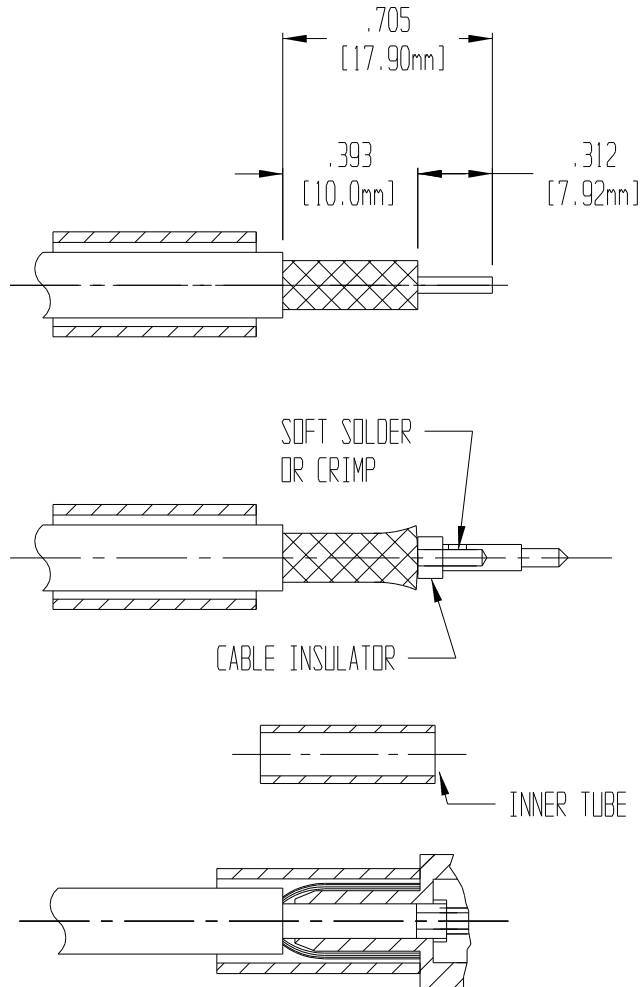


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REV	REVISION	DATE	ER #	INTL
D	ADDED NOTE TO INSTRUCTIONS	2/1/2007	6454	CCE
E	CORRECT DIMENSIONS	01/05/2010	10438	LLP



ES-105-26 CABLE ASSEMBLY INSTRUCTIONS

- 1.) STRIP CABLE PER DIMENSIONS. DO NOT KNICK THE BRAID OR CENTER CONDUCTOR. SLIDE SMALL END OF CRIMP TUBE ONTO CABLE FIRST AND PUSH BACK OUT OF WAY BEFORE REMOVING MATERIALS.
 - 2.) DO NOT REMOVE THE ALUMINUM MYLAR FOIL SHIELD FROM THE DIELECTRIC.
 - 3.) SLIDE BLACK ADHESIVE HEAT SHRINK AND ANY OTHER LABELS OVER THE CABLE AT THIS TIME.
 - 4.) FLARE END OF CABLE BRAID BY ROTATING CABLE DIELECTRIC. SLIDE CABLE INSULATOR ONTO CENTER CONDUCTOR UP AGAINST DIELECTRIC. SOLDER CONTACT ONTO CENTER CONDUCTOR AS SHOWN. DO NOT OVERHEAT AND SWELL CABLE DIELECTRIC. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.
 - 5.) IT MAY BE NECESSARY TO RE-FLARE THE END OF THE BRAID BEFORE INSTALLING THE CABLE ASSEMBLY ONTO THE CONNECTOR.
 - 6.) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL CONTACT SNAPS INTO PORTION.
 - 7.) SLIDE CRIMP TUBE OVER BRAID & UP AGAINST CONNECTOR BODY. CRIMP USING APPROPRIATE HEX SIZE CRIMPING TOOL. RECOMMEND USING HEX SIZE CRIMPING TOOL.
- *NOTE: WHEN TERMINATING PFLX140-500, USE GOLD CRIMP TUBE SUPPLIED. WHEN TERMINATING PFLX195-500, USE THE SILVER CRIMP TUBE SUPPLIED.

CABLE TYPE	HEX SIZE	P/N	SOLDER TEMPERATURE
PFLX140-100	B	M22520/5-43	700-750 ° F (371-398 ° C)
TFLX130-100	B	M22520/5-43	700-750 ° F (371-398 ° C)

DATE 03/18/2002	EMTEQ 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	CABLE STRIPPING INSTRUCTIONS	SHT 1 OF 1
DRAWN L. LUGO			
DESIGNED			
CHECKED <i>T. Forst</i> 1/13/2010			
APPROVED T. FORST 1/18/2010	CAGE CODE 06WH3	DWG # ES-105-26	

FILE: ES-105-26.prt