

CABLE ASSEMBLY PROCEDURE

P/N 15-0080-0670

PAGE 1 OF 1 DATE: 04/23/01

DRAWN: EK APPROVED: HN

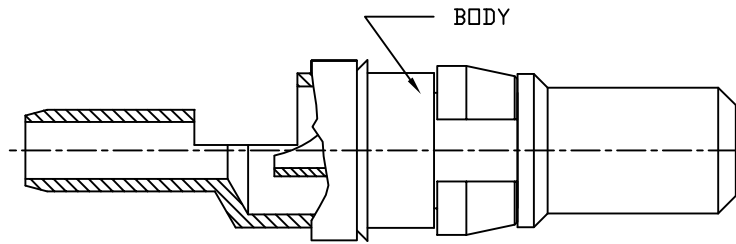
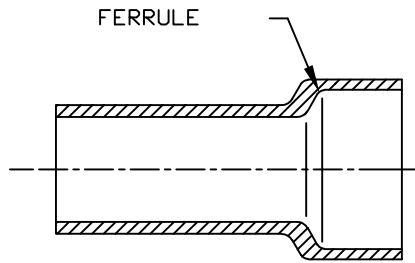
FOR USE RG174, 179, 188 & 316 CABLES

The **PHOENIX** Company of Chicago™

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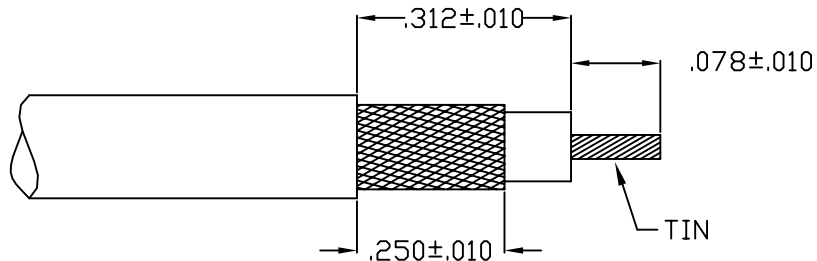
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REV	DESCRIPTION	DATE	APPR
C	PER ECN 6105	05/01/01	HN
E	PER ECN 6763	10/11/02	HN
F	PER ECN 6812	11/18/02	HN
G	PER ECN 13635	1/15/20	JEM



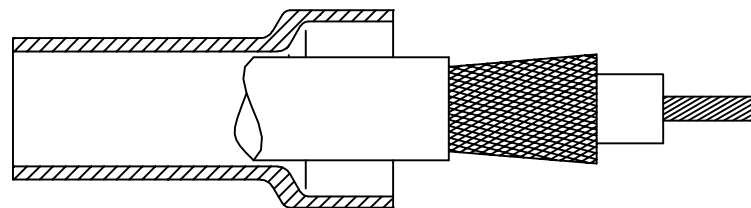
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR.



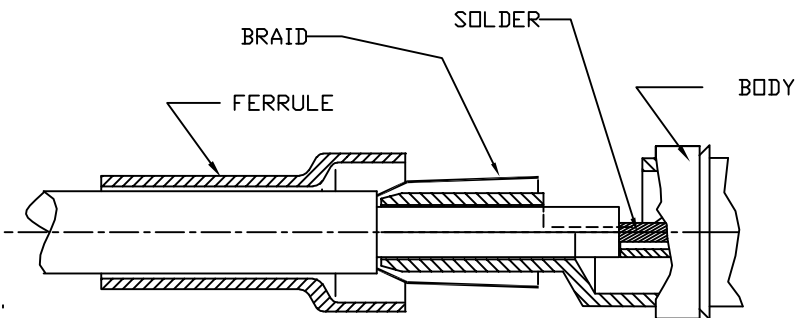
STEP 2

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

BUTT FERRULE AGAINST SHOULDER OF CONNECTOR
AND CRIMP USING .128 HEX DIE (M22520/5-03).

