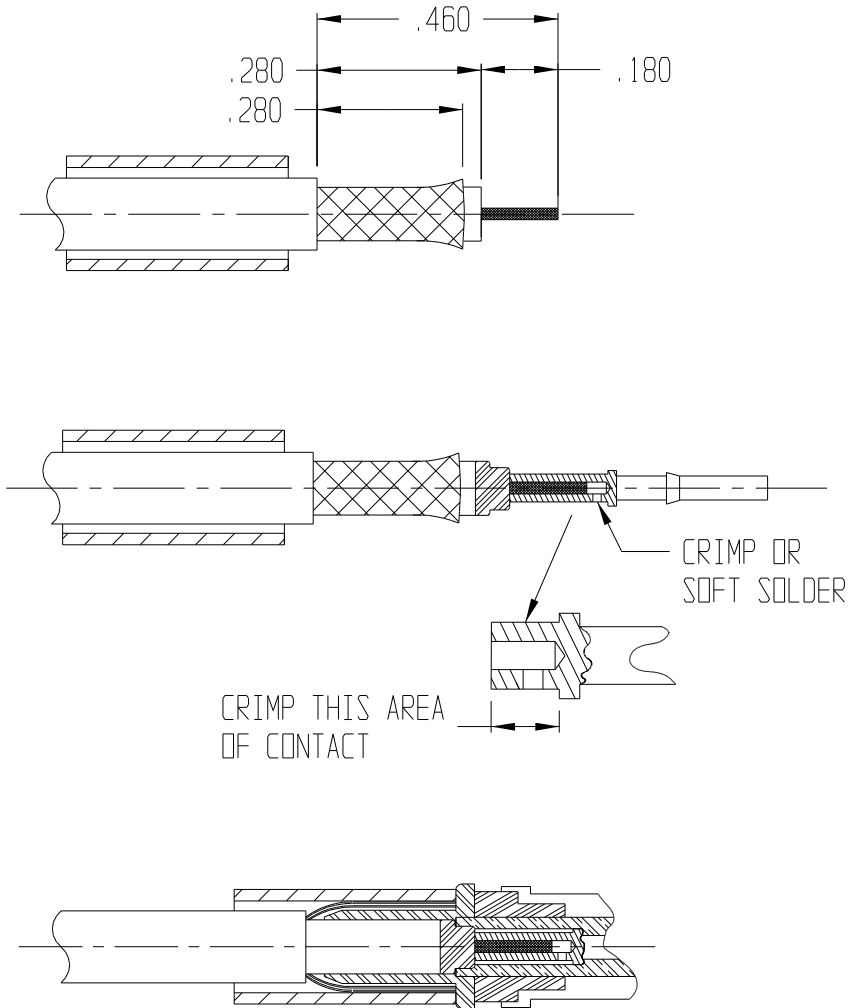


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REV	REVISION	DATE	ER #	INTL
IR	INITIAL RELEASE	10/06/2008	8964	VML
A	ADD CABLES PFLX175-095 & TFLX125-075	12/1/2008	9136	LLP

ES-105-58  
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. SLIDE BLACK ADHESIVE HEAT SHRINK AND ANY OTHER LABELS OVER THE CABLE AT THIS TIME.
- 2.) FLARE END OF CABLE BRAID BY ROTATING CABLE DIELECTRIC. SLIDE CABLE INSULATOR ONTO CENTER CONDUCTOR UP AGAINST DIELECTRIC. CRIMP OR SOLDER CONTACT ONTO CENTER CONDUCTOR AS SHOWN. IF CRIMPING CONTACT USE CRIMP TOOL #M22520/2-01 AND SELECT NO. 1. SEE DIAGRAM FOR CRIMPING LOCATION. IF SOLDERING CONTACT, DO NOT OVERHEAT AND SWELL CABLE DIELECTRIC. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.
- 3.) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL CONTACT BOTTOMS OUT IN CONNECTOR. SLIDE CRIMP TUBE OVER BRAID & UP AGAINST THE CONNECTOR BODY. CRIMP USING APPROPRIATE HEX SIZE CRIMPING TOOL.

CABLE TYPE	MIL-SPEC HEX DIE P/N	DANIELS HEX DIE P/N	HEX SIZE	SOLDER TEMPERATURE
PFLX175-095	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
PFLX195-075	M22520/5-05	Y197	A	700-750 ° F (371-398 ° C)
TFLX125-075	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)

DATE 10/06/2008	<b>EMTAQ</b> 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170
DRAWN V. LEX	
DESIGNED	CABLE STRIPPING INSTRUCTIONS
CHECKED T. FORST 12/1/2008	
APPROVED <i>[Signature]</i> 12/2/2008	CAGE CODE 06WH3
DWG # ES-105-58	
SHT 1 OF 1	

FILE: ES-105-58.dwg