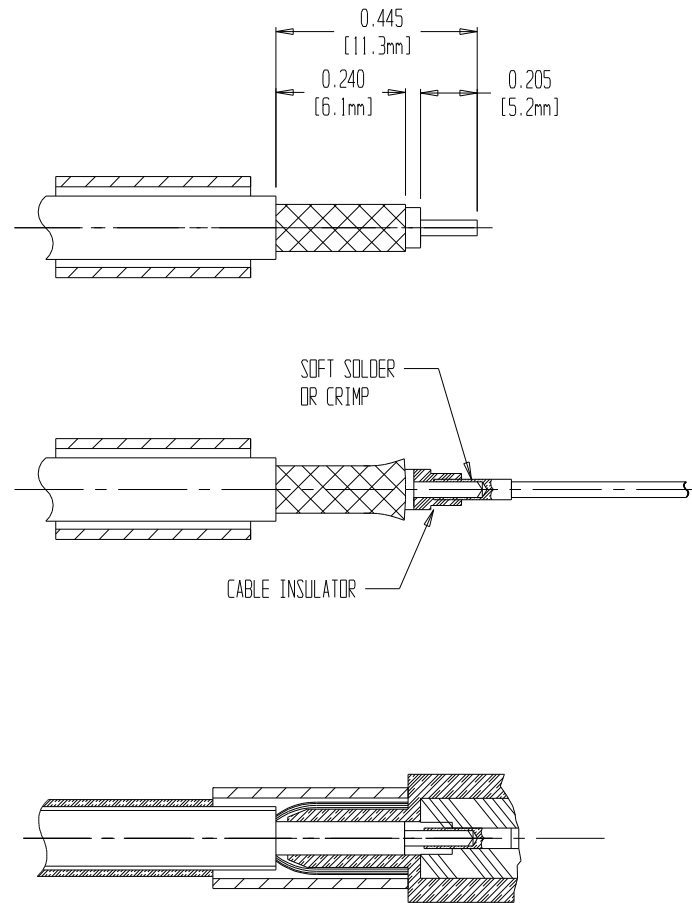


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REV	REVISION	DATE	ER #	INTL
B1	UPDATED INSTRUCTION, CHART	10/09/2006	5704	LRL
C	ADDED NOTE AND DANIELS HEX DIE P/N	3/10/2008	8188	LLP



ES-105-33 CABLE ASSEMBLY INSTRUCTIONS

1.) STRIP CABLE PER DIMENSIONS. DO NOT KNICK THE BRAID OR CENTER CONDUCTOR. SLIDE CRIMP TUBE ONTO CABLE 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. SOLDER CONTACT/INSULATOR ONTO CENTER CONDUCTOR AS SHOWN. DO NOT OVERHEAT AND SWELL CABLE DIELECTRIC. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.

5.) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL INSULATOR STOPS IN POSITION.

6.) SLIDE CRIMP TUBE OVER BRAID & UP AGAINST CONNECTOR BODY. CRIMP USING APPROPRIATE HEX SIZE CRIMPING TOOL.

* NOTE: WHEN TERMINATING RG-142, RG400, FLX140-500, OR PFLX200-XXX, USE THE GOLD CRIMP TUBE SUPPLIED. WHEN TERMINATING PFLX195-500, OR TFLX130-100, USE THE SILVER CRIMP TUBE SUPPLIED.

CABLE TYPE	HEX SIZE	DANIELS HEX DIE P/N	MIL-SPEC HEX DIE P/N	SOLDER TEMPERATURE
PFLX140-XXX	B	Y140	M22520/5-41	700-750 ° F (371-398 ° C)
PFLX175-075-XX	B	Y140	M22520/5-41	700-750 ° F (371-398 ° C)
TFLX125-075-XX	B	Y140	M22520/5-41	700-750 ° F (371-398 ° C)

DATE	03/28/2001
DRAWN	A. SWENSON
DESIGNED	
CHECKED	3/10/2008
T. FORST	
APPROVED	3/10/2008
K. STUCKART	



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CABLE STRIPPING INSTRUCTIONS	
CAGE CODE	DWG #
06WH3	ES-105-33
SHT	1 OF 1

FILE: ES-105-33.prt