

ASSEMBLY PROCESS:

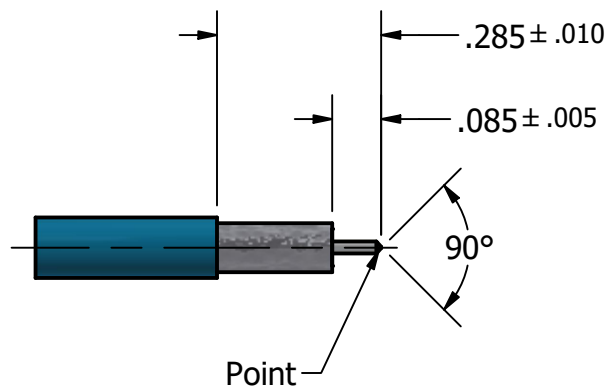
STEP 1

(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.

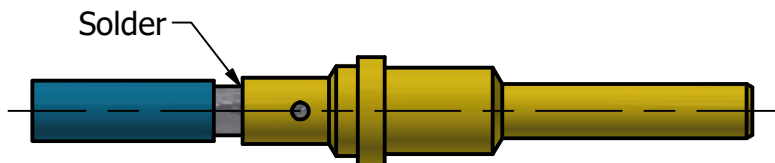
STEP 2

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.



WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

The information and designs disclosed in this document are confidential and/or proprietary to The Phoenix Company of Chicago, Inc. and may not be used for manufacturing, reproduced, disclosed to others, or used for any other purpose without express written consent of The Phoenix Company of Chicago, Inc.

MATERIAL:

				UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]		APPROVALS	DATE
				DO NOT SCALE PRINTS		DRAWN	
				TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ ANGLES: $\pm 1/2^\circ$		JEM	8/10/2015
J	PER ECN 14466	1/13/2025	DW		CHECKED	RMB	8/10/2015
H	PER ECN 14379	4/3/2024	SPS		QA		
G	PER ECN 13349	6/11/2019	JEM		MFG		
F	PER ECN 13163	10/26/2018	JEM		ENGINEER	JEM	8/10/2015
E	PER ECN 12707	11/21/2017	JEM		APPROVED	RMB	8/10/2015
REV.	DESCRIPTION	DATE	APPR.				

The PHOENIX Company of Chicago, Inc.

22 GREAT HILL RD., NAUGATUCK, CT 06770
WWW.PHOENIXOFCHICAGO.COM
PHONE: (800) 323-9562 FAX: (630) 206-1801

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

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	168-0020-0860	J	
SCALE	3:1	F.S.R. #	SHEET 1	OF 1