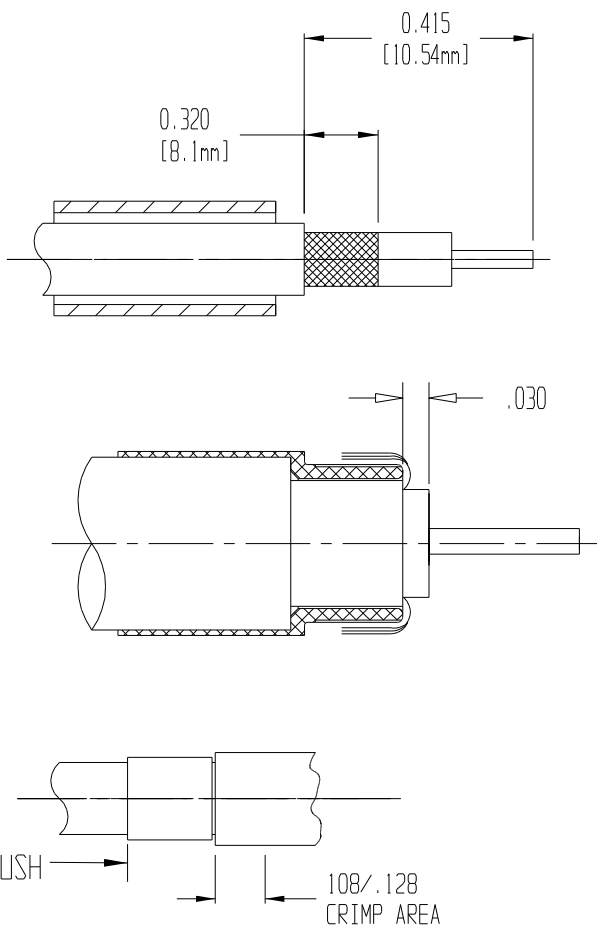


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REV	REVISION	DATE	ER #	INTL
A02	CORRECT NOTE 4, CORRECT DIE P/N & HEX SIDE	01/07/2011	11527	LLP
A03	DEL. NOTE 5, ADD NOTE 3, RENLUMBER NOTE 4 & 5	01/13/2011	11537	LLP
A04	UPDATE NOTE 2 AND NOTE 6	03/08/2011	11655	VML
A05	UPDATED NOTE 5; FROM SEL NO. 7 TO SEL NO. 6	05/31/2011	11916	VML
A06	NOTE 5 WAS M22520/2-01 SEL#6; POSITIONER WAS K343	06/28/2011	0060-11	ASL



ES-105-54  
CABLE ASSEMBLY INSTRUCTIONS

- 1.) SLIDE ON ANY HEAT SHRINK LABELS IF USED, THEN THE BLACK ADHESIVE HEAT SHRINK
- 2.) STRIP THE CABLE PER THE DIMENSIONS SHOWN. REMOVE THE MATERIALS.
- 3.) SLIDE BACK BUSHING OVER BRAID UNTIL JACKET BUTTS UP AGAINST ID OF BUSHING. FOLD BRAID BACK OVER BUSHING AS SHOWN.
- 4.) INSTALL THE CABLE INSULATOR ONTO THE CENTER CONDUCTOR BUTTING IT UP AGAINST THE CABLE DIELECTRIC.
- 5.) SOLDER CENTER CONTACT ONTO CABLE OR CRIMP USING MH995 AND POSITIONER K1795
- 6.) SLIDE THE CRIMP TUBE UP OVER THE BRAID AND UP AGAINST THE CONNECTOR BODY. CRIMP AT A LENGTH OF 0.108 TO 0.128 AT THE END OF THE CONTACT, USING M22520/5-01 (HX4) CRIMPING TOOL WITH APPROPRIATE DIE. SEE CHART.

CABLE TYPE	MIL-SPEC HEX DIE P/N	DANIELS HEX DIE P/N	HEX SIDE	SOLDER TEMPERATURE
PFLX190-075-01	N/A	Y2016P	N/A	700-750° F (371-398° C)

DATE 11/02/2010	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	CABLE STRIPPING INSTRUCTIONS	FILE: ES-105-54.Pr
DRAWN V. LEX			
DESIGNED	CABLE STRIPPING INSTRUCTIONS		
CHECKED <i>[Signature]</i> 06/28/2011	CABLE STRIPPING INSTRUCTIONS		
APPROVED T. FORST 06/28/2011	CAGE CODE 06WH3	DWG # ES-105-54	SHT 1 OF 1