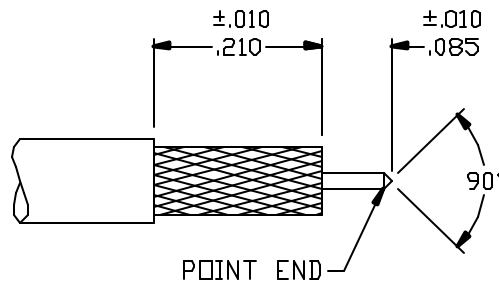
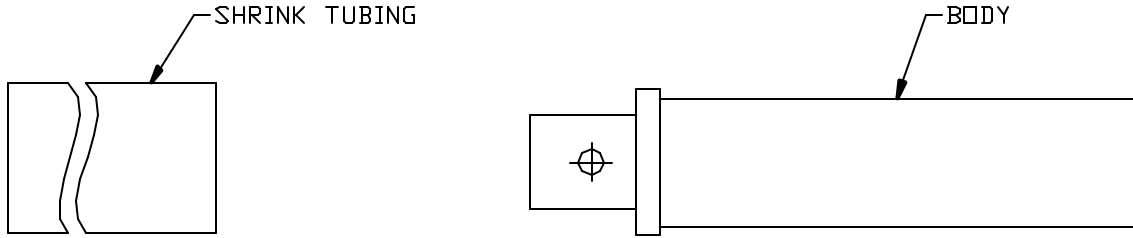
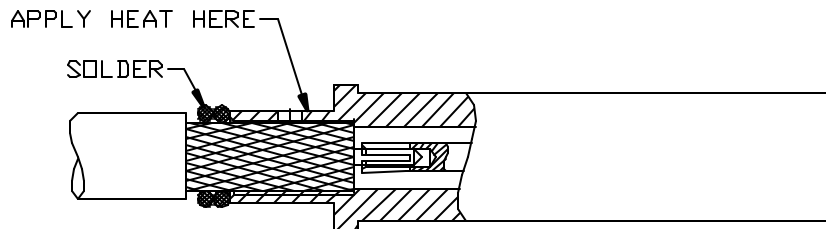


| | | | | | | |
|------------------------------|----------------|---|-----|---------------|----------|------|
| CABLE ASSEMBLY PROCEDURE | | <p style="text-align: center;">PALEO</p> <p style="text-align: center;">CONNECTOR</p> <p>22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794</p> | REV | DESCRIPTION | DATE | APPR |
| P/N | 56-1021-0861 | | A | REL. ECN 3934 | 06/16/97 | HN |
| PAGE 1 OF 1 | DATE: 06/16/97 | | B | PER ECN 8102 | 07/21/05 | JEM |
| DRAWN: JEM | APPROVED: HN | | C | PER ECN 9455 | 07/30/08 | JEM |
| FOR USE WITH T-FLEX405 CABLE | | | | | | |



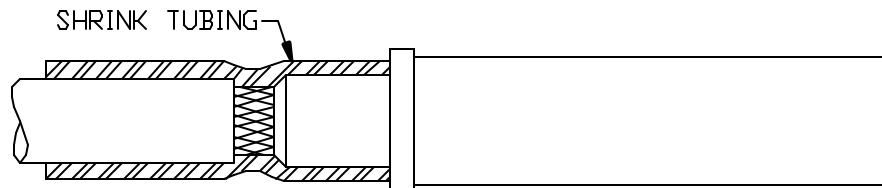
STEP 1

DIP END OF CABLE INTO FLUX AND THEN INTO A SOLDER POT (KESTER 60/40) MAINTAINED AT 500°F TO A DEPTH OF .295 FOR SIX SECOND MAX. SLIDE SHRINK TUBING OVER CABLE. TRIM CABLE TO DIMENSIONS SHOWN, POINT CENTER CONDUCTOR.



STEP 2

SLIDE THE CABLE INTO THE CONNECTOR BACKSHELL AND WRAP TWO TURNS OF .020 SOLDER AROUND THE CABLE AT THE BACKSHELL, APPLY HEAT TO THE CONNECTOR BACKSHELL UNTIL THE SOLDER MELTS.



STEP 3

SLIDE SHRINK TUBING INTO POSITION AND APPLY HEAT TO SHRINK TUBING.