



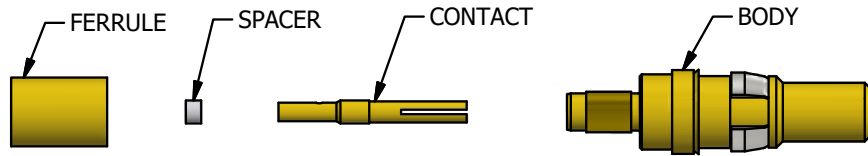
Leading Blindmate Microwave Contact Technology

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.

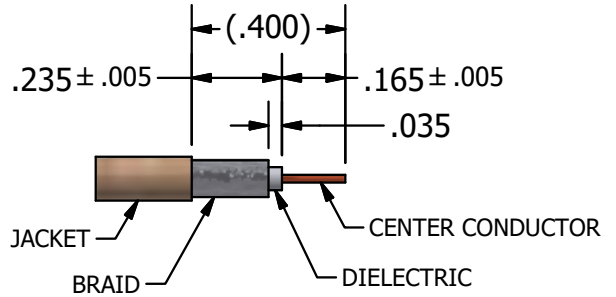
Please contact our sales team at Sales@PhoenixofChicago.com or 1-800-323-9562 for assistance with tooling or if you require the cable assembly instructions for product shipped from the factory prior to 7/1/23.

Thank you.

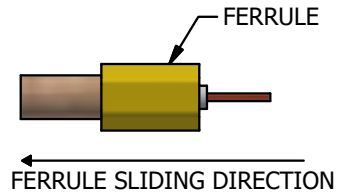


EXPLODED VIEW OF THE CONNECTOR

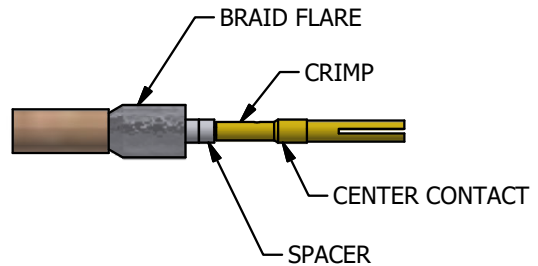
STEP 1
TRIM CABLE TO THE DIMENSIONS SHOWN.



STEP 2
SLIDE FERRULE OVER THE CABLE.

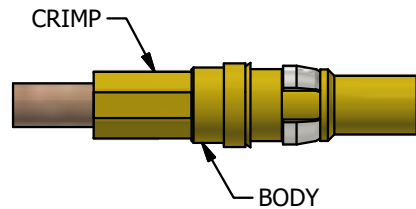


STEP 3
SLIDE SPACER OVER THE CENTER CONDUCTOR OF THE CABLE UNTIL IT BOTTOMS AGAINST CABLE DIELECTRIC. SLIDE CENTER CONTACT ONTO CABLE CENTER CONDUCTOR AS SHOWN AND CRIMP THE CENTER CONTACT USING DANIELS 'AFM8' CRIMPER - SETTING #1 AND POSITIONER 'K2159'.



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 .151 HEX DIE (M22520/5-37).



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MATERIAL:

| | | | | | |
|------|-------------------|-----|------------|-------|------------|
| D | PER ECN 14263 | SPS | 7/6/2023 | SJG | 7/6/2023 |
| C | PER ECN 10232 | SS | 03/15/2010 | JEM | 03/15/2010 |
| B | PER ECN 4680 | YS | 08/31/1998 | HN | 08/31/1998 |
| A | REL. PER ECN 4507 | EY | 05/20/1998 | HN | 05/20/1998 |
| REV. | DESCRIPTION | BY | DATE | APPR. | DATE |

Filename: gs from server2\Autodesk Inventor Data Base\Assemblies\15 Series\15-0090-2670-CAP.ipt
 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°

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| APPROVALS | DATE |
|-------------|------------|
| DRAWN EY | 05/20/1998 |
| CHECKED HN | 05/20/1998 |
| QA | |
| MFG | |
| ENGINEER EY | 05/20/1998 |
| APPROVED HN | 05/20/1998 |

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 WWW.PHOENIXOFCHICAGO.COM
 PHONE: (800) 323-9562 FAX: (630) 206-1801

TITLE
CABLE ASSEMBLY PROCEDURE FOR 15-0090-2670

| | | | | |
|-------|----------|--------------|-----|--------------|
| SIZE | FSCM | DWG NO | REV | PLATING OPT. |
| A | 58167 | 15-0090-2670 | D | |
| SCALE | F.S.R. # | SHEET 1 OF 1 | | |