

# MICROPHONE CABLE ASSEMBLY WORK INSTRUCTION

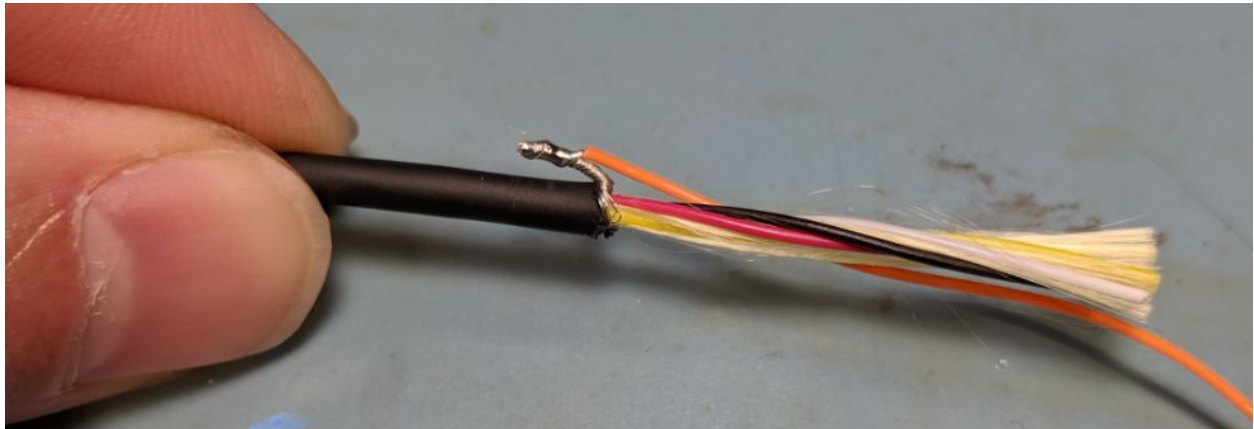
REV. B

USE IN CONJUNCTION WITH DRAWINGS WH-00125 & WH-00126

PAGE 1 OF 6

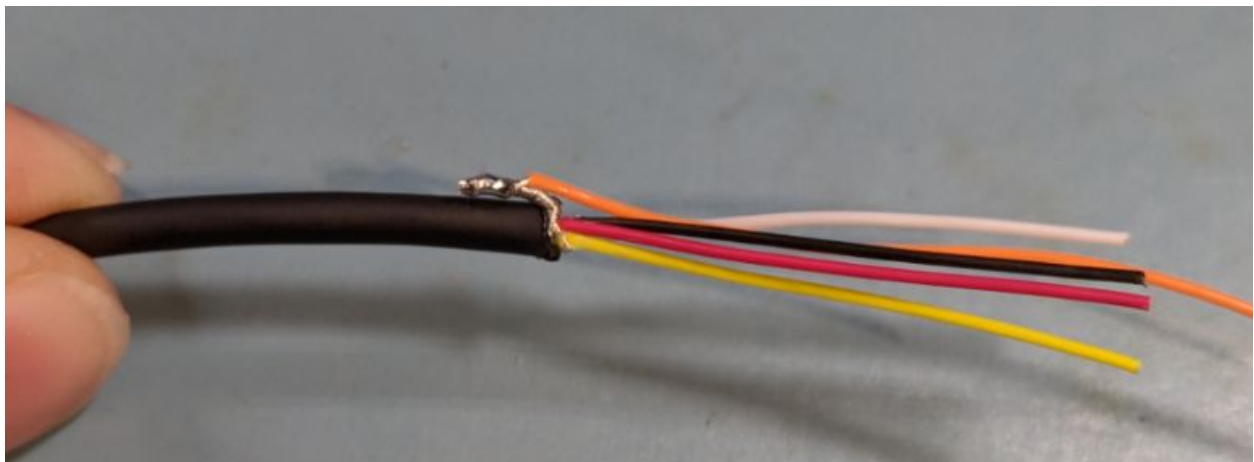
## 1. Terminate Inner Shield

- A) Remove the outer insulating jacket to an appropriate length (~30mm).
- B) Twist the shield conductors into one bundle.
- C) Strip the 28 AWG, 19 Strand, Orange wire to approximately 10mm length.
- D) Twist the orange wire around the shield conductors. Note it is very important to leave some length of shield (2mm min, 4mm preferred) between the orange wire and the wire bundle as a thermal and strain relief.
- E) Bend the shielded conductor wire back with the twisted orange wire such that the orange wire exits parallel to the other conductors in the shielded cable.
- F) Solder the orange wire to the shield conductors.
- G) Keep the orange wire parallel to the other conductors; do not bend the orange wire at the solder joint.
- H) Trim the shield conductors appropriately.



