

STEP 1 (PER CABLE TYPE)

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

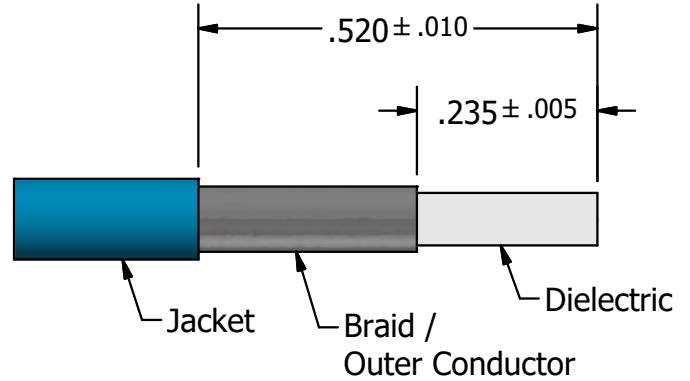
Flux and Tin Dip Cable to dimension $.520 \pm .010$

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

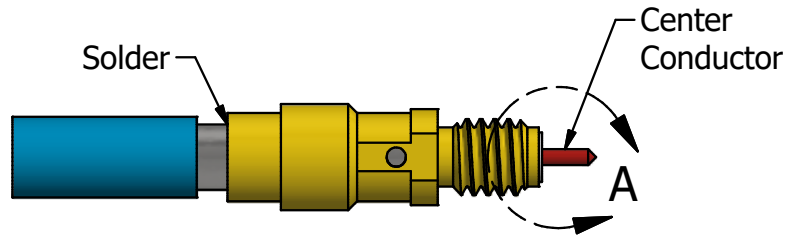
Insert cable into solder nut and solder. Clean solder joint.

Now Trim:

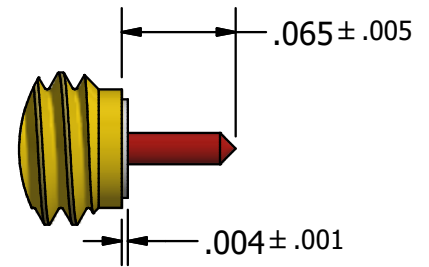
-Dielectric to dimension : $.004 \pm .001$

-Center Conductor Length: $.065 \pm .005$.

Point the Center Conductor.

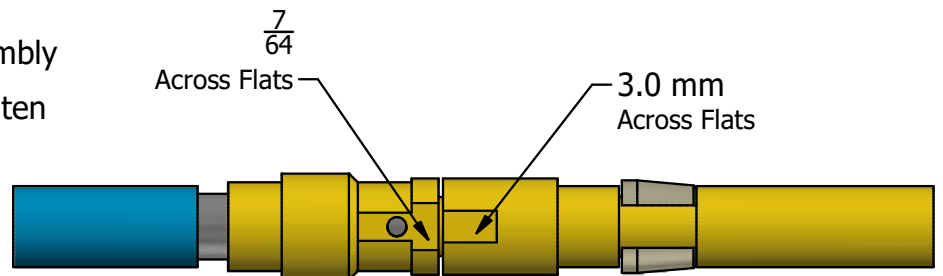


DETAIL A



STEP 3

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



CAD DRAWING - NO MANUAL REVISIONS

filename:ver2\Autodesk Inventor Data Base\Assemblies\156 Series\156-1302-0861-CAP.idw

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MATERIAL:

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: $\pm 1/2^\circ$				APPROVALS		DATE		<i>The PHOENIX Company of Chicago, Inc.</i> 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM			
				DRAWN	SPS	03/27/2020	TITLE CABLE ASSEMBLY PROCEDURE FOR 156-1302-0861				
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				QA			A	58167	156-1302-0861	B	
B	PER ECN 13341	3/30/2020	JEM	ENGINEER	SPS	03/27/2020	SCALE	F.S.R. #	SHEET	1 OF 1	
A	REL. PER ECN 12500	4/12/2017	RMB	APPROVED	JEM	03/27/2020					