PICTURE	PROCESS	CHECK	TOOLS
CABLE CABLE BRAID	STRIP THE JACKET SLIDE THE PIGGY BACK GROMMET IF APPLICABLE AND CRIMPING FERULE	DO NOT DAMAGE THE BRAID	BLADE
CRIMP CABLE BRAID INNER WIRES TRIM 11.4	OPEN THE BRAID OVER THE CRIMPING FERULE	THE BRAID SHALL COVER EQUALLY THE CRIMPING FERULE	BLADE (to trim excess braid)
CRIMP BUSHING CENTER CONDUCTORS 3.8	STRIP THE INNER CONDUCTORS	DO NOT DAMAGE THE INNER CONDUCTORS	BLADE
CRIMP CONTACTS (CONTACTS (PINS SHOWN FOR REFERENCE) INNER WIRES CABLE WINSPECTION HOLE	CRIMP THE INNER CONTACTS	THE INNER CONDUCTOR SHALL BE VISIBLE THRU THE INSPECTION HOLE	M22520/2-01 WITH POSITIONNER M22520/2-37 (5)
REAR INSULATOR SLOTS REAR INSULATOR SLOTS INNER CONTACTS INNER CONTACT RETENTION SHOULDER	INSTALL THE REAR INSULATOR AND RESPECT THE LOCATION FOR EACH INDIVIDUAL CONTACT		
REAR INSULATOR FRONT INSULATOR KEYWAY REAR INSULATOR FRONT CONTACTS SLOTS INSULATOR	SLIDE THE FRONT INSULATOR OVER THE CONTACT BY THE FRONT	THE KEYWAY ORIENTATION SHALL MEET THE KEY WAY IN OUTER CONTACT	
S,84 CRIMP AREA OUTER CONTACT ORIENTATION KEY CRIMP OUTER CONTACT ORIENTATION KEY OUTER CONTACT ORIENTATION KEY OUTER CONTACT ORIENTATION KEY OUTER CONTACT ORIENTATION KEY	CRIMP THE OUTER CONTACT		M22520/5-01 WITH M22520/5-45(B)