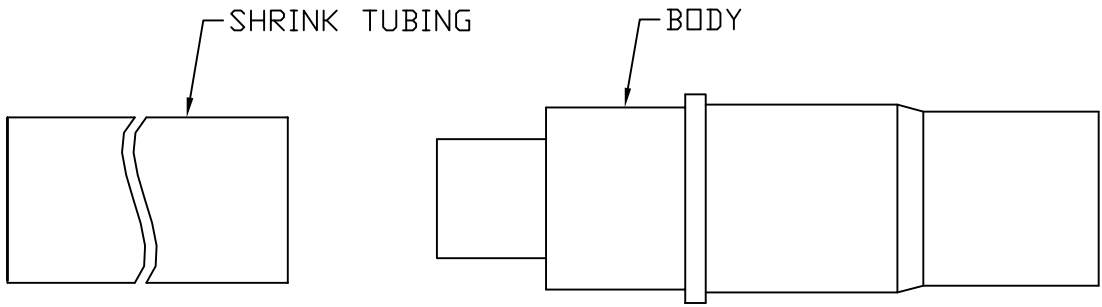


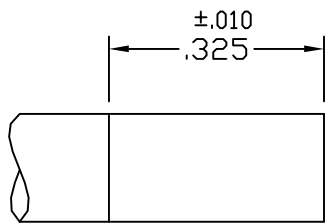
CABLE ASSEMBLY PROCEDURE	
P/N	78-1020-1413
PAGE 1 OF 1	DATE: 09/18/98
DRAWN: JEM	APPROVED: HN
FOR USE WITH HARBOUR SS402 CABLE	

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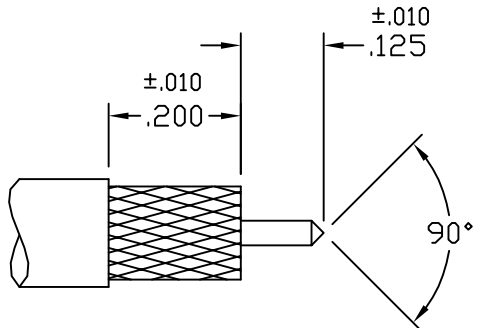
REV	DESCRIPTION	DATE	APPR
A	REL. ECN 4696	09/18/98	HN
B	PER ECN 5534	07/18/00	HN
C	PER ECN 9686	12/09/08	JEM
D	PER ECN 13522	10/4/19	JEM



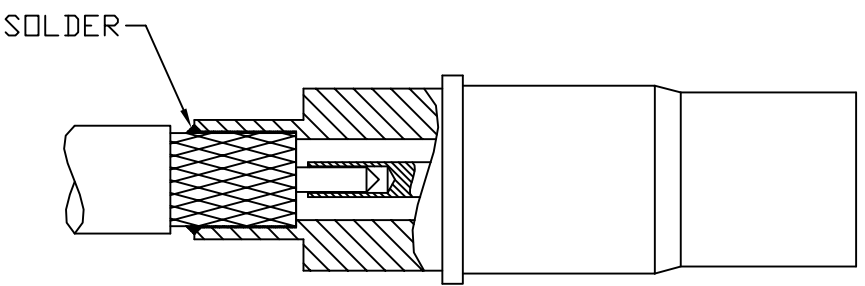
STEP 1
 FLUX END OF CABLE. STICK CABLE INTO
 SOLDER POT TO DIMENSION SHOWN, FOR
 3 SECONDS MAX.



STEP 2
 TRIM CABLE TO DIMENSIONS
 SHOWN. POINT CENTER CONDUCTOR.
 SLIDE SHRINK TUBING OVER CABLE.



STEP 3
 INSERT CABLE INTO BACK OF BODY
 AND SOLDER BRAID TO CONNECTOR
 AS SHOWN. CLEAN SOLDER JOINT.



STEP 4
 SLIDE SHRINK TUBING INTO
 POSITION OVER BODY AND
 SHRINK INTO PLACE.

