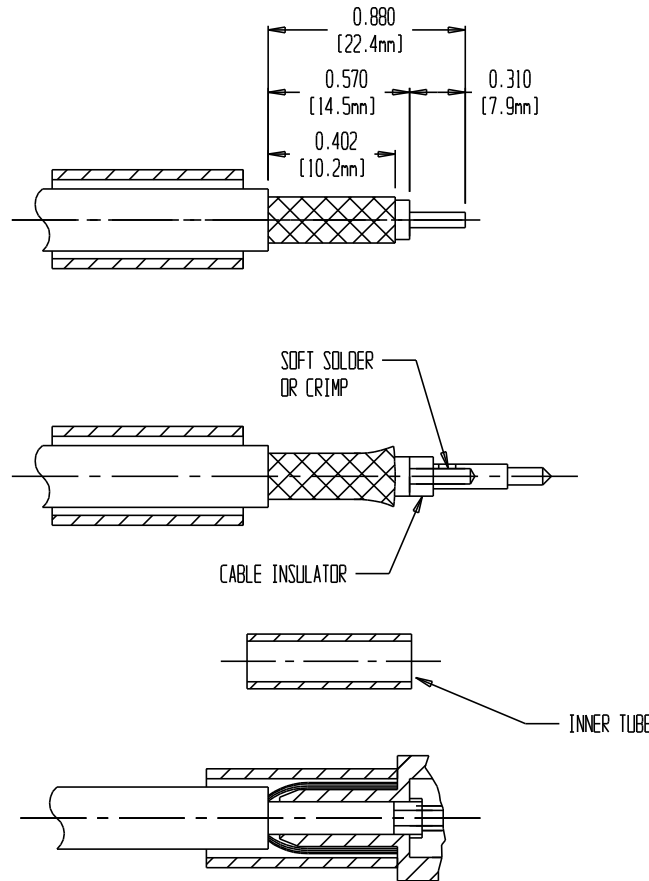


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REV	REVISION	DATE	ER #	INTL
B1	UPDATED INSTRUCTION, CHART	10/09/2006	5704	LRL

ES-105-25
CABLE ASSEMBLY INSTRUCTIONS



1.) STRIP CABLE PER DIMENSIONS. DO NOT KNICK THE BRAID OR CENTER CONDUCTOR. SLIDE SMALL END OF CRIMP TUBE ONTO CABLE FIRST AND PUSH BACK OUT OF WAY BEFORE REMOVING MATERIALS.

2.) DO NOT REMOVE THE ALUMINUM MYLAR FOIL SHIELD FROM THE DIELECTRIC.

3.) SLIDE BLACK ADHESIVE HEAT SHRINK AND ANY OTHER LABELS OVER THE CABLE AT THIS TIME.

4.) FLARE END OF CABLE BRAID BY ROTATING CABLE DIELECTRIC. SLIDE CABLE INSULATOR ONTO CENTER CONDUCTOR UP AGAINST DIELECTRIC. SOLDER CONTACT ONTO CENTER CONDUCTOR AS SHOWN. DO NOT OVERHEAT AND SWELL CABLE DIELECTRIC. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.

5.) SLIDE THE TAPERED END OF THE SUPPLIED INNER TUBE UNDER THE BRAID. IT MAY BE NECESSARY TO RE-FLARE THE END OF THE BRAID BEFORE INSTALLING THE CABLE ASSEMBLY ONTO THE CONNECTOR.

6.) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL CONTACT SNAPS INTO PORTION.

7.) SLIDE CRIMP TUBE OVER BRAID & UP AGAINST CONNECTOR BODY. CRIMP USING APPROPRIATE HEX SIZE CRIMPING TOOL.

CABLE TYPE	HEX SIZE	P/N	SOLDER TEMPERATURE
PFLX140-100	B	M22520/5-43	700-750 ° F (371-398 ° C)
TFLX130-100	B	M22520/5-43	700-750 ° F (371-398 ° C)

DATE	03/27/2001
DRAWN	A. SWENSON
DESIGNED	
CHECKED	10/09/2006
T. FORST	
APPROVED	10/09/2006



5349 S. EMMER DRIVE
NEW BERLIN, WI 53151
(888) 679-6170

CABLE STRIPPING INSTRUCTIONS

CAGE CODE	06WH3	DWG #	ES-105-25	SHT	1 OF 1
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FILE: ES-105-25.prt