## 2. Finish the Termination

- A) Carefully separate the Kevlar filler material from the conductors.
- B) Trim the Kevlar material as close as possible to the shield connection.



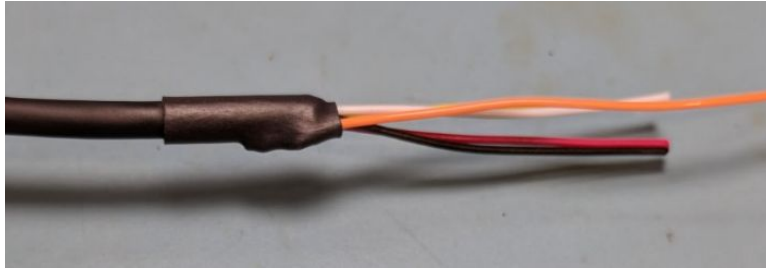
- C) Apply heat shrink tubing over the shield connection.

# MICROPHONE CABLE ASSEMBLY WORK INSTRUCTION

REV. B

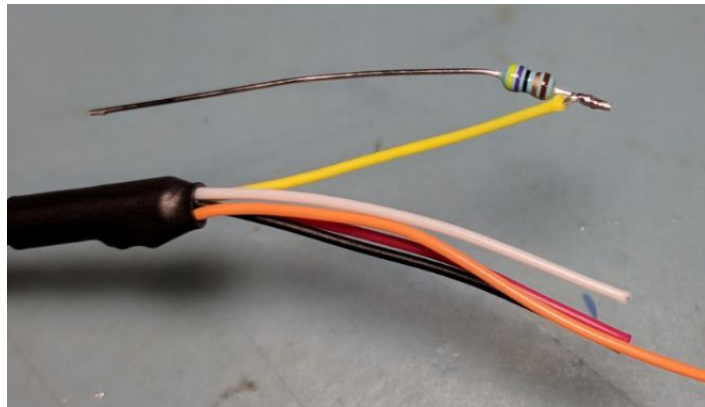
USE IN CONJUNCTION WITH DRAWINGS WH-00125 & WH-00126

PAGE 2 OF 6

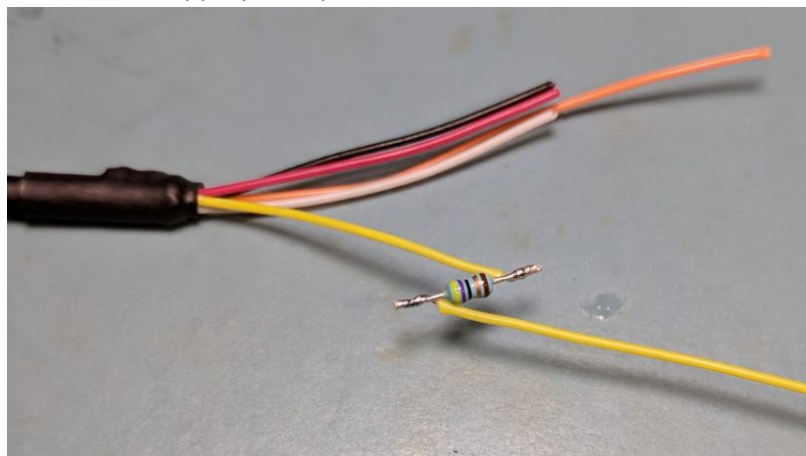


## 3. Install Resistors

- A) Strip the yellow wire approximately 10mm in length.
- B) Twist this wire around the 51 ohm resistor lead keeping the wire parallel to the resistor body.
- C) Solder the connection; trim appropriately.



