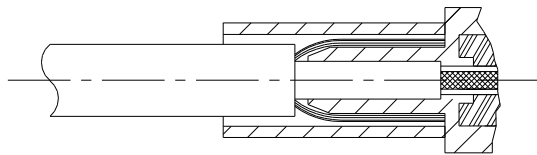
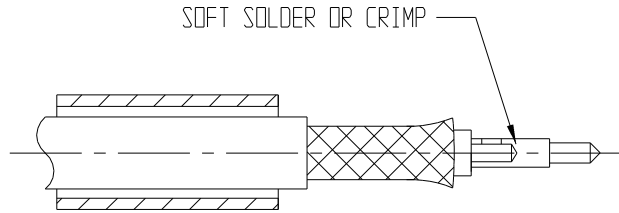
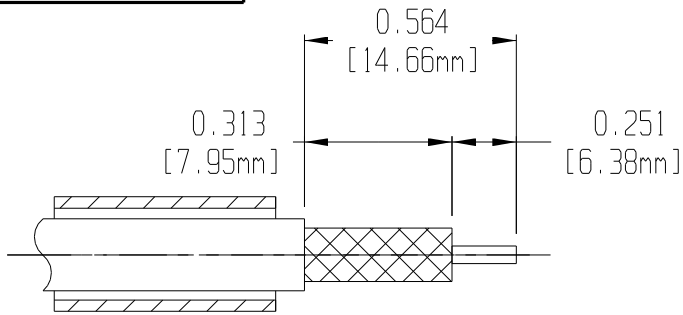


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REV	REVISION	DATE	ER #	INTL
A00	RELEASED FOR PRODUCTION	12/14/2011	0680-11	VML
A01	ADD TFLX180-075-01 TO CHART;UPD PICTOR	06/09/2014	0826-14	ASL



### ES-105-74 CABLE ASSEMBLY INSTRUCTIONS

- 1.) STRIP CABLE PER DIMENSIONS. DO NOT KNICK 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. SOLDER CONTACT ONTO CENTER CONDUCTOR AS SHOWN. DO NOT OVERHEAT AND SWELL CABLE DIELECTRIC. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES. CONTACT CAN ALSO BE CRIMPED USING 0.041 OR 0.042 SQUARE DIE.
- 5.) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF 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.

CABLE TYPE	MIL-SPEC HEX DIE P/N	DANIELS HEX DIE P/N	HEX SIDE	SOLDER TEMPERATURE
PFLX175-075-01	M22520/5-41	Y140	A	700-750 ° F (371-398 ° C)
PFLX190-075-01	M22520/5-19(B)	Y142	B	700-750 ° F (371-398 ° C)
TFLX125-075-01	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
TFLX180-075-01	M22520/5-19(B)	Y142	B	700-750 ° F (371-398 ° C)

DATE 12/14/2011	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	CABLE ASSEMBLY INSTRUCTIONS	SHT 1 OF 1	
DRAWN V. LEX				
DESIGNED				
CHECKED V. LEX 06/09/2014				
APPROVED K. BACHLEDA 06/09/2014	CAGE CODE 06WH3			DWG # ES-105-74
FILE: ES-105-74.prt				