

CABLE ASSEMBLY PROCEDURE

P/N 20-1965-0298

PAGE 1 OF 1 DATE: 11/15/12

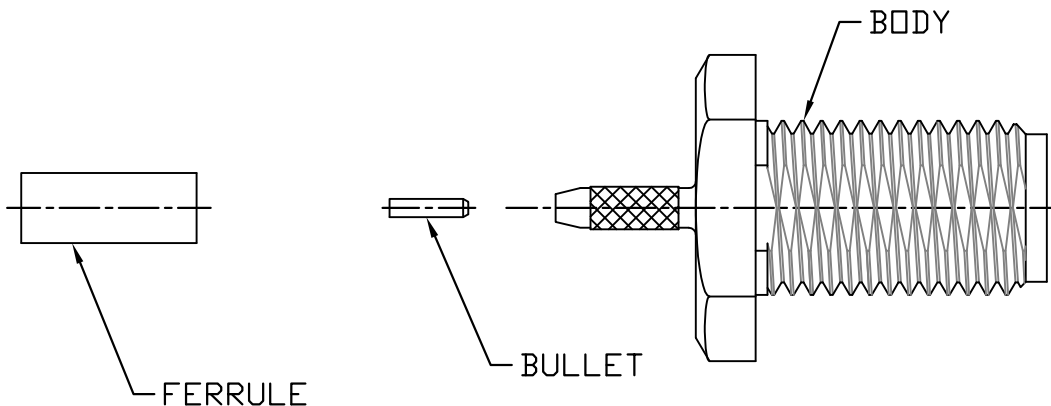
DRAWN: JEM APPROVED: JEM

FOR USE WITH HIROSE 1.13mm CABLE

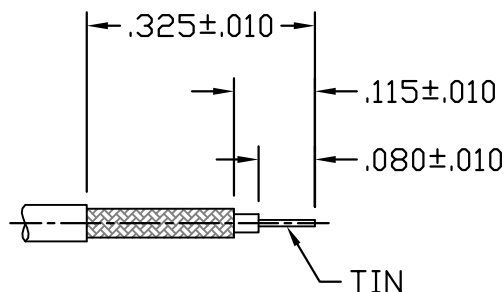
PALEO CONNECTOR

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

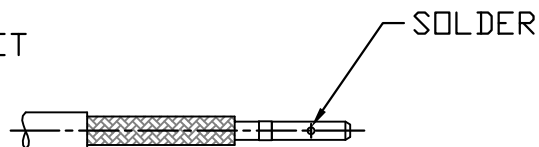
REV	DESCRIPTION	DATE	APPR
01	PRELIMINARY	11/15/12	JEM
A	PER ECN 11575	02/07/13	JEM
B	PER ECN 11895	05/23/14	JEM



STEP 1
 TRIM CABLE TO DIMENSIONS
 SHOWN.. TIN CENTER CONDUCTOR.
 CLEAN.



STEP 2
 SLIDE BULLET ONTO
 CENTER CONDUCTOR. SOLDER BULLET
 TO CENTER CONDUCTOR. CLEAN
 SOLDER JOINT.



STEP 3
 SLIDE FERRULE ONTO CABLE.
 FLARE BRAID BY ROTATING
 CABLE DIELECTRIC.



STEP 4
 INSERT CABLE INTO BODY
 UNTIL CABLE BOTTOMS.
 SLIDE FERRULE UP UNTIL
 IT BOTTOM ON SHOULDER.
 CRIMP USING .081 HEX
 DIE (DANIELS Y1547P).

