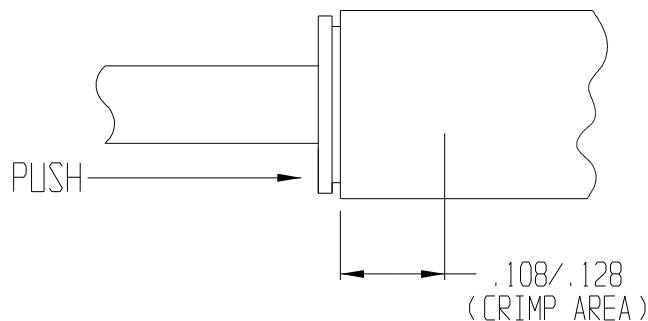
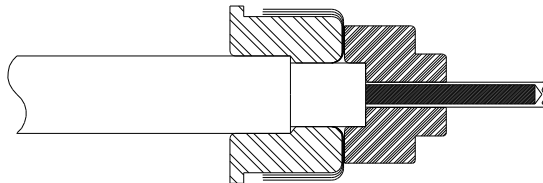
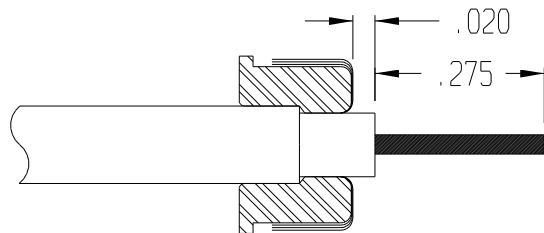


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REV	REVISION	DATE	ER #	INTL
B	CHANGED STRIPPING INSTRUCTIONS	04/21/2005	4529	VML
C	ADDED NOTE 5	04/13/2009	9590	VML
(C)	ADD PFLX190-075-01 TO NOTE 5	05/17/2010	10839	ASL
(D)	UPDATE NOTE 5 TO REFLECT (2) DIFFERENT DIES	05/29/2014	0758-14	ASL

ES-105-36 CABLE ASSEMBLY INSTRUCTIONS

- 1.) SLIDE ANY SHRINK TUBING OR LABELS OVER THE CABLE. STRIP CABLE TO DIMENSION SHOWN. DO NOT KNICK BRAID OR CENTER CONDUCTOR.
- 2.) SLIDE BUSHING OVER BRAID UNTIL JACKET BUTTS UP AGAINST ID OF BUSHING. FOLD BRAID BACK OVER BUSHING AS SHOWN AND TRIM. TRIM DIELECTRIC TO DIMENSION SHOWN (.275).
- 3.) SLIDE CONTACT/INSULATOR ASSEMBLY ONTO CENTER CONDUCTOR OF CABLE AND CRIMP USING CRIMP TOOL #M22520/2-01, SELECTOR #3 (NO POSITIONER NEEDED) OR SOFT SOLDER INTO PLACE.
- 4.) SLIDE CABLE ASSEMBLY INTO BODY AND PUSH UNTIL BUSHING BUTTS AGAINST BODY. CRIMP IN AREA INDICATED USING CRIMP TOOL #M22520/5-01 (DANIELS HX4) WITH DIE #M22520/5-104 (DANIELS #Y692 HEX B) OR DANIELS #Y793, HEX B. APPLY PRESSURE TO CABLE IN DIRECTION SHOWN DURING CRIMPING PROCESS.
- (D) 5.) CRIMP INSTRUCTIONS ABOVE APPLY TO ARINC SIZE 8 CONTACTS. THE COAXIAL CABLES THAT WORK WITH THIS CONTACT ARE:
FOR THE Y793 HEX B: PFLX175-075-01, PFLX-190-075-01
PFLX195-500, PFLX240-500
FOR THE Y692 HEX B: TFLX125-075-01.



NOTE:

- 1). RECOMMENDED SOLDER TEMPERATURE: 700-750° F (371-398° C)

DATE 01/20/2004	EMTEQ 5349 SOUTH EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	CABLE ASSEMBLY INSTRUCTIONS	SHT 1 OF 1
DRAWN V. LEX			
DESIGNED			
CHECKED V. LEX	05/29/2014		
APPROVED K. BACHLEDA	05/29/2014	CAGE CODE 06WH3	DWG # ES-105-36

FILE: ES-105-36 prt