- D) Strip another length of 28AWG, 19 Strand, Yellow wire to approximately 10mm length.
- E) Twist this wire around the other lead of the 51 ohm resistor keeping the wire parallel to the resistor body.
- F) Solder the connection; trim appropriately.



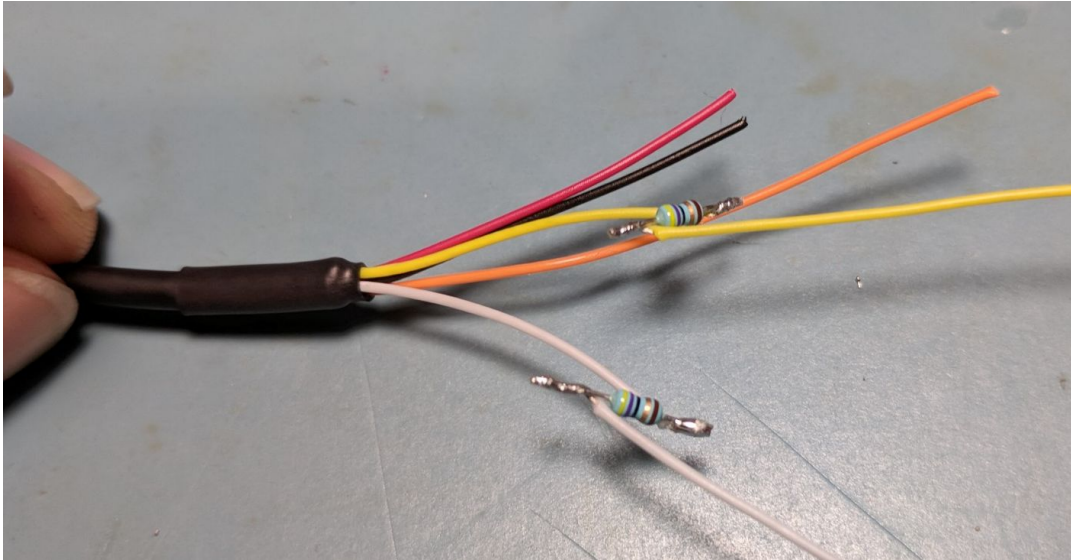
- G) Repeat this procedure for installing another 51 ohm resistor to the white wire. Use 28AWG, 19 Strand, White wire for the remaining lead of the resistor.

# MICROPHONE CABLE ASSEMBLY WORK INSTRUCTION

REV. B

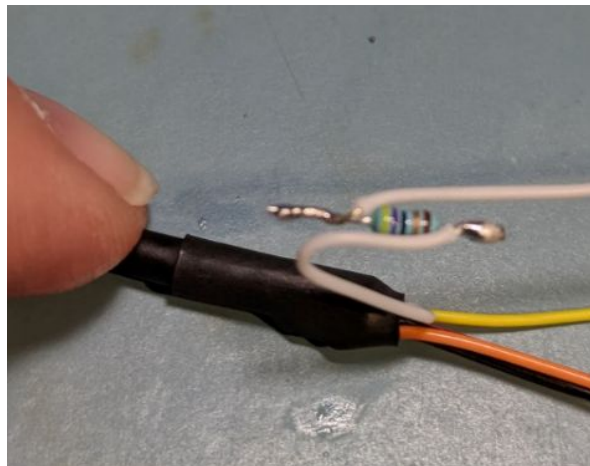
USE IN CONJUNCTION WITH DRAWINGS WH-00125 & WH-00126

PAGE 3 OF 6



## 4. Finish Resistors

- A) Form the conductors around the resistors. The yellow and white conductors existing the shielded bundle should double back around the resistor to run parallel to the resistor body. Do not bend the wires at the solder joint. Note there should be a well-defined loop in the conductor going to the resistor.



