



Leading Blindmate Microwave Contact Technology

NOTICE!

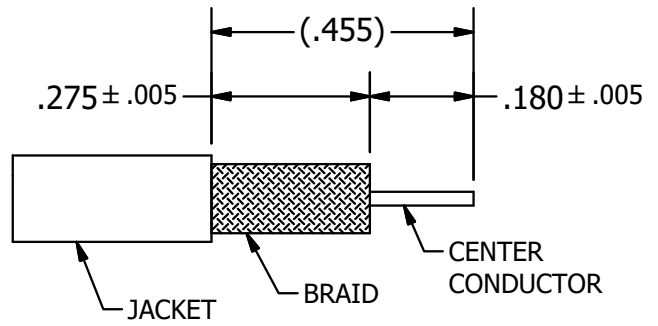
The cable assembly procedure for this item changed and affects all product shipped from the factory after 7/1/23. This change includes the **cable strip dimensions and crimp tooling**. A copy of the new cable assembly procedure is attached.

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.

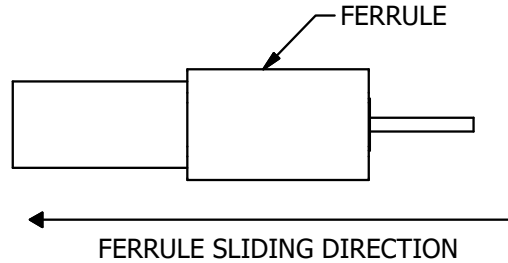
Technical questions can be directed to our Sales Application Engineer, Cory Clark, at cclark@phoenixofchicago.com or on his direct line at 475-212-3409.

Thank you.

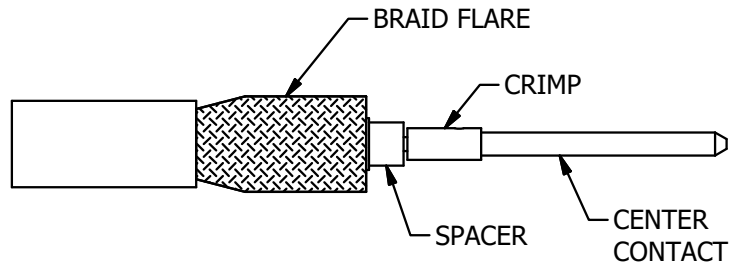
STEP 1
TRIM CABLE TO THE DIMENSIONS SHOWN.



STEP 2
SLIDE FERRULE OVER THE CABLE.

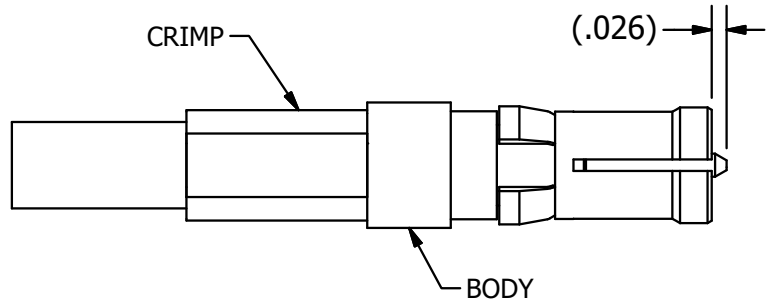


STEP 3
SLIDE SPACER OVER THE CENTER CONDUCTOR OF THE CABLE UNTIL IT BOTTOMS AGAINST CABLE DIELECTRIC. SLIDE CENTER CONTACT ONTO CABLE CENTER CONDUCTOR AS SHOWN AND CRIMP THE CENTER CONTACT USING DANIELS AFM8 CRIMPER,
*SETTING 3 FOR S86208 CABLE,
*SETTING 2 FOR TFLX130-100 CABLE, AND DANIELS POSITIONER K2160.



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 |
|------|---------------|-----|------------|-------|------------|
| F | PER ECN 14260 | SPS | 6/27/2023 | SJG | 6/27/2023 |
| 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 |

Filename: gs from server2\Autodesk Inventor Data Base\Assemblies\15 Series\15-1090-2202-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°

APPROVALS

| 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 | FSCM | DWG NO | REV | PLATING OPT. |
| A | 58167 | 15-1090-2202 | F | |

SCALE: F.S.R. # SHEET 1 OF 1