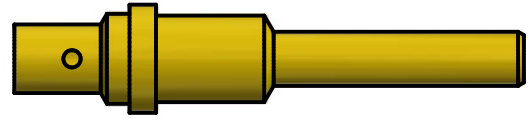
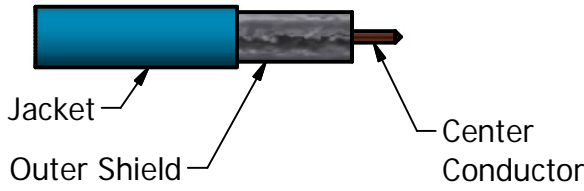


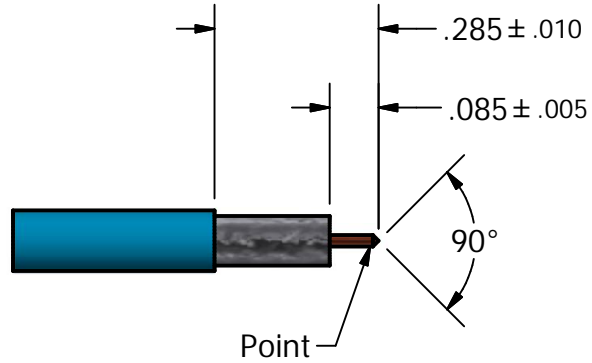
**CABLE**

**PkZ ASSEMBLY**

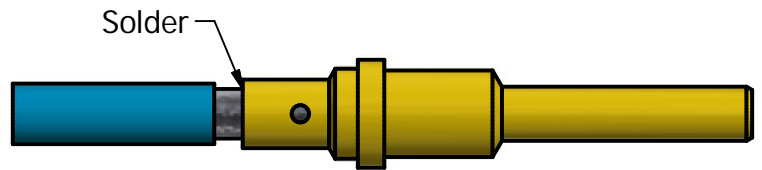


Step 1 (for Flex style cable only)  
Dip end of cable into flux and then tip dip cable to  $.30 \pm .02$  into solder pot for 3 second max.

Step 2  
Trim cable to dimensions shown, ( $.285 \pm .010$  dimension for jacketed cables only). Point center conductor. Check center conductor for straightness.



Step 3  
Install cable into body until cable bottoms in body. Solder body to cable as shown. Clean solder joint.



CAD DRAWING - NO MANUAL REVISIONS  
filename:h-Palco-Phoenix\Palco\_A-B-C\_Sizes\_11-26-2018.idw

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**MATERIAL:**

REV.	DESCRIPTION	DATE	APPR.
G	PER ECN 13349	6/11/2019	JEM
F	PER ECN 13163	10/26/2018	JEM
E	PER ECN 12707	11/21/2017	JEM
D	PER ECN 12668	10/12/2017	SPS
C	PER ECN 12294	3/15/2016	RMB
B	PER ECN 12240	10/28/2015	RMB
A	REL. PER ECN 12197	8/12/2015	RMB

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS (PPF) 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 JEM	08/10/15
CHECKED R.M.B	08/10/15
QA	
MFG	
ENGINEER JEM	08/10/15
APPROVED R.M.B	08/10/15

The **PHOENIX** Company of Chicago <sup>TM</sup>  
22 GREAT HILL RD., NAUGATUCK, CT 06770  
WWW.PHOENIXOFCHICAGO.COM

TITLE  
**CABLE ASSEMBLY PROCESS FOR 168-0020-0860**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	168-0020-0860	G	
SCALE	F.S.R. #	SHEET 1 OF 1		