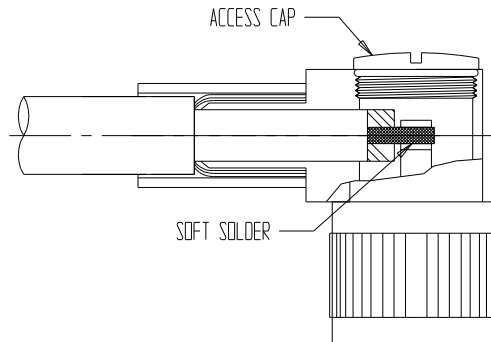
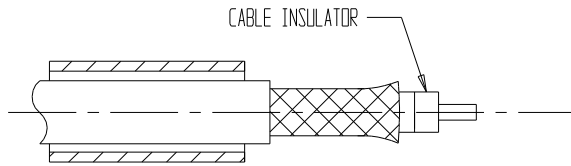
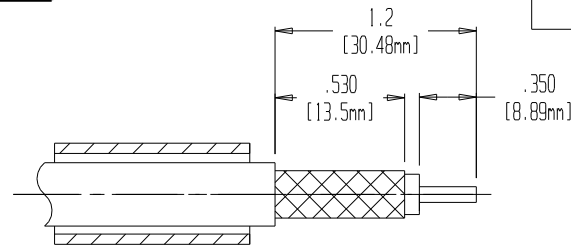


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REV	REVISION	DATE	ER #	INTL
C	ADDED TFLX410-XXX	7/8/2008	8631	LLP
000	CORRECT MIL-SPEC & HEX DIE INFO FOR TFLX410 & 480	1/29/2010	10512	LLP



### ES-105-30 CABLE ASSEMBLY INSTRUCTIONS

- 1.) SLIDE ON ANY HEAT SHRINK LABELS IF USED, THEN THE BLACK ADHESIVE HEAT SHRINK AND THEN THE CRIMP TUBE.
  - 2.) STRIP THE CABLE PER THE DIMENSIONS SHOWN. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR OR THE SHIELD BRAID. REMOVE THE MATERIALS. DO NOT REMOVE THE INNER FOIL SHIELD FROM THE DIELECTRIC.
  - 3.) INSTALL THE CABLE INSULATOR ONTO THE CENTER CONDUCTOR BUTTING IT UP AGAINST THE CABLE DIELECTRIC.
  - 4.) TIN THE CENTER CONDUCTOR. FLARE THE OUTER SHIELD BRAID BY GENTLY ROTATING THE CENTER CONDUCTOR AND DIELECTRIC, THEN FINISH TO FLARE OUT, NOT DISTURBING THE INNER FOIL SHIELD. DO NOT REMOVE THE INNER FOIL SHIELD FROM THE DIELECTRIC.
  - 5.) INSERT THE CABLE INTO THE REAR OF THE CONNECTOR BODY, THE INNER FOIL SHIELD BEING INSIDE OF THE CONNECTOR BODY AND THE BRAID SHIELD OVER THE OUTSIDE, INSERTING THE CENTER CONDUCTOR INTO THE SLOT OF THE CONTACT, UNTIL THE CABLE INSULATOR BUTTS AGAINST THE CONTACT.
  - 6.) SOLDER THE CENTER CONDUCTOR TO THE CONTACT. CAUTION: DO NOT OVERHEAT THE CONTACT AND SWELL THE DIELECTRIC AND/OR CABLE INSULATOR. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.
  - 7.) SLIDE THE CRIMP TUBE UP OVER THE BRAID AND UP AGAINST THE CONNECTOR BODY. CRIMP USING M22520/5-01 (DANIELS HX4) CRIMPING TOOL WITH APPROPRIATE DIE. SEE CHART.
- \* NOTE: WHEN TERMINATING RG-142, RG400 OR PFLX200-XXX, USE THE GOLD CRIMP TUBE SUPPLIED. WHEN TERMINATING PFLX195-500, USE THE SILVER CRIMP TUBE SUPPLIED.
- 8.) ADD "O" RING TO ACCESS CAP, THEN THREAD ON CAP AND TIGHTEN. INSTALL AND HEAT SHRINK THE BLACK ADHESIVE HEAT SHRINK ONTO CONNECTOR, COMPLETELY COVERING THE CRIMP TUBE AND REAR PART OF THE CONNECTOR BODY IF POSSIBLE.

CABLE TYPE	MIL-SPEC HEX DIE P/N	DANIELS HEX DIE P/N	HEX SIDE	SOLDER TEMPERATURE
PFLX175-075-XX	M22520/5-43	Y141	B	700-750 ° F (371-398 ° C)
RG-142 B/U	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX140-XXX	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
PFLX195-XXX	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX200-XXX	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX240-XXX	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
PFLX340-XXX	M22520/5-35	Y137	A	750-800 ° F (398-427 ° C)
PFLX400-XXX	M22520/5-61	Y178	A	800-850 ° F (427-454 ° C)
PFLX500-XXX	M22520/5-21	Y149	A	800-850 ° F (427-454 ° C)
TFLX125-075-XX	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
TFLX130-XXX	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
TFLX165-XXX	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
TFLX205-XXX	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
TFLX225-XXX	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
TFLX295-XXX	M22520/5-35	Y137	A	750-800 ° F (398-427 ° C)
TFLX410-XXX	M22520/5-53	Y148	A	800-850 ° F (427-454 ° C)
TFLX480-XXX	N/A	Y373	A	800-850 ° F (427-454 ° C)

DATE 03/27/2001	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	
DRAWN A. SWENSON		
DESIGNED	CABLE STRIPPING INSTRUCTIONS	
CHECKED <i>[Signature]</i> 1/29/2010		
APPROVED T. FORST 2/1/2010		
CAGE CODE 06WH3	DWG # ES-105-30	
		SHT 1 OF 1

FILE: ES-105-30 prt