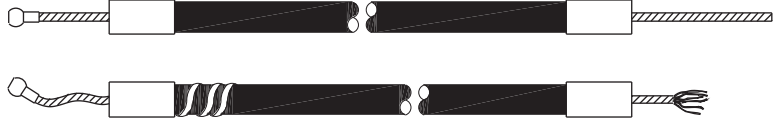


Soldering Cable Hints

1. Plug in solder pot and allow it to heat to proper temperature.
Determine the proper fittings to be used to make your cable.

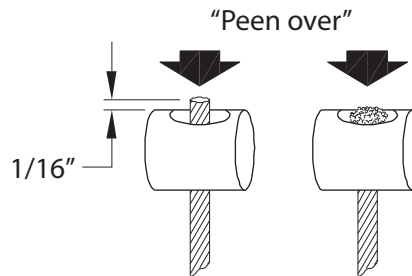


2. Compare new fittings and casing to old cable.
Check diameter of ferrules and end fittings to determine proper fit.



3. Measure the exposed wire on the old cable and write it down. The exposed wire will be the measurement with the wire pulled over to one side. See above figure.

4. Wire should extend through cable fitting $1/16$ " to allow for peening.
Peening the wire is very important to the solder joint strength.
See Figure.



5. Peen wire over fitting per figure.
6. Dip fitting into clean flux until complete fitting is covered.
7. Dip into solder pot, holding for approximately 10 seconds. This allows heat to penetrate evenly. Do not dip fitting more than $1/8$ " below full coverage. If solder is allowed to penetrate the wire, it can cause the wire to become brittle and break.
8. Recheck your new cable against the old cable and check solder for even, clean, penetrating coating.