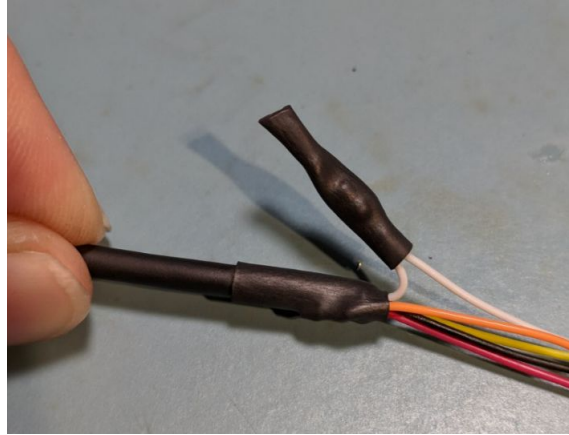
- B) Apply heat shrink over the resistor.

# MICROPHONE CABLE ASSEMBLY WORK INSTRUCTION

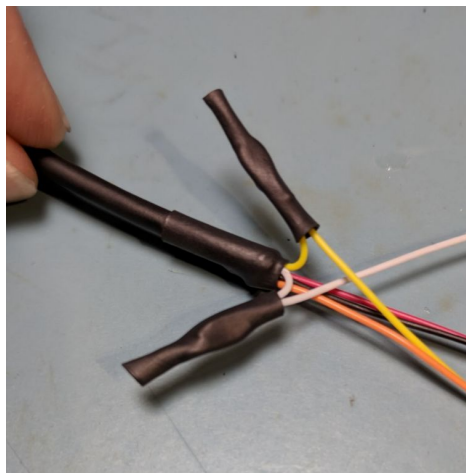
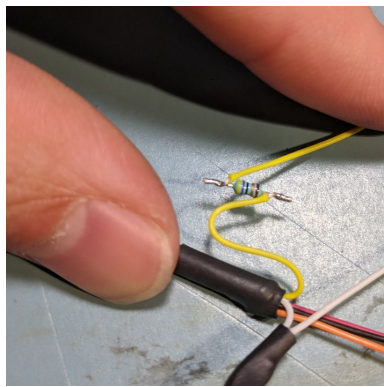
REV. B

USE IN CONJUNCTION WITH DRAWINGS WH-00125 & WH-00126

PAGE 4 OF 6



C) Repeat for the other resistor.



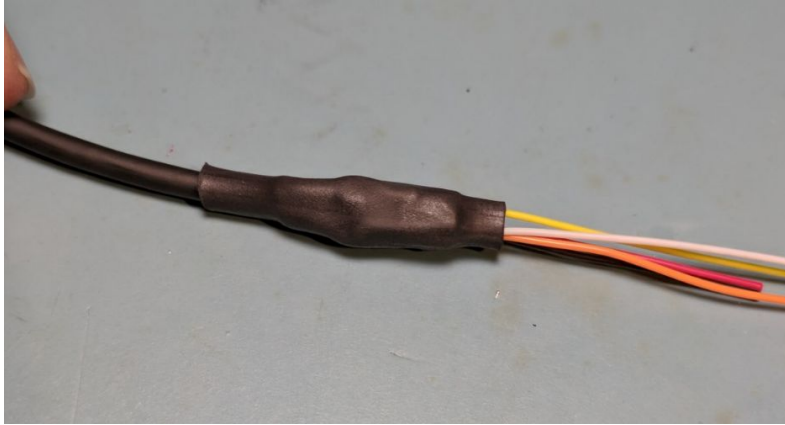
D) Apply heat shrink over the resistors and shield connection.

