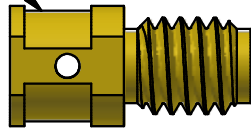


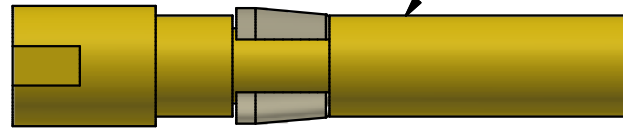
2

1

SOLDER NUT



BODY



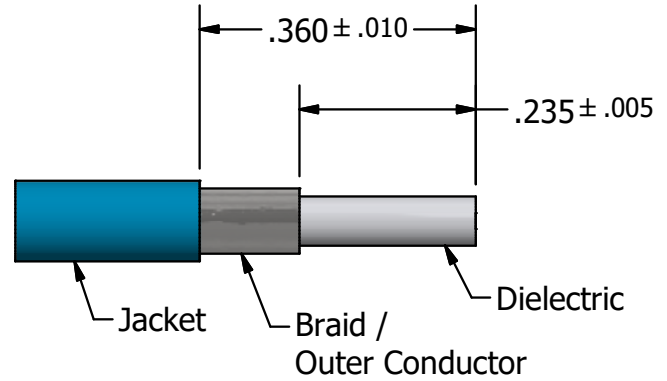
STEP 1 (PER CABLE TYPE)

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

Flux and Tin Dip Cable to dimension $.360 \pm .010$
Trim Jacket to dimension - $.360 \pm .010$
Trim Braid to dimension - $.235 \pm .005$

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

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

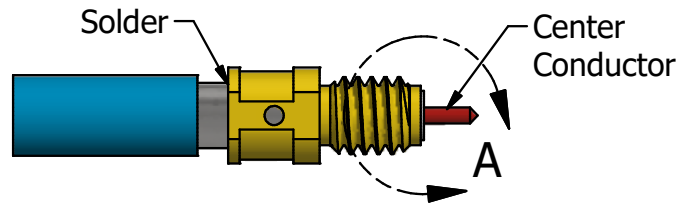


STEP 2

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

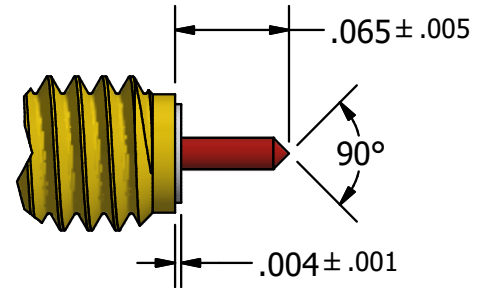
Now Trim:

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



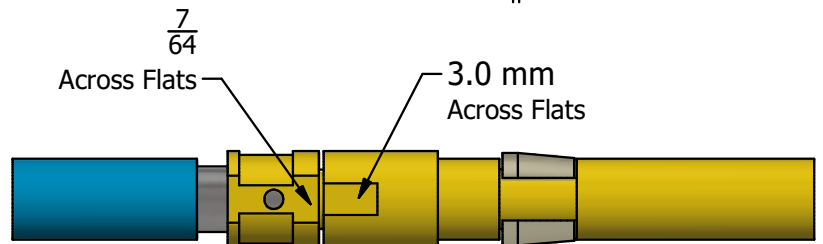
Point the Center Conductor.

DETAIL A



STEP 3

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



CAD DRAWING - NO MANUAL REVISIONS

filename:ver2\Autodesk Inventor Data Base\Assemblies\156 Series\156-1302-0860-CAP.idw

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MATERIAL:

REV.	DESCRIPTION	DATE	APPR.
F	PER ECN 13341	03/27/2020	JEM
E	PER ECN 12373	9/29/2016	RMB
D	PER ECN 12357	9/6/2016	RMB
C	PER ECN 12338	7/15/2016	RMB
B	PER ECN 12283	2/15/2016	RMB
A	REL. PER ECN 12276	1/28/2016	RMB

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

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WWW.PHOENIXOFCHICAGO.COM

TITLE
CABLE ASSEMBLY PROCEDURE FOR 156-1302-0860/J (FLEX / SEMI-RIGID CABLES)

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	156-1302-0860	F	
SCALE	F.S.R. #		SHEET 1 OF 1	

2

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