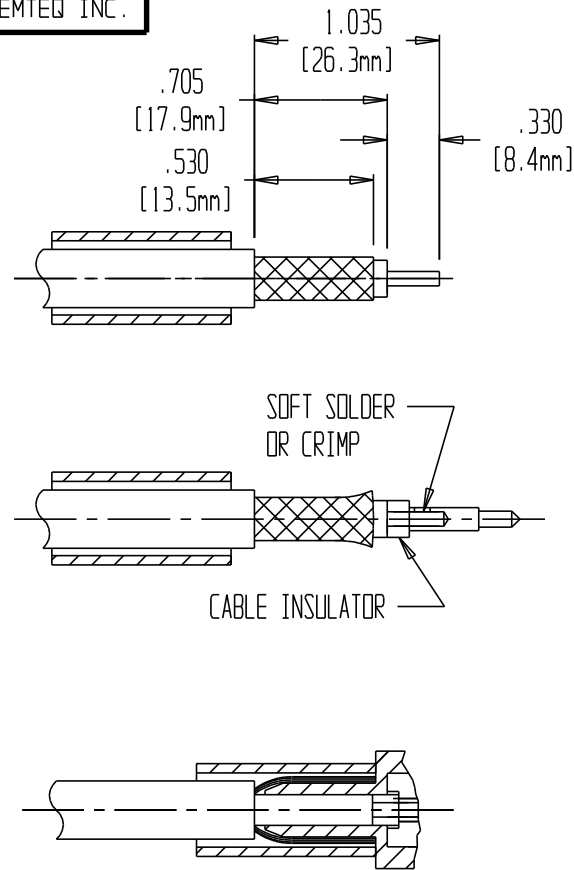


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REV	REVISION	DATE	ER #	INTL
C1	UPDATED INSTRUCTION, CHART	10/09/2006	5704	LRL



ES-105-28 CABLE ASSEMBLY INSTRUCTIONS

- 1.) STRIP CABLE PER DIMENSIONS. DO NOT NICK THE BRAID OR CENTER CONDUCTOR. SLIDE CRIMP TUBE ONTO CABLE AND PUSH BACK OUT OF WAY BEFORE REMOVING MATERIALS.
- 2.) DO NOT REMOVE THE ALUMINUM MYLAR FOIL SHIELD FROM THE DIELECTRIC.
- 3.) SLIDE BACK 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.) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF THE BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL CONTACT SNAPS INTO POSITION.
- 6.) SLIDE CRIMP TUBE OVER BRAID & UP AGAINST CONNECTOR BODY. CRIMP USING APPROPRIATE HEX SIZE CRIMPING TOOL. RECOMMEND USING APPROPRIATE HEX SIZE CRIMPING TOOL.

CABLE TYPE	DANIELS HEX DIE P/N	HEX SIDE	SOLDER TEMPERATURE
PFLX140-XXX	Y140	B	700-750 ° F (371-398 ° C)
TFLX488-100	Y373	.550	800-850 ° F (471-498 ° C)

DATE 03/18/2002	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170		
DRAWN L. LUGO			
DESIGNED	CABLE STRIPPING INSTRUCTIONS		
CHECKED T. FORST			
APPROVED 			
10/09/2006	CAGE CODE 06WH3	DWG # ES-105-28	SHT 1 OF 1

FILE: ES-105-28.dwt