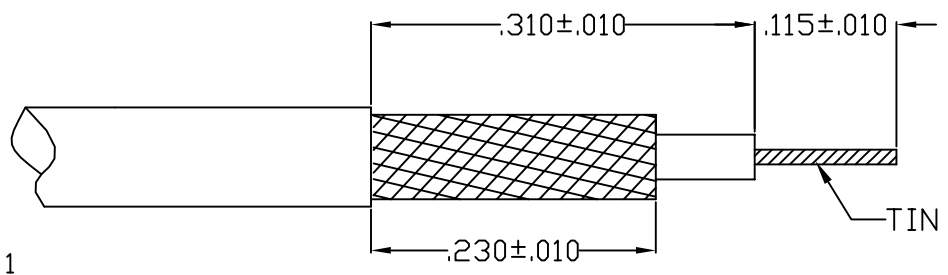


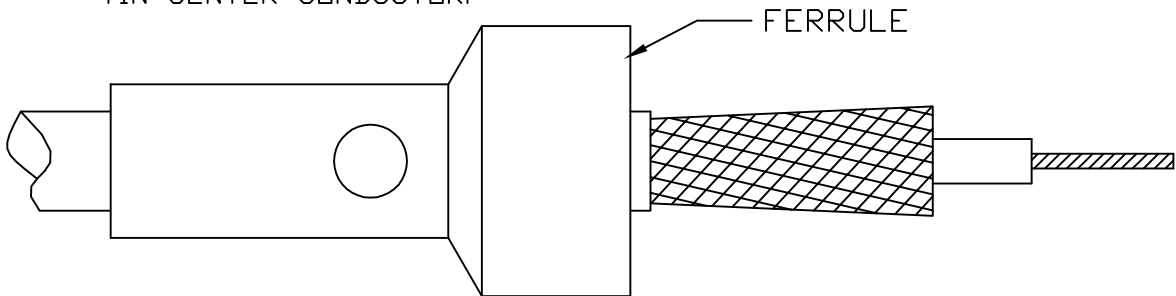
CABLE ASSEMBLY PROCEDURE	
P/N	15-0020-0400
PAGE 1 OF 1	DATE: 02/10/99
DRAWN: MY	APPROVED: HN
FOR USE RG-178 & 196 CABLES	

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

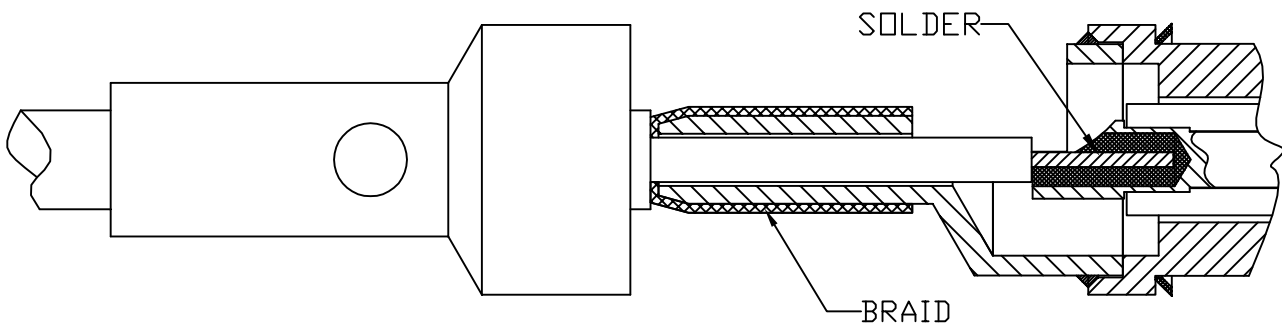
REV	DESCRIPTION	DATE	APPR
F	PER ECN 6332	02/10/99	HN
G	PER ECN 6823	12/12/02	HN
H	PER ECN 12608	08/29/17	JEM
J	PER ECN 13625	1/3/20	JEM



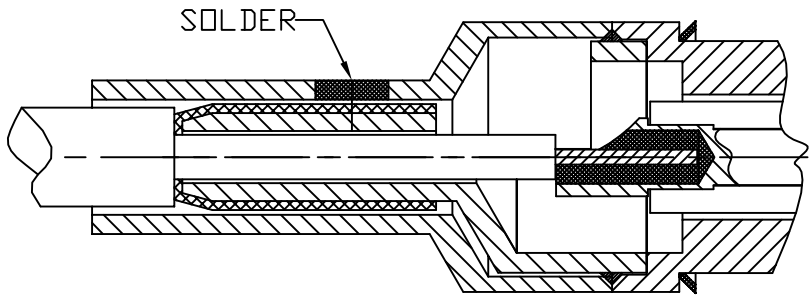
STEP 1  
 TRIM CABLE TO DIMENSIONS SHOWN.  
 TIN CENTER CONDUCTOR.



STEP 2  
 SLIDE FERRULE UP OVER CABLE,  
 ROTATE DIELECTRIC TO FLAIR BRAID.



STEP 3  
 INSERT CONNECTOR WEDGE BETWEEN CABLE BRAID  
 AND DIELECTRIC UNTIL CABLE DIELECTRIC BUTTS  
 AGAINST CONNECTOR CENTER CONTACT. SOLDER  
 CENTER CONDUCTOR OF CABLE TO CENTER CONTACT.  
 CLEAN.



STEP 4  
 SEAT FERRULE ON BODY AND SOLDER FERRULE TO  
 BODY THROUGH SOLDER HOLE. CLEAN.