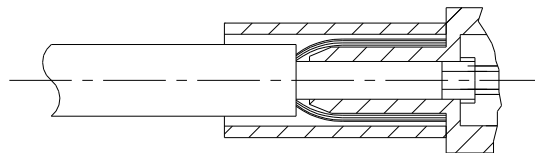
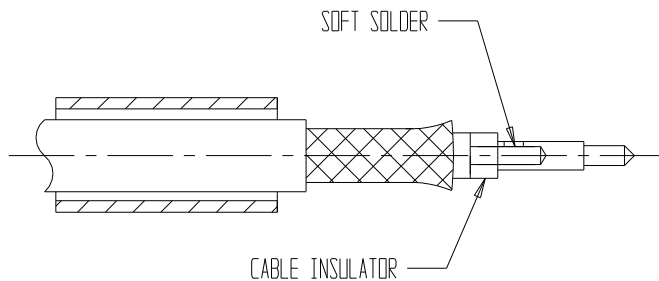
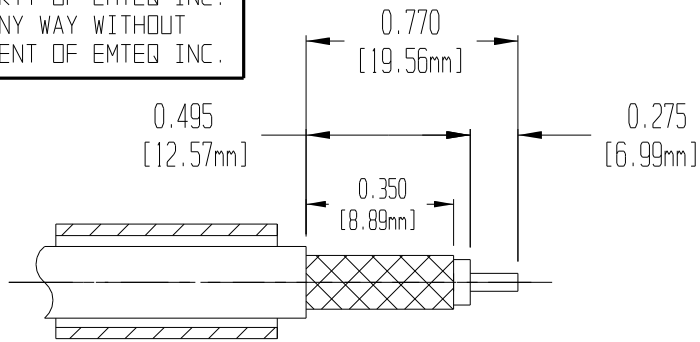


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REV	REVISION	DATE	ER #	INTL
IR	INITIAL RELEASE	5/25/2008	8461	LLP




ES-105-57
CABLE ASSEMBLY INSTRUCTIONS

- 1.) SLIDE ON ANY HEAT SHRINK LABELS IF USED, THEN THE BLACK ADHESIVE HEAT SHRINK AND THEN THE CRIMP TUBE.
- 2.) STRIP THE CABLE PER THE DIMENSIONS SHOWN. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR OR THE SHIELD BRAID. REMOVE THE MATERIALS. DO NOT REMOVE THE INNER FOIL SHIELD FROM THE DIELECTRIC.
- 3.) INSTALL THE CABLE INSULATOR ONTO THE CENTER CONDUCTOR BUTTING IT UP AGAINST THE CABLE DIELECTRIC.
- 4.) TIN THE CENTER CONDUCTOR. FLARE THE OUTER SHIELD BRAID BY GENTLY ROTATING THE CENTER CONDUCTOR AND DIELECTRIC, THEN FINISH TO FLARE OUT, NOT DISTURBING THE INNER FOIL SHIELD. DO NOT REMOVE THE INNER FOIL SHIELD FROM THE DIELECTRIC.
- 5.) INSERT THE CABLE INTO THE REAR OF THE CONNECTOR BODY, THE INNER FOIL SHIELD BEING INSIDE OF THE CONNECTOR BODY AND THE BRAID SHIELD OVER THE OUTSIDE, INSERTING THE CENTER CONDUCTOR INTO THE SLOT OF THE CONTACT, UNTIL THE CABLE INSULATOR BUTTS AGAINST THE CONTACT.
- 6.) SOLDER THE CENTER CONDUCTOR TO THE CONTACT. CAUTION: DO NOT OVERHEAT THE CONTACT AND SWELL THE DIELECTRIC AND/OR CABLE INSULATOR. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.
- 7.) SLIDE THE CRIMP TUBE UP OVER THE BRAID AND UP AGAINST THE CONNECTOR BODY. CRIMP USING M22520/5-01 (DANIELS HX4) CRIMPING TOOL WITH APPROPRIATE DIE. SEE CHART.

* NOTE: WHEN TERMINATING RG-142, RG400 OR PFLX200-XXX, USE THE GOLD CRIMP TUBE SUPPLIED. WHEN TERMINATING PFLX195-500, USE THE SILVER CRIMP TUBE SUPPLIED.

CABLE TYPE	MIL-SPEC HEX DIE P/N	DANIELS HEX DIE P/N	HEX SIDE	SOLDER TEMPERATURE
PFLX175-075	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
PFLX195	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX240	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
RG-142 B/U	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
RG-400	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
TFLX225	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
PFLX275-075	M22520/5-41	Y140	A	700-750 ° F (371-398 ° C)

DATE 5/28/2008	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	
DRAWN L. PACIGA		
DESIGNED	CABLE STRIPPING INSTRUCTIONS	
CHECKED T. FORST 5/29/2008		
APPROVED <i>[Signature]</i> 6/4/2008		
CAGE CODE 06WH3	DWG # ES-105-57	SHT 1 OF 1

FILE: ES-105-57.pr