

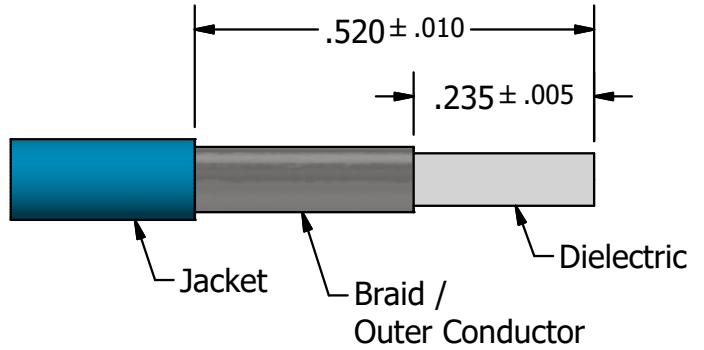
STEP 1 (PER CABLE TYPE)

**\*FOR FLEX CABLES: (Jacketed)**

- Flux and Tin Dip Cable to dimension  $.520 \pm .010$
- Trim Jacket to dimension -  $.520 \pm .010$
- Trim Braid to dimension -  $.235 \pm .005$

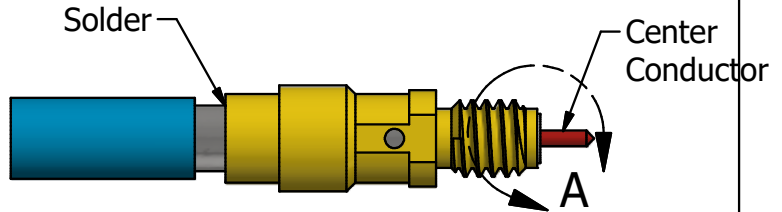
**\*FOR SEMI RIGID CABLES: (Non-Jacketed)**

- Trim Outer Conductor to dimension -  $.235 \pm .005$



STEP 2

Insert cable into solder nut and solder. Clean solder joint.

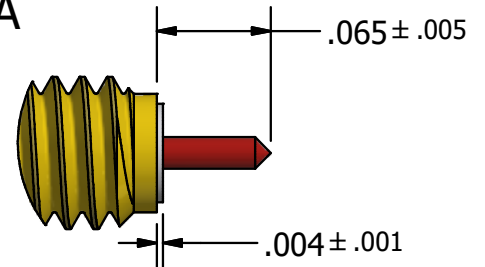


Now Trim:

- Dielectric to dimension :  $.004 \pm .001$ .
- Center Conductor Length:  $.065 \pm .005$ .

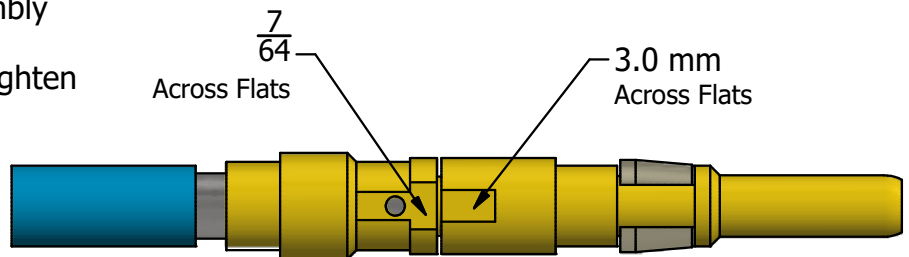
Point the Center Conductor.

DETAIL A



STEP 3

Screw body onto above cable assembly using  $\frac{7}{64}$  & 3.0 mm wrenches and tighten to 28-35 in-oz.



CAD DRAWING - NO MANUAL REVISIONS

filename:ver2\Autodesk Inventor Data Base\Assemblies\156 Series\156-0302-0861-CAP.idw

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MATERIAL:

B	PER ECN 13311	3/30/2020	JEM
A	REL. PER ECN 12500	4/12/2017	RMB
REV.	DESCRIPTION	DATE	APPR.

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC).  
DO NOT SCALE PRINTS  
TOLERANCES ARE:  
FRACTIONS:  $\pm 1/64$   
DECIMALS: .XX  $\pm .01$   
.XXX  $\pm .003$   
ANGLES:  $\pm 1/2^\circ$

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APPROVALS	DATE
DRAWN SPS	03/27/2020
CHECKED JEM	03/27/2020
QA	
MFG	
ENGINEER SPS	03/27/2020
APPROVED JEM	03/27/2020

The **PHOENIX** Company of Chicago, Inc.  
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TITLE  
**CABLE ASSEMBLY PROCEDURE FOR 156-0302-1861**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	156-0302-0861	B	
SCALE	4 : 1		F.S.R. #	SHEET 1 OF 1