

CABLE ASSEMBLY PROCEDURE

P/N 78-0080-2670

PAGE 1 OF 1 DATE: 05/16/02

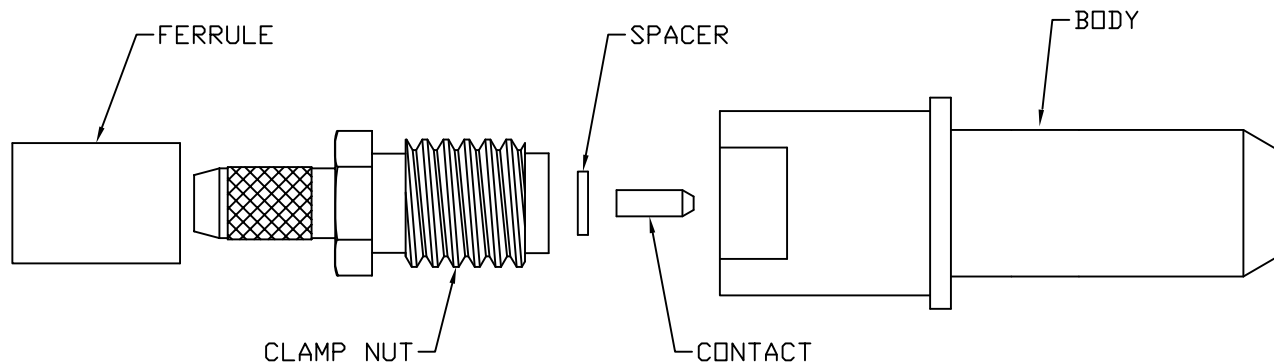
DRAWN: YT APPROVED: HN

FOR USE WITH RD-316 CABLE

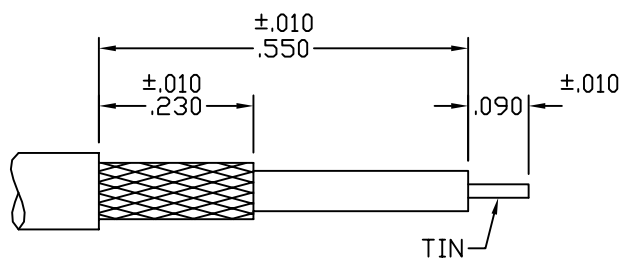
# PALEO CONNECTOR

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

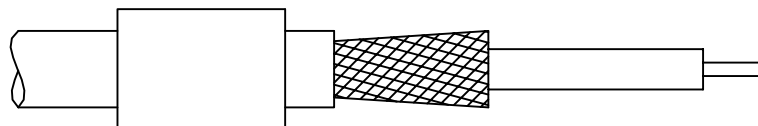
REV	DESCRIPTION	DATE	APPR
F	PER ECN 12955	05/23/18	JEM
G	PER ECN 13461	8/20/19	JEM



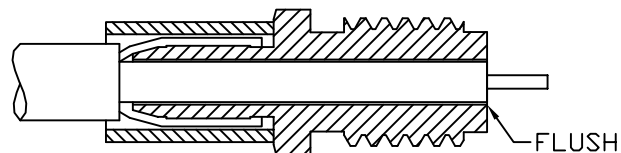
**STEP 1**  
 TRIM CABLE TO DIMENSIONS SHOWN.  
 TIN CENTER CONDUCTOR AND CLEAN  
 SOLDER JOINT.



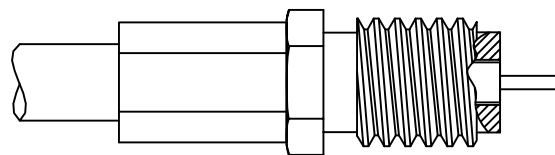
**STEP 2**  
 SLIDE FERRULE OVER CABLE  
 AND FLAIR BRAID BY ROTATING  
 DIELECTRIC.



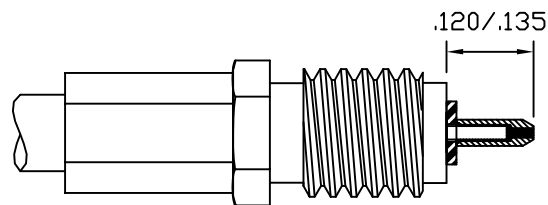
**STEP 3**  
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN  
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT  
 THE END OF THE CABLE DIELECTRIC IS FLUSH  
 WITH THE END OF THE CRIMP NUT.



**STEP 4**  
 SLIDE THE FERRULE AGAINST THE SHOULDER  
 OF THE CRIMP NUT AND CRIMP USING .151 HEX  
 DIE (M22520/5-37).



**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.

