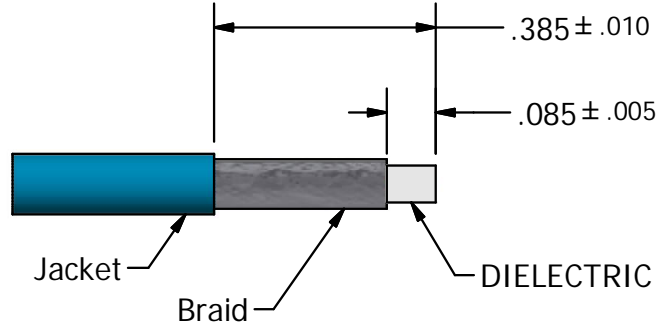
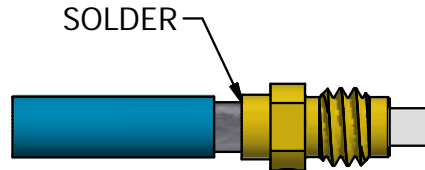


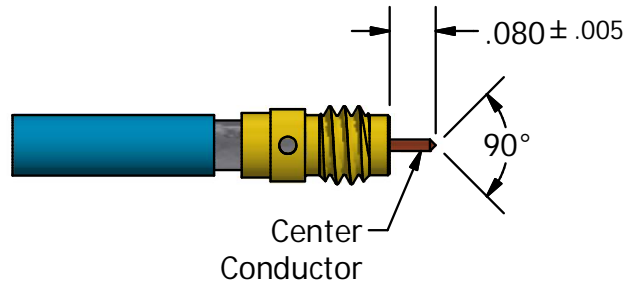
Step 1 (for Flex style cable only)
 Using flux EF-6100 and solder pot with 63/37 solder @ 500°F ±25°F:
 Dip end of cable into flux.
 Tin Dip fluxed end of cable into solder pot to a depth of .385±.010, for a maximum of 3 seconds.



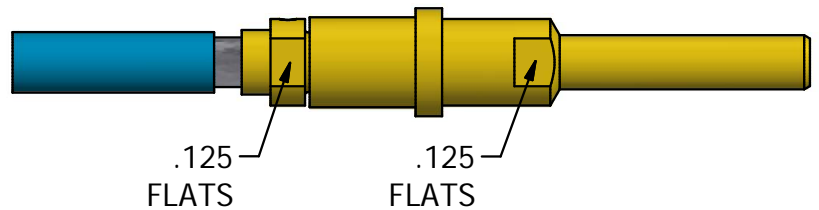
Step 2
 Trim cable to dimensions shown, (.385±.010 dimension for jacketed cables only).



Step 3
 Install cable into solder nut until cable bottoms out. Solder the cable as shown. Clean solder joint.



Step 4
 Trim Dielectric to the face of the solder nut (.003 MAX. extrusion) and point the center conductor maintaining the dimension shown.



Step 5
 Install solder nut onto the body. Torque to 3.0 in-lbs. using two 1/8 torque wrenches.

CAD DRAWING - NO MANUAL REVISIONS
 filename:h-Palco-Phoenix\Palco_A-B-C_Sizes_11-26-2018.idw

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MATERIAL:				APPROVALS		DATE	The PHOENIX Company of Chicago, Inc. 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM				
<small>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS (PPF) DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°</small>				DRAWN	SPS	07/01/2019	TITLE CABLE ASSEMBLY PROCEDURE FOR 168-0030-0860				
				CHECKED	JEM	07/01/2019					
				QA							
				MFG							
<small>THE INFORMATION DISCLOSED IN THIS DOCUMENT IS CONFIDENTIAL AND PROPRIETARY TO PHOENIX CO. INC. AND MAY NOT BE USED FOR MANUFACTURE OR ANY OTHER PURPOSE WITHOUT THE WRITTEN CONSENT OF THE PHOENIX CO. OF CHICAGO INC.</small>				ENGINEER	SPS	07/01/2019	SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	REL. PER ECN 13509	4/7/2020	JEM	APPROVED	JEM	07/01/2019	A	58167	168-0030-0860	A	
01	PRILIMINARY	07/01/2019	JEM				SCALE	F.S.R. #	SHEET 1 OF 1		