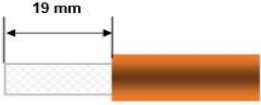
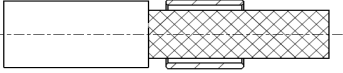
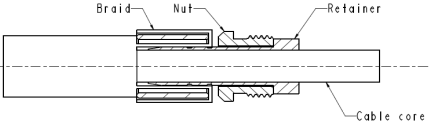
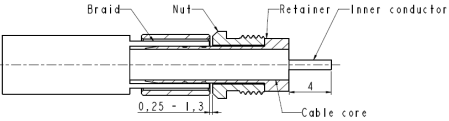
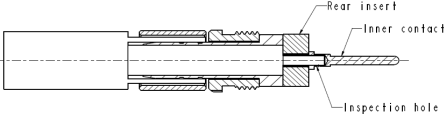
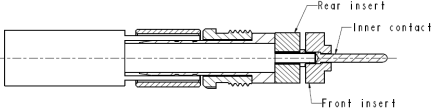
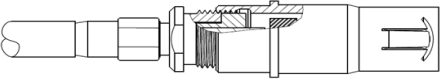


PICTURE	PROCESS	CHECK	TOOLS
	<p>STRIP THE JACKET SLIDE THE PIGGY BACK GROMMET</p>	<p>DO NOT DAMAGE THE BRAID</p>	<p>BLADE</p>
	<p>SLIDE THE FERRULE IN THE BRAID OPEN THE BRAID IN THE CRIMPING FERRULE</p>	<p>DO NOT DAMAGE THE BRAID</p>	
	<p>POSITION NUT ON RETAINER AS ILLUSTRATED SLIDE THE ASSEMBLY BETWEEN THE CABLE CORE AND THE BRAID</p>		
	<p>CUT THE BRAID OFF EXCESS STRIP INNER CONDUCTEUR CRIMP THE FERRULE IN POSITION (SEE DRAWING)</p>	<p>DO NOT DAMAGE THE INNER CONDUCTOR NUT MUST BE ROTATE FREELY AFTER CRIMPING SLEEVE</p>	<p>M22520/5-01 WITH DIE SET M22520/5-05 (A)</p>
	<p>INSTALL REAR INSERT ON BACK OF INNER PIN CONTACT SLIDE INNER CONTACT OVER CABLE CENTER CONDUCTOR SOLDER INNER CONDUCTOR</p>	<p>THE INNER CONDUCTOR SHALL BE VISIBLE THRU THE INSPECTION HOLE</p>	
	<p>SLIDE FRONT INSULATOR UNTIL THE INNER CONTACT FLANGE</p>		
	<p>SLIDE OUTER PIN CONTACT OVER INNER SOCKET ASSEMBLY AND INSULATOR THREAD NUT INTO REAR OF OUTER PIN CONTACT TIGHTEN NUT UNTIL METAL TO METAL (0.21-0.25N.M)</p>	<p>DO NOT ALLOW THE CABLE TO ROTATE WHILE TIGHTENING THE NUT</p>	