



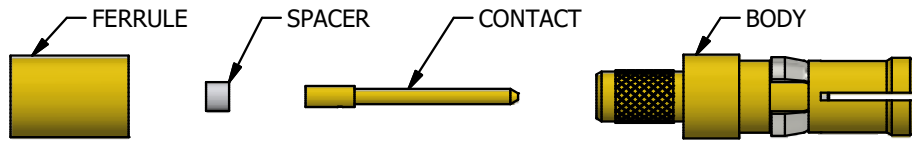
Leading Blindmate Microwave Contact Technology

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.

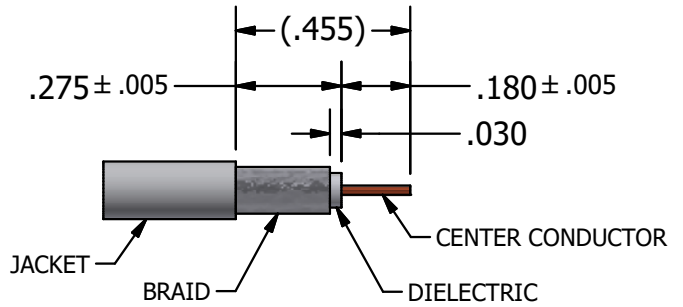
Please contact our sales team at Sales@PhoenixofChicago.com or 1-800-323-9562 for assistance with tooling or if you require the cable assembly instructions for product shipped from the factory prior to 7/1/23.

Thank you.

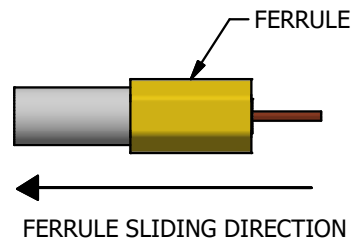


EXPLODED VIEW OF THE CONNECTOR

STEP 1
TRIM CABLE TO THE DIMENSIONS SHOWN.



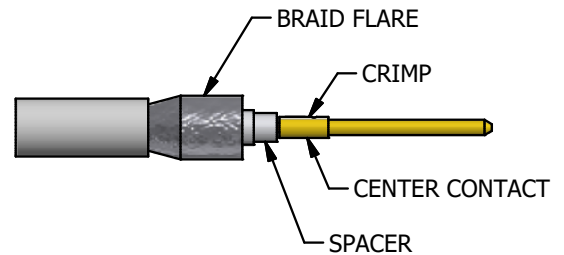
STEP 2
SLIDE FERRULE OVER THE CABLE.



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 AND POSITIONER 'K2160'

*SETTING 8 FOR S86208 CABLE.
*SETTING 7 FOR TFLX130-100 CABLE.

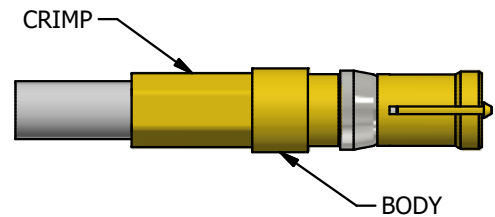
ROTATE DIELECTRIC AND FLARE THE BRAID.



STEP 4
SLIDE BODY ONTO PREPARED CABLE OVER DIELECTRIC AND UNDER THE BRAID UNTIL CONTACT BOTTOMS IN CONNECTOR.

CAUTION: PRIOR TO CRIMPING FERRULE, CENTER CONTACT MUST BE VISIBLE BEYOND CONNECTOR BODY AS SHOWN.

ONCE THIS IS CONFIRMED, SLIDE FERRULE UP AGAINST THE SHOULDER OF THE BODY AND CRIMP USING .178 HEX DIE (M22520/5-05).



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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
G	PER ECN 14435	BAK	4/21/2024	SPS	6/24/2024
F	PER ECN 14260	SPS	06/27/2023	SJG	06/27/2023
E	PER ECN 10530	HN	08/17/2010	JEM	08/17/2010
D	PER ECN 9380	HN	05/16/2008	JEM	05/16/2008
C	PER ECN 5090	EY	06/07/1999	HN	06/07/1999
B	PER ECN 4900	EY	01/27/1999	HN	01/27/1999
A	PER ECN 4871	EY	01/19/1999	HN	01/19/1999

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DO NOT SCALE PRINTS

TOLERANCES ARE:
FRACTIONS: ± 1/64
DECIMALS: .XX ± .01
.XXX ± .003

ANGLES: ± 1/2°

APPROVALS	DATE
DRAWN EY	01/19/1999
CHECKED JEM	01/19/1999
QA	
MFG	
ENGINEER EY	01/19/1999
APPROVED HN	01/19/1999

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TITLE
**CABLE ASSEMBLY PROCEDURE FOR
15-1090-2202**

SIZE A	FSCM 58167	DWG NO 15-1090-2202	REV G	PLATING OPT.
SCALE	F.S.R. #	SHEET 1 OF 1		