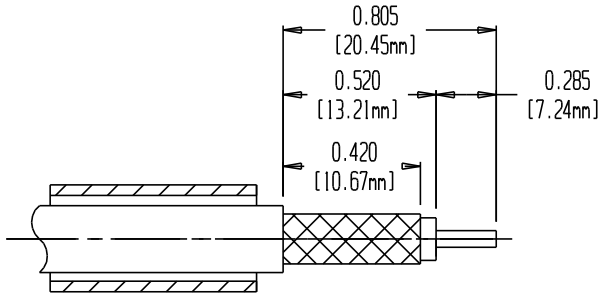
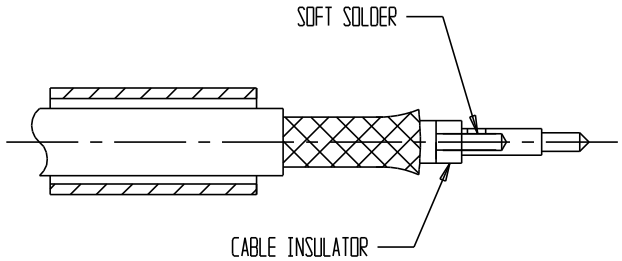
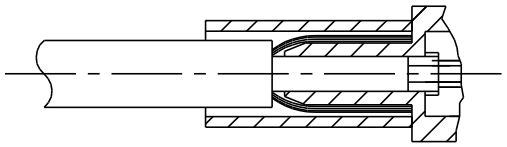
REV	REVISION	DATE	ER #	INTL
IR1	UPDATED INSTRUCTION, CHART	10/09/2006	5704	LRL







ES-105-49
CABLE ASSEMBLY INSTRUCTIONS

1.) SLIDE ON ANY HEAT SHRINK LABELS IF USED, THEN THE BLACK ADHESIVE HEAT SHRINK AND THEN THE CRIMP TUBE, SMALL END FIRST IF APPLICABLE.

2.) STRIP THE CABLE PER THE DIMENSIONS SHOWN. REMOVE THE MATERIALS.

3.) INSTALL THE CABLE INSULATOR ONTO THE CENTER CONDUCTOR BUTTING IT UP AGAINST THE CABLE DIELECTRIC.

4.) TIN THE CENTER CONDUCTOR, THEN SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, BUTTING THE CONTACT UP AGAINST THE CABLE INSULATOR, LEAVING NO GAPS. CAUTION: DO NOT OVERHEAT THE CONTACT AND SWELL THE DIELECTRIC AND/OR INSULATOR. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.

5.) FLARE THE OUTER SHIELD BRAID BY GENTLY ROTATING THE CONTACT AND DIELECTRIC, THEN FINISH TO FLARE OUT, NOT DISTURBING THE INNER FOIL SHIELD. DO NOT REMOVE THE ALUMINUM MYLAR FOIL INNER SHIELD FROM THE DIELECTRIC.

6.) INSERT THE CONTACT INTO THE REAR OF THE CONNECTOR BODY, THE INNER SHIELD BEING INSIDE OF THE CONNECTOR BODY AND THE BRAID SHIELD OUTSIDE, UNTIL THE CONTACT SNAPS INTO PLACE. SLIDE THE CRIMP TUBE UP OVER THE BRAID AND UP AGAINST THE CONNECTOR BODY. CRIMP USING M22520/5-01 (HX4) CRIMPING TOOL WITH APPROPRIATE DIE. SEE CHART.

7.) SLIDE BLACK ADHESIVE HEAT SHRINK UP OVER REAR END OF CONNECTOR BODY (EXCLUDING ARINC CONNECTOR'S) AND HEAT SHRINK. FOR ARINC CONNECTOR'S, SLIDE UP TO REAR OF CONNECTOR BODY AND HEAT SHRINK.

CABLE TYPE	MIL-SPEC HEX DIE P/N	HEX SIDE	SOLDER TEMPERATURE
LMR400	M22520/5-67	.429	700-800 ° F (371-448 ° C)
PFLX140-XXX	M22520/5-41	B	700-750 ° F (371-398 ° C)

DATE 04/05/2006
DRAWN L.LUGO
DESIGNED
CHECKED 10/09/2006 T.FORST
APPROVED 10/09/2006

EMTEQ
5349 S. EMMER DRIVE
NEW BERLIN, WI 53151
(888) 679-6170

CABLE STRIPPING INSTRUCTIONS

CAGE CODE 06WH3 | DWG # ES-105-49 | SHT 1 OF 1

FILE: ES-105-49.prt