

CABLE ASSEMBLY PROCEDURE

P/N 785-1080-0670

PAGE 1 OF 1 DATE: 02/16/18

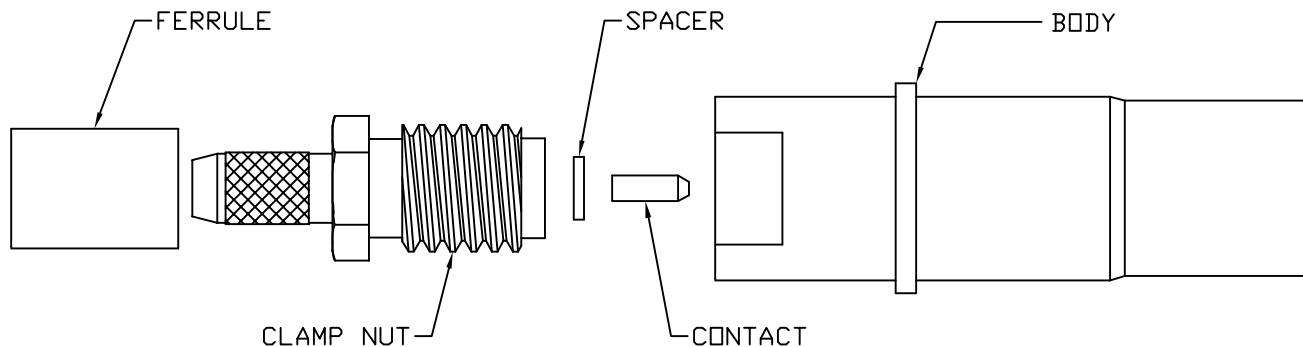
DRAWN: SPS APPROVED: JEM

FOR USE WITH M17/113-RG179 CABLE

# PALEO CONNECTOR

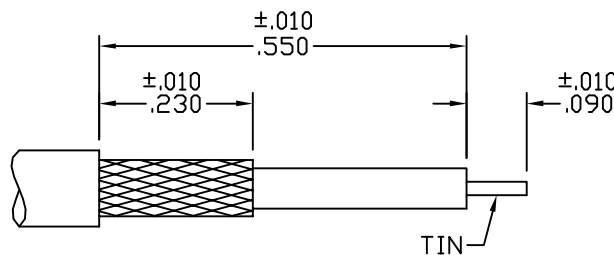
22 GREAT HILL ROAD, NAUGATUCK, CT. 06770  
 PHONE: (203) 729-9090 FAX: (203) 723-1794

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



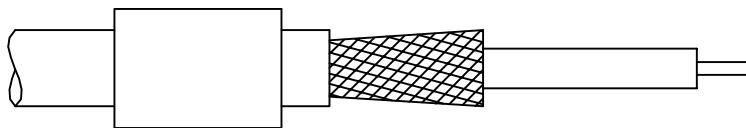
**STEP 1**

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



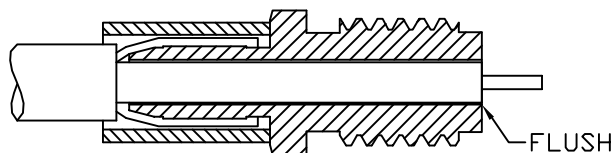
**STEP 2**

SLIDE FERRULE OVER CABLE AND FLAIR BRAID BY ROTATING DIELECTRIC.



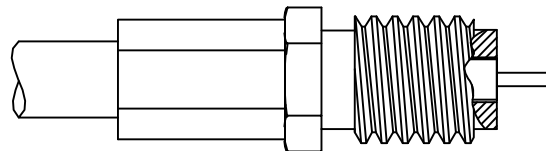
**STEP 3**

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.



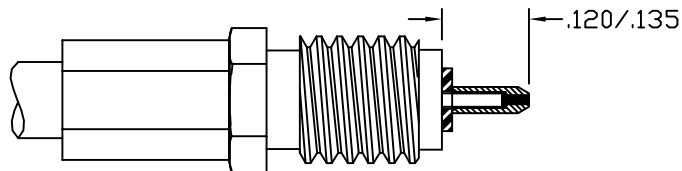
**STEP 4**

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.

