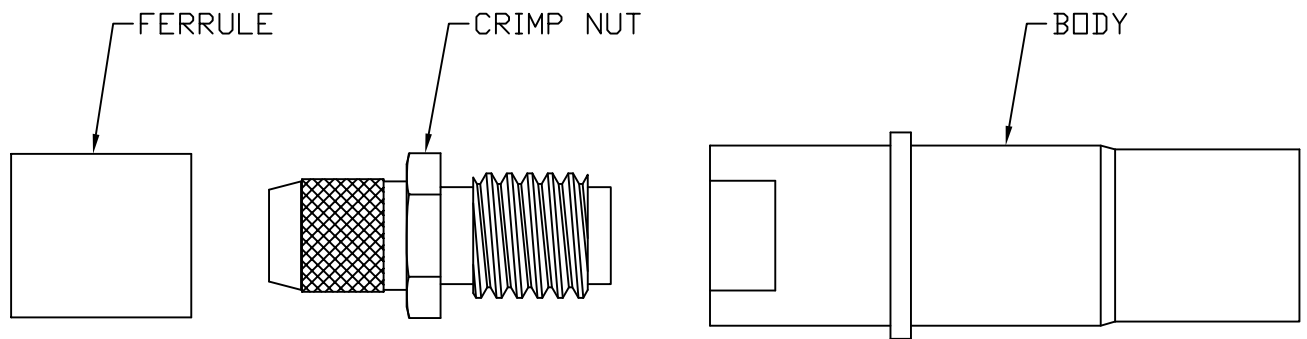


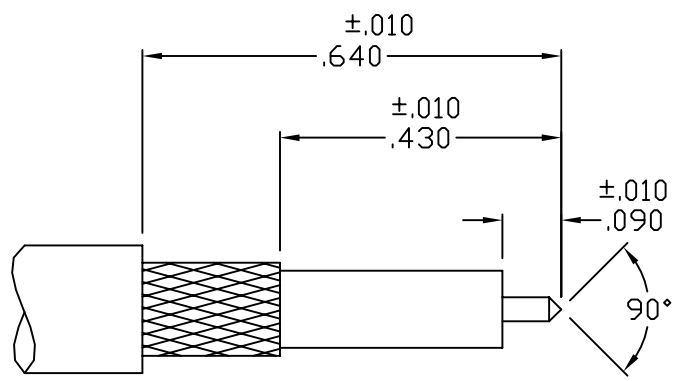
CABLE ASSEMBLY PROCEDURE	
P/N	78-1080-2201
PAGE 1 OF 1	DATE: 12/18/98
DRAWN: JEM	APPROVED: HN
FOR RG-142 D/S (M17/60) CABLE	

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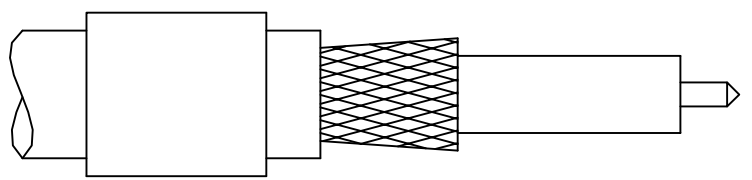
REV	DESCRIPTION	DATE	APPR
A	REL. ECN 4836	12/18/98	HN
B	PER ECN 9818	02/26/09	JEM
C	PER ECN 11420	08/23/12	JEM
D	PER ECN 13538	10/17/19	JEM



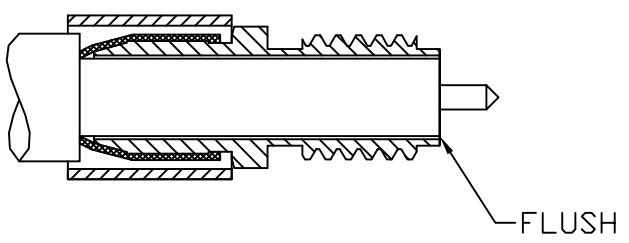
STEP 1
 STRIP CABLE TO DIMENSIONS SHOWN, POINT CENTER CONDUCTOR.



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



STEP 3
 SLIDE CRIMP NUT OVER CABLE DIELECTRIC AND UNDER BRAID, BE SURE CRIMP NUT IS FLUSH WITH CABLE DIELECTRIC. SLIDE FERRULE UP AGAINST SHOULDER OF CRIMP NUT AND CRIMP USING .213 HEX DIE (M22520/5-05).



STEP 4
 INSERT PREPARED CABLE ASSEMBLY INTO BACK OF BODY AND TORQUE CRIMP NUT TO 7-10 INCH-LBS.

