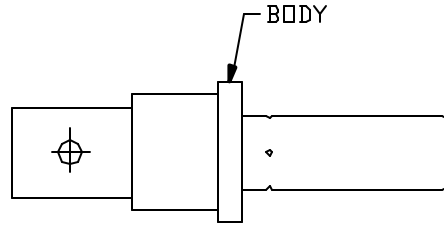
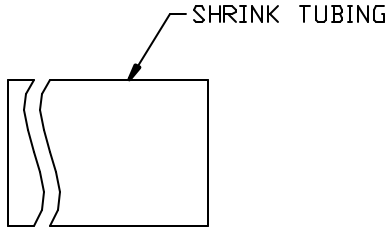


|                              |                |
|------------------------------|----------------|
| CABLE ASSEMBLY PROCEDURE     |                |
| P/N                          | 56-0021-0861   |
| PAGE 1 OF 1                  | DATE: 06/16/97 |
| DRAWN: JEM                   | APPROVED: HN   |
| FOR USE WITH T-FLEX405 CABLE |                |

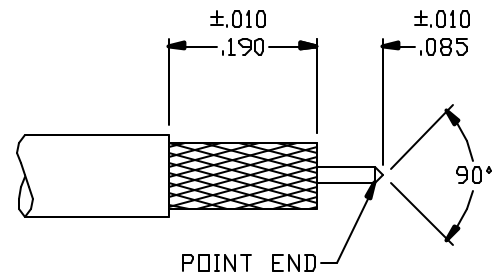
**PALEO**  
**CONNECTOR**

22 GREAT HILL ROAD, NAUGATUCK, CT. 06770  
PHONE: (203) 729-9090 FAX: (203) 723-1794

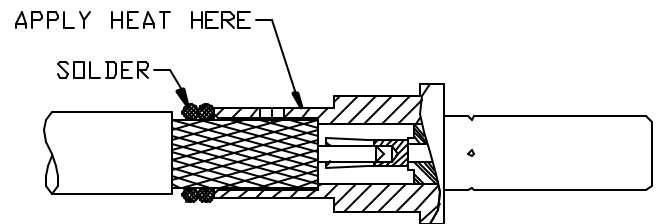
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|-----|---------------|----------|------|
| A   | REL. ECN 3933 | 06/16/97 | HN   |
| D   | PER ECN 8101  | 07/21/05 | JEM  |
|     |               |          |      |
|     |               |          |      |



**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 .215 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.

