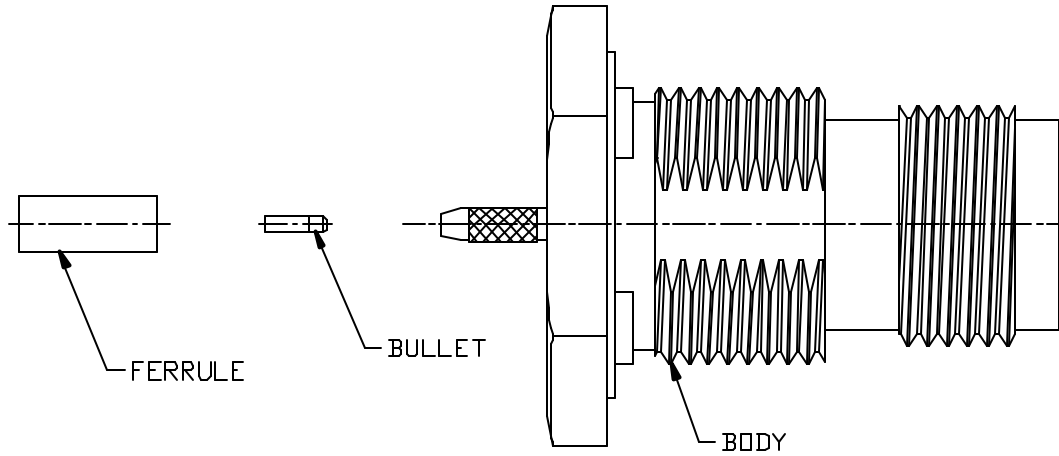
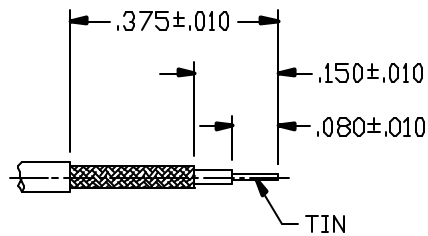


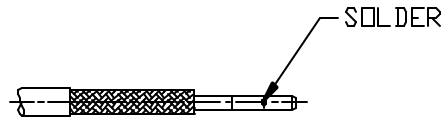
CABLE ASSEMBLY PROCEDURE			REV	DESCRIPTION	DATE	APPR
P/N	42-1915-0390		01	PRELIMINARY	12/4/12	JEM
PAGE 1 OF 1	DATE: 12/4/12		A	PER ECN 11594	02/20/13	JEM
DRAWN: JEM	APPROVED: JEM					
FOR USE WITH HIROSE 1.32mm CABLE		22 GREAT HILL ROAD, NAUGATUCK, CT. 06770		PHONE: (203) 729-9090		FAX: (203) 723-1794



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 BOTTOMS ON SHOULDER. CRIMP USING .081 HEX DIE (DANIELS Y1547P).

