



*Leading Blindmate Microwave Contact Technology*

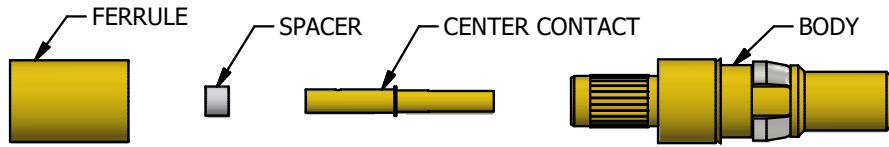
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# NOTICE!

The cable assembly procedure for this item changed and affects all product shipped from the factory after 7/1/23. This change includes the **cable strip dimensions and crimp tooling**. A copy of the new cable assembly procedure can be found in the “Assembly Procedure” listed in this same **Product Documents** section.

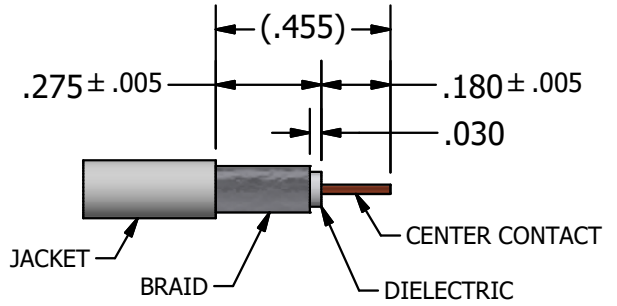
Please contact our sales team at [Sales@PhoenixofChicago.com](mailto:Sales@PhoenixofChicago.com) or 1-800-323-9562 for assistance with tooling or if you require the cable assembly instructions for product shipped from the factory prior to 7/1/23.

Thank you.

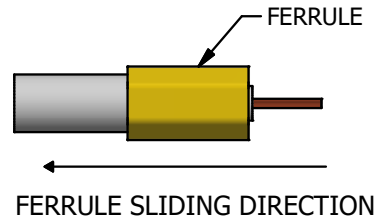


EXPLODED VIEW OF THE CONNECTOR

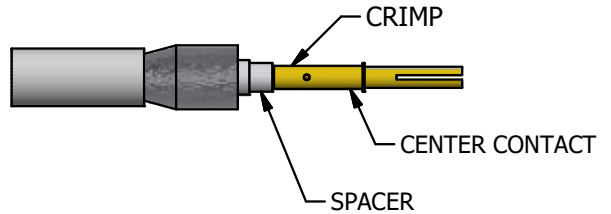
STEP 1  
TRIM CABLE TO DIMENSIONS SHOWN



STEP 2  
SLIDE FERRULE OVER THE CABLE.

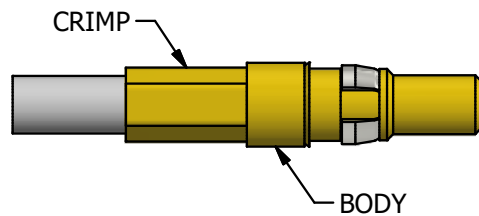


STEP 3  
SLIDE SPACER OVER THE CENTER CONDUCTOR OF THE CABLE UNTIL IT BOTTOMS AGAINST CABLE DIELECTRIC. SLIDE CENTER CONTACT ONTO CABLE CENTER CONDUCTOR AS SHOWN AND CRIMP THE CENTER CONTACT USING DANIELS 'AFM8' CRIMPER AND POSITIONER 'K2159'  
\*SETTING 8 FOR S86208 CABLE,  
\*SETTING 7 FOR TFLX130-100 CABLE.



ROTATE DIELECTRIC AND FLARE THE BRAID.

STEP 4  
SLIDE BODY ONTO PREPARED CABLE OVER DIELECTRIC AND UNDER THE BRAID. SLIDE FERRULE UP AGAINST THE SHOULDER OF THE BODY AND CRIMP USING .178 HEX DIE (M22520/5-05).

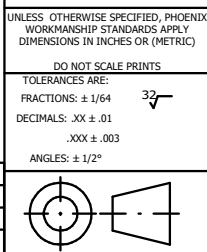


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MATERIAL:

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC)					
DO NOT SCALE PRINTS					
TOLERANCES ARE:					
FRACTIONS: ± 1/64					
DECIMALS: .XX ± .01					
.XXX ± .003					
ANGLES: ± 1/2°					
C	PER ECN 14435	BAK	6/24/2024	SPS	6/24/2024
B	PER ECN 14260	SPS	6/28/2023	SJG	6/28/2023
A	REL. PER ECN 5320	MY	12/23/1999	HN	12/23/1999
REV.	DESCRIPTION	BY	DATE	APPR.	DATE



APPROVALS		DATE
DRAWN	EY	12/23/1999
CHECKED	HN	12/23/1999
QA		
MFG		
ENGINEER	EY	12/23/1999
APPROVED	HN	12/23/1999

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TITLE  
**CABLE ASSEMBLY PROCEDURE FOR 15-0090-2202**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	15-0090-2202	C	
SCALE	F.S.R. #	SHEET 1 OF 1		