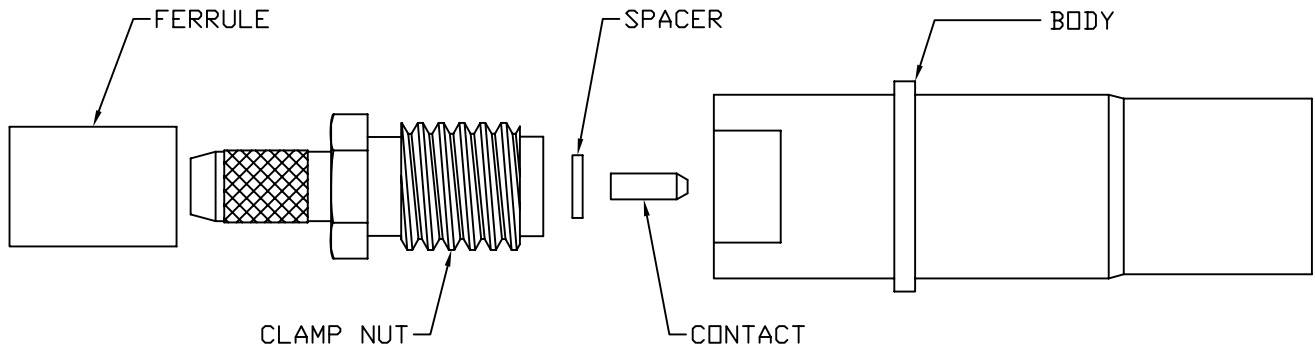


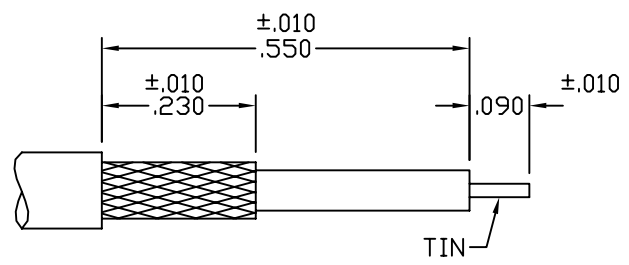
CABLE ASSEMBLY PROCEDURE	
P/N	78-1080-0670
PAGE 1 OF 1	DATE: 07/22/03
DRAWN: YT	APPROVED: HN
FOR USE WITH M17/113-RG316 CABLE	

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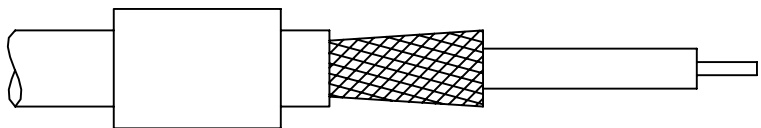
REV	DESCRIPTION	DATE	APPR
C	PER ECN 9681	12/08/08	JEM
D	PER ECN 10928	04/11/11	JEM
E	PER ECN 12958	05/24/18	JEM
F	PER ECN 13489	9/11/19	JEM



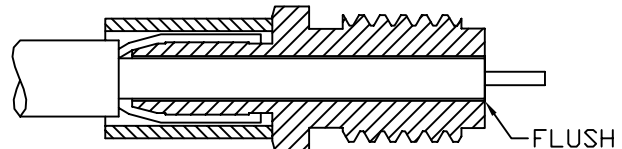
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN CENTER CONDUCTOR AND CLEAN
 SOLDER JOINT.



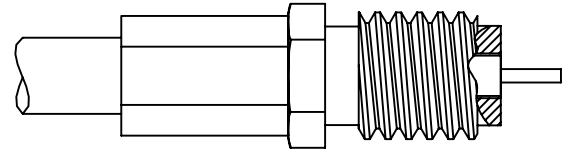
STEP 2
 SLIDE FERRULE OVER CABLE
 AND FLAIR BRAID BY ROTATING
 DIELECTRIC.



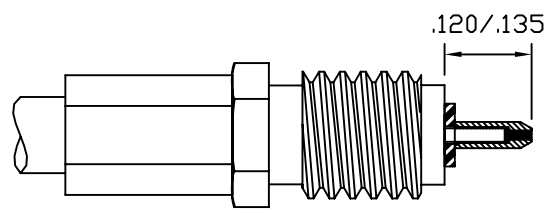
STEP 3
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT
 THE END OF THE CABLE DIELECTRIC IS FLUSH
 WITH THE END OF THE CRIMP NUT.



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.

