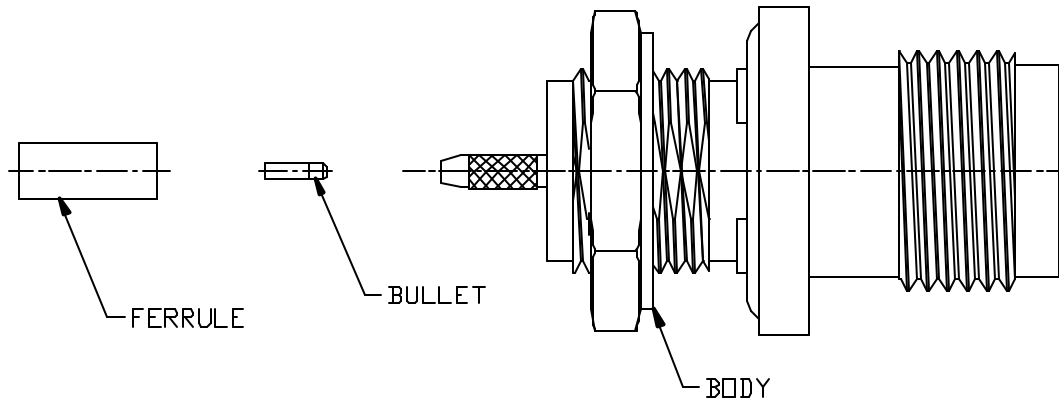
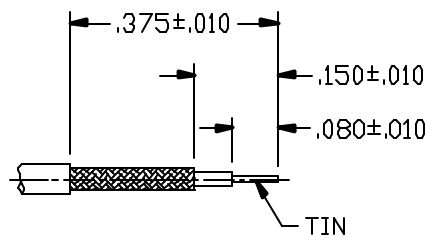


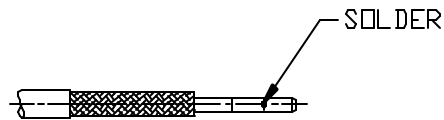
CABLE ASSEMBLY PROCEDURE		PALEO CONNECTOR 22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794	REV	DESCRIPTION	DATE	APPR
P/N	42-1969-0290		01	PRELIMINARY	12/5/12	JEM
PAGE 1 OF 1	DATE: 12/5/12		A	PER ECN 11595	02/20/13	JEM
DRAWN: JEM	APPROVED: JEM					
FOR USE WITH HIROSE 1.13mm CABLE						



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).