# MICROPHONE CABLE ASSEMBLY WORK INSTRUCTION

REV. B

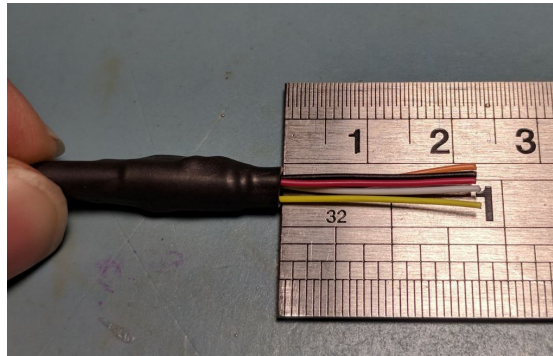
USE IN CONJUNCTION WITH DRAWINGS WH-00125 & WH-00126

PAGE 5 OF 6

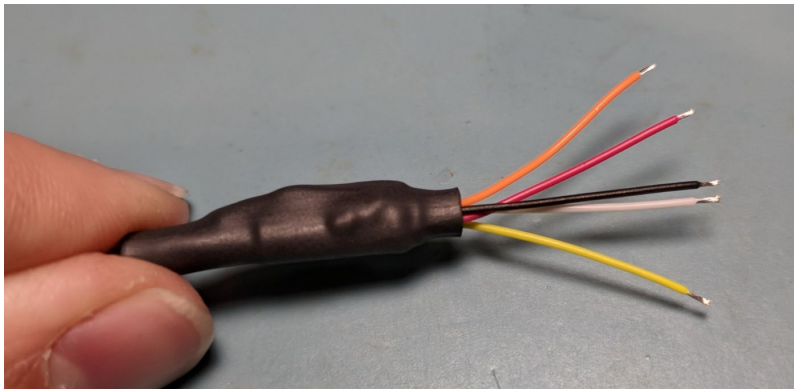


## 5. Add Contacts to P1 End

- A) Trim the conductors to an appropriate length (~22mm).



- B) Strip the ends per standard work instruction for JST SPHD (PA family) type contact.



- C) Install JST SPHD (PA family) type contacts per standard work instruction.

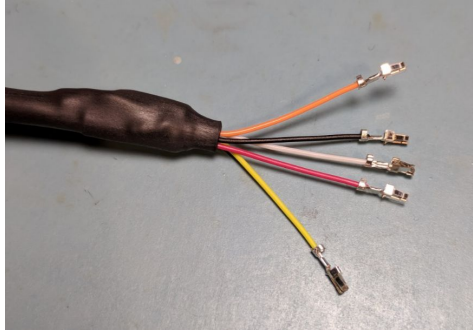


# MICROPHONE CABLE ASSEMBLY WORK INSTRUCTION

REV. B

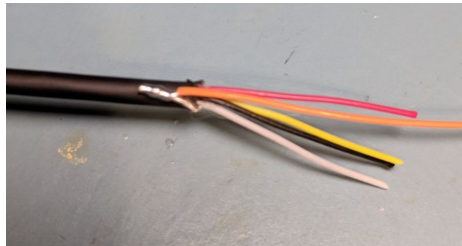
USE IN CONJUNCTION WITH DRAWINGS WH-00125 & WH-00126

PAGE 6 OF 6

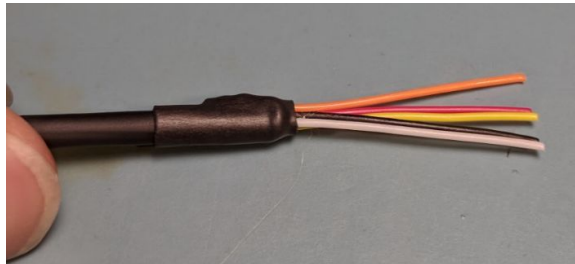


## 6. Terminate Shield at P2/P3 Ends

- A) Cut the cable to appropriate length to meet the specifications of the drawing.
- B) Remove the outer insulating jacket to an appropriate length (25mm).
- C) Twist the shield conductors into one bundle.
- D) Strip the 28 AWG, 19 Strand, Orange wire to approximately 10mm length.
- E) Twist the orange wire around the shield conductors. Note it is very important to leave some length of shield (2mm min, 4mm preferred) between the orange wire and the wire bundle as a thermal and strain relief.
- F) Bend the shielded conductor wire back with the twisted orange wire such that the orange wire exits parallel to the other conductors in the shielded cable.
- G) Solder the orange wire to the shield conductors.
- H) Keep the orange wire parallel to the other conductors; do not bend the orange wire at the solder joint.
- I) Trim the shield conductors appropriately.



- J) Apply heat shrink tubing over the shield connection and trim the shield conductor to match the length of the other conductors.



- K) Strip and crimp per standard work instruction to install the Amphenol Mezzselect contacts.

## 7. Finish the Cable Assembly

- A) Apply any labels called out by the part drawing.
- B) Insert the contacts into their respective housings per the part drawing.
- C) Visually inspect and test (if applicable) the assembly.