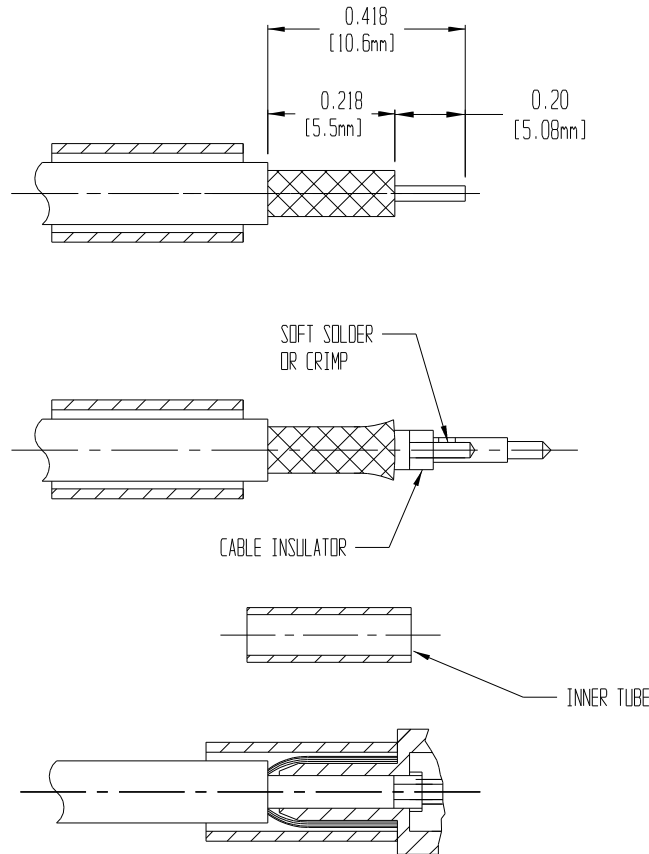


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REV	REVISION	DATE	ER #	INTL
E	UPDATED INSTRUCTION	05/14/2007	7029	LRL
F	UPDATED INSTRUCTION AFTER NOTE 3	09/18/2007	7589	VML



ES-105-71 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.

2.) FLARE END OF CABLE BRAID BY ROTATING CABLE DIELECTRIC. SLIDE CABLE INSULATOR ONTO CENTER CONDUCTOR UP AGAINST DIELECTRIC. INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT THE TUBE PORTION OF BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL CENTER CONDUCTOR IS FULLY SEATED. SOLDER CENTER CONDUCTOR ONTO CONTACT. DO NOT OVERHEAT AND SWELL CABLE DIELECTRIC. SEE CHART FOR RECOMMENDED SOLDER TEMPERATURES.

3.) SLIDE CRIMP TUBE OVER BRAID & UP AGAINST CONNECTOR BODY. CRIMP USING APPROPRIATE HEX SIZE CRIMPING TOOL. RECOMMEND USING M22520/5-01 TOOL FRAME.

* DFC & DMC 125-075-1 TO BE CRIMPED USING Y322A.

CABLE TYPE	HEX SIZE	P/N	SOLDER TEMPERATURE
PFLX175-075-XX	B	M22520/5-43	700-750 ° F (371-398 ° C)
RG-142 B/U	B	M22520/5-19	700-750 ° F (371-398 ° C)
PFLX140-XXX	B	M22520/5-41	700-750 ° F (371-398 ° C)
PFLX195-XXX	B	M22520/5-19	700-750 ° F (371-398 ° C)
PFLX200-XXX	B	M22520/5-19	700-750 ° F (371-398 ° C)
PFLX240-XXX	A	M22520/5-43	700-750 ° F (371-398 ° C)
PFLX340-XXX	A	M22520/5-35	750-800 ° F (398-427 ° C)
PFLX400-XXX	-	M22520/5-61	800-850 ° F (427-454 ° C)
PFLX500-XXX	-	M22520/5-21	800-850 ° F (427-454 ° C)
* TFLX125-075-XX	B	M22520/5-41	700-750 ° F (371-398 ° C)
TFLX130-XXX	B	M22520/5-41	700-750 ° F (371-398 ° C)
TFLX165-XXX	B	M22520/5-19	700-750 ° F (371-398 ° C)
TFLX205-XXX	A	M22520/5-43	700-750 ° F (371-398 ° C)
TFLX225-XXX	A	M22520/5-43	700-750 ° F (371-398 ° C)
TFLX295-XXX	A	M22520/5-35	750-800 ° F (398-427 ° C)
TFLX350-075-XX	-	M22520/5-23	700-750 ° F (371-398 ° C)
TFLX480-XXX	-	M22520/5-27	800-850 ° F (427-454 ° C)

DATE	03/28/2001
DRAWN	A. SWENSON
DESIGNED	
CHECKED	T. FORST 09/19/2007
APPROVED	[Signature] 09/19/2007



5349 S. EMMER DRIVE
NEW BERLIN, WI 53151
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CABLE STRIPPING INSTRUCTIONS

CAGE CODE	DWG #	SHT
06WH3	ES-105-71	1 OF 1

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