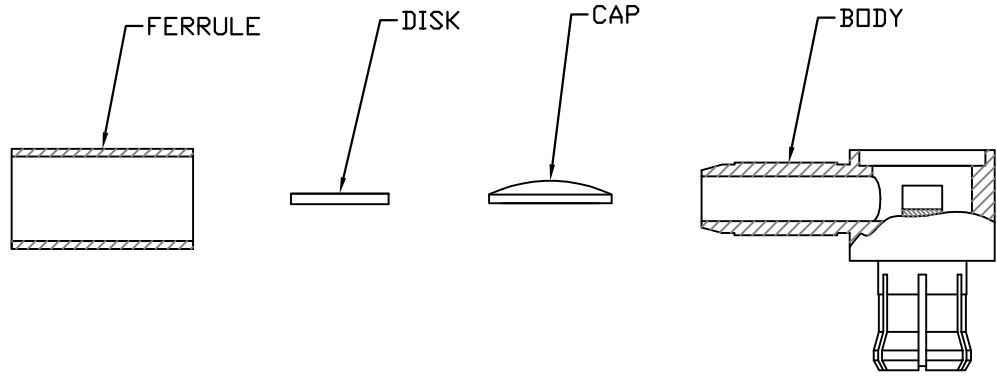


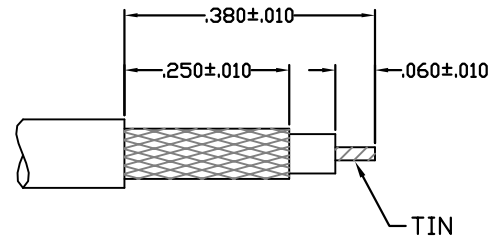
CABLE ASSEMBLY PROCEDURE	
P/N	13-2800-0400
PAGE 1 OF 1	DATE: 02/13/03
DRAWN: RVR	APPROVED: HN
USE WITH RG-178,196 OR SIMILAR CABLE	

The **PHOENIX** Company of Chicago™
 22 GREAT HILL RD., NAUGATUCK, CT 06770
 WWW.PHOENIXOFCHICAGO.COM
 PHONE: (203) 729-9090 FAX: (203) 723-1794

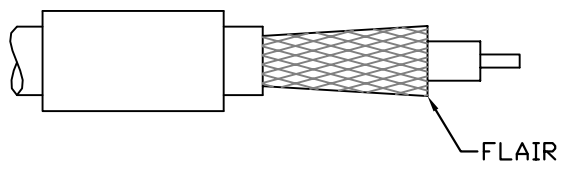
REV	DESCRIPTION	DATE	APPR
N	PER ECN 10762	12/01/10	JEM
P	PER ECN 10840	01/26/11	MS
R	PER ECN 118130	11/27/13	JEM
S	PER ECN 13633	1/14/20	JEM



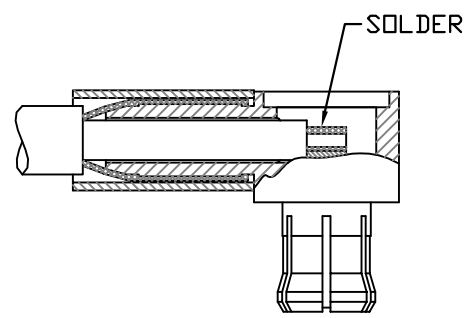
STEP 1
 TRIM CABLE TO DIMENSIONS
 SHOWN AND TIN CENTER CONDUCTOR.



STEP 2
 SLIDE FERRULE OVER CABLE.
 FLAIR BRAID BY ROTATING
 CABLE DIELECTRIC.



STEP 3
 SLIDE CABLE INTO BODY UNTIL CABLE
 DIELECTRIC BUTTS UP AGAINST CENTER
 CONTACT. SLIDE FERRULE OVER BRAID
 AND CRIMP USING .105 HEX DIE SET Y-196 (M22520/5-03).
 SOLDER CENTER CONDUCTOR TO CENTER CONTACT. CLEAN.



STEP 4
 PLACE TEFLON DISK INTO THE BODY,
 THEN PRESS CAP INTO THE BODY.

