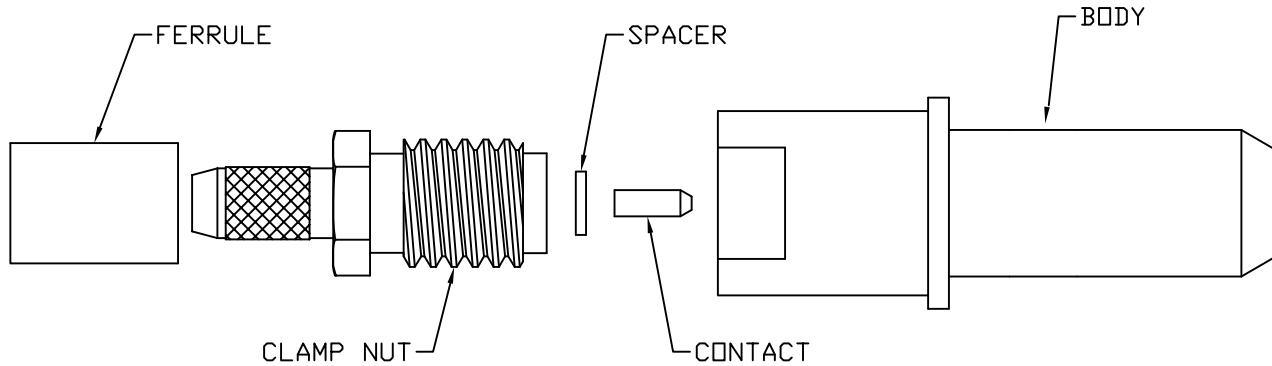
DRAWN: JEM APPROVED: HN

FOR USE WITH M17/113-RG316 CABLE

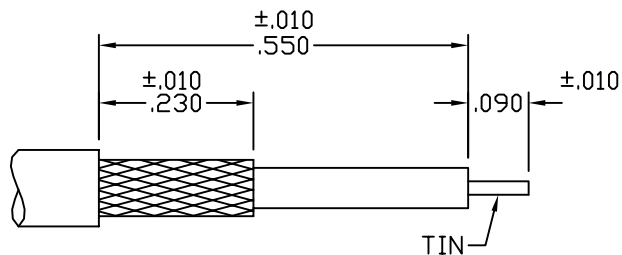
**PALEO**  
**CONNECTOR**

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

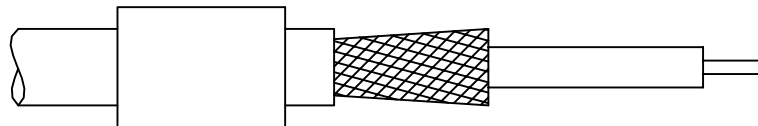
REV	DESCRIPTION	DATE	APPR
F	PER ECN 12955	05/23/18	JEM
G	PER ECN 13454	8/14/19	JEM



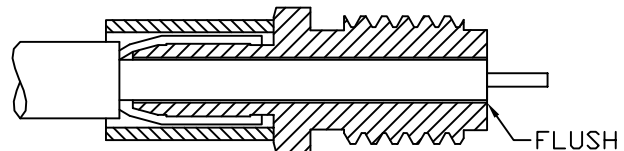
**STEP 1**  
TRIM CABLE TO DIMENSIONS SHOWN.  
TIN CENTER CONDUCTOR AND CLEAN  
SOLDER JOINT.



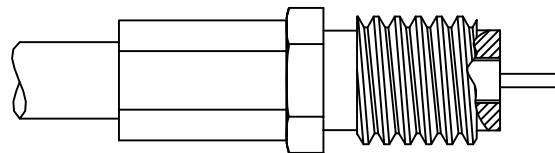
**STEP 2**  
SLIDE FERRULE OVER CABLE  
AND FLAIR BRAID BY ROTATING  
DIELECTRIC.



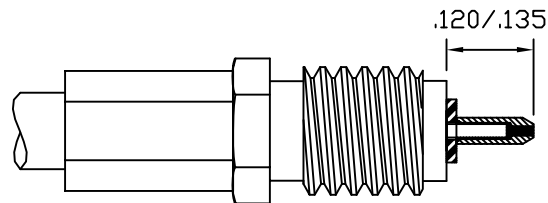
**STEP 3**  
INSERT THE BARREL OF THE CRIMP NUT BETWEEN  
THE BRAID AND DIELECTRIC, POSITIONED SO THAT  
THE END OF THE CABLE DIELECTRIC IS FLUSH  
WITH THE END OF THE CRIMP NUT.



**STEP 4**  
SLIDE THE FERRULE AGAINST THE SHOULDER  
OF THE CRIMP NUT AND CRIMP USING .128 HEX  
DIE (M22520/5-03).



**STEP 5**  
PLACE THE SPACER AGAINST THE CRIMP  
NUT. SLIDE THE BULLET OVER THE CENTER  
CONDUCTOR. USING RESISTANCE SOLDERING  
TWEETERS, APPLY HEAT TO THE BULLET  
TO REFLOW THE SOLDER, CLEAN SOLDER JOINT.



**STEP 6**  
THREAD CONNECTOR BODY ONTO  
THE CRIMP NUT ASSEMBLY,  
TIGHTEN TO 7-10 IN-LBS.

