



*Leading Blindmate Microwave Contact Technology*

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# NOTICE!

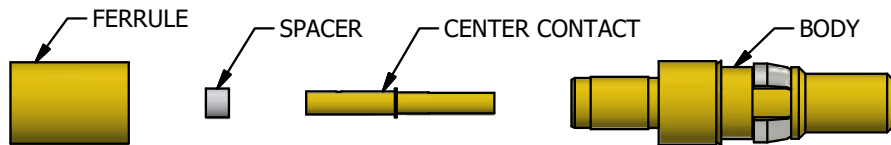
The cable assembly procedure for this item changed and affects all product shipped from the factory after 7/1/23. This change includes the **cable strip dimensions**. A copy of the new cable assembly procedure can be found in the “Assembly Procedure” listed in this same **Product Documents** section.

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.

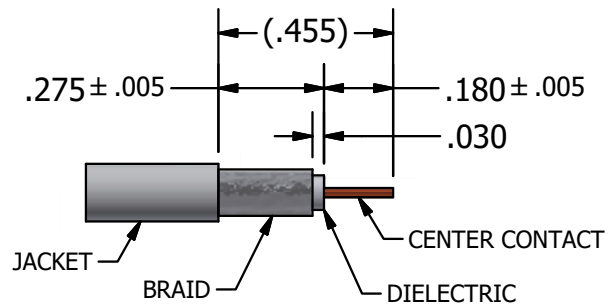
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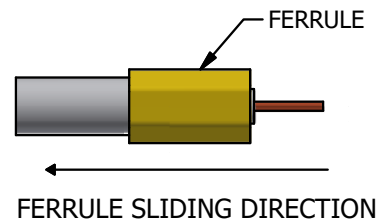


## EXPLODED VIEW OF THE CONNECTOR

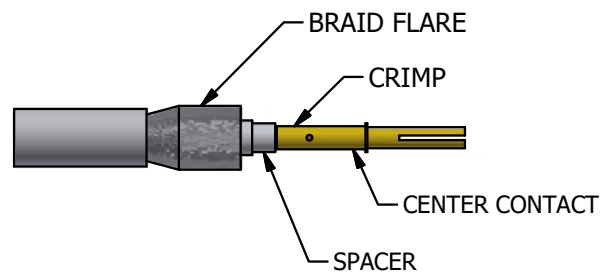
STEP 1  
TRIM CABLE TO DIMENSIONS SHOWN



STEP 2  
SLIDE FERRULE OVER THE CABLE.

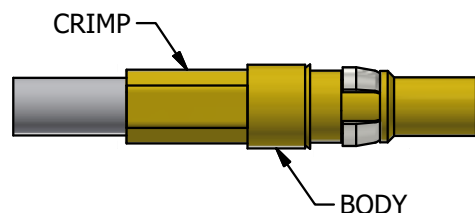


STEP 3  
SLIDE SPACER OVER THE CENTER CONDUCTOR OF THE CABLE UNTIL IT BOTTOMS AGAINST CABLE DIELECTRIC. SLIDE CENTER CONTACT ONTO CABLE CENTER CONDUCTOR AS SHOWN AND CRIMP THE CENTER CONTACT USING DANIELS 'AFM8' CRIMPER AND POSITIONER 'K2159'  
\*SETTING 3 FOR S86208 CABLE,  
\*SETTING 2 FOR TFLX130-100 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).

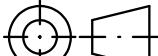


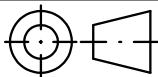
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## MATERIAL:

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

Filename: gs from server2\Autodesk Inventor Data Base\Assemblies\15 Series\15-0090-2202-CAP.idw			
UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC)			
DO NOT SCALE PRINTS			
TOLERANCES ARE:		APPROVALS	
FRACTIONS: ± 1/64		DATE	
DECIMALS: .XX ± .01		DRAWN	
.XXX ± .003		EY	12/23/1999
ANGLES: ± 1/2°		CHECKED	
		HN	12/23/1999
		QA	
		MFG	
		ENGINEER	
		EY	12/23/1999
		APPROVED	
		HN	12/23/1999



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PHONE: (800) 323-9562 FAX: (630) 206-1801					
TITLE					
<b>CABLE ASSEMBLY PROCEDURE FOR 15-0090-2202</b>					
SIZE	FSCM	DWG NO	REV	PLATING OPT.	
A	58167	15-0090-2202	B		
SCALE		F.S.R. #	SHEET 1 OF 1		

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