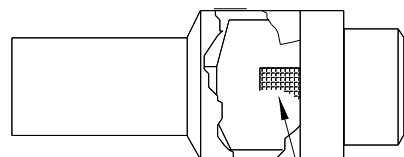
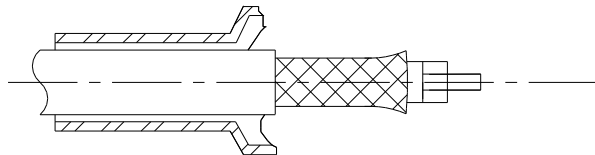
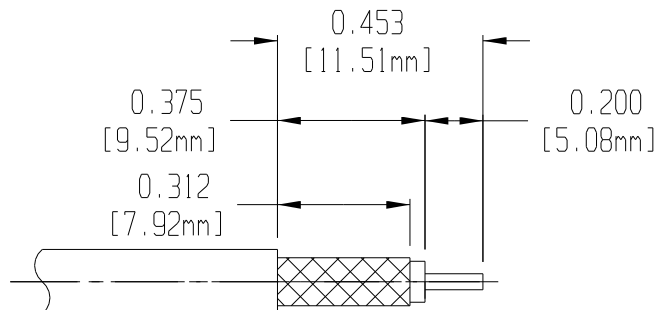


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REV	REVISION	DATE	ER #	INTL
D	UPDATED INSTRUCTION	05/25/2007	7102	LRL
E	UPDATED INSTRUCTION AFTER NOTE 3	09/18/2007	7589	VML




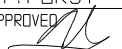
SOFT SOLDER CENTER CONTACT

ES-105-72
CABLE ASSEMBLY INSTRUCTION

- 1.) STRIP CABLE PER DIMENSIONS, DO NOT NICK 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.
- 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	MIL-SPEC HEX DIE P/N	DANIELS HEX DIE P/N	HEX SIZE	SOLDER TEMPERATURE
PFLX175-075-XX	M22520/5-43	Y141	B	700-750 ° F (371-398 ° C)
RG-142 B/U	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX140-XXX	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
PFLX195-XXX	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX200-XXX	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
PFLX240-XXX	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
PFLX340-XXX	M22520/5-35	Y137	A	750-800 ° F (398-427 ° C)
PFLX400-XXX	M22520/5-61	Y178	A	800-850 ° F (427-454 ° C)
PFLX500-XXX	M22520/5-21	Y149	A	800-850 ° F (427-454 ° C)
* TFLX125-075-XX	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
TFLX130-XXX	M22520/5-41	Y140	B	700-750 ° F (371-398 ° C)
TFLX165-XXX	M22520/5-19	Y142	B	700-750 ° F (371-398 ° C)
TFLX205-XXX	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
TFLX225-XXX	M22520/5-43	Y141	A	700-750 ° F (371-398 ° C)
TFLX295-XXX	M22520/5-35	Y137	A	750-800 ° F (398-427 ° C)
TFLX480-XXX	M22520/5-27	Y151	A	800-850 ° F (427-454 ° C)

DATE 04/18/2000	 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170
DRAWN A. LIPOWSKI	
DESIGNED	
CHECKED T. FORST 09/19/2007	CABLE STRIPPING INSTRUCTIONS
APPROVED  09/19/2007	
CAGE CODE 06WH3	DWG # ES-105-72
SHT 1 OF 1	

FILE: ES-105-72.prt