

CABLE ASSEMBLY PROCEDURE

P/N 785-0080-0670

PAGE 1 OF 1 DATE: 02/16/18

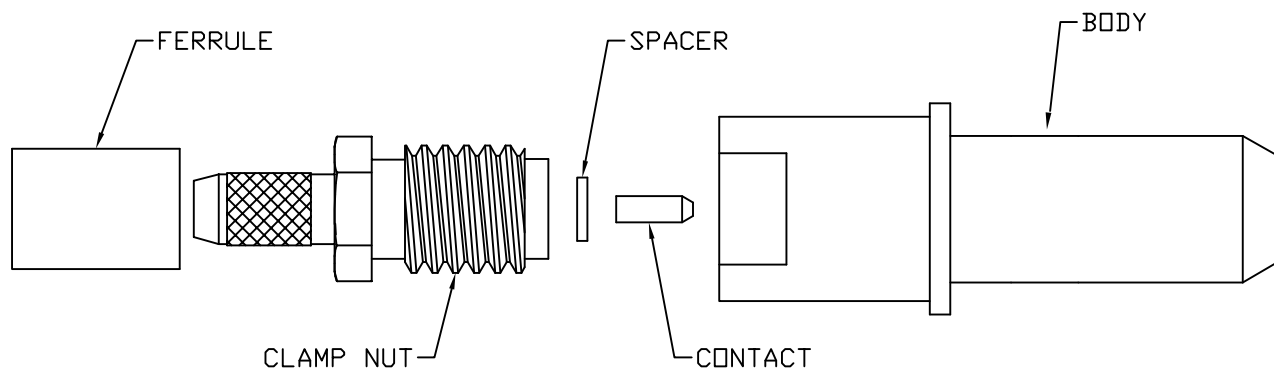
DRAWN: SPS APPROVED: JEM

FOR USE WITH M17/113-RG179 CABLE

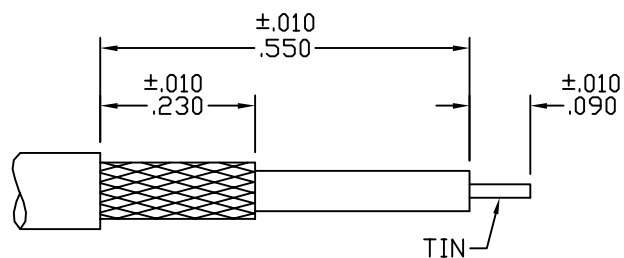
PALEO CONNECTOR

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

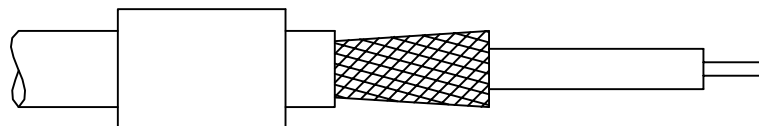
| REV | DESCRIPTION | DATE | APPR |
|-----|-------------------|----------|------|
| A | REL PER ECN 12788 | 02/16/18 | JEM |
| | | | |
| | | | |



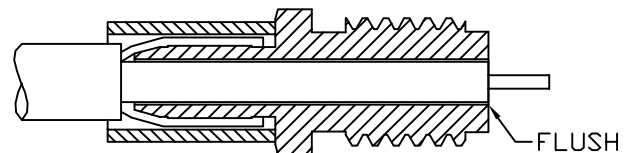
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN CENTER CONDUCTOR AND CLEAN
 SOLDER JOINT.



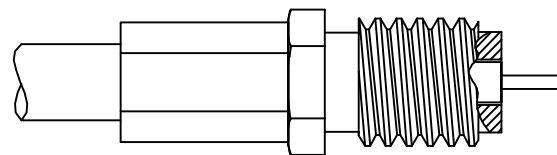
STEP 2
 SLIDE FERRULE OVER CABLE
 AND FLAIR BRAID BY ROTATING
 DIELECTRIC.



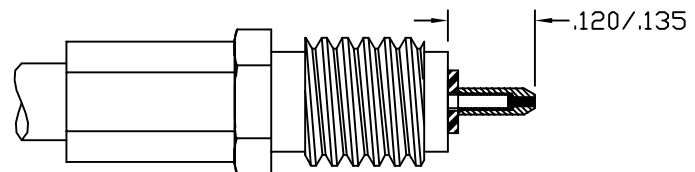
STEP 3
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT
 THE END OF THE CABLE DIELECTRIC IS FLUSH
 WITH THE END OF THE CRIMP NUT.



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.

