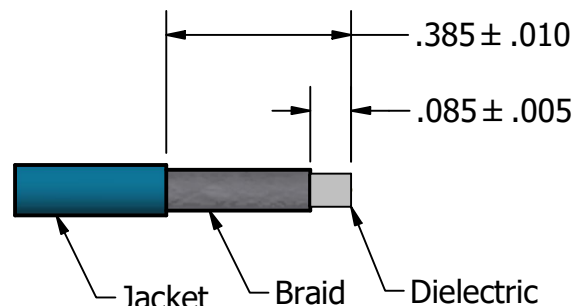
**STEP 1**

(For Flex style cable only)

Dip the end of the cable into flux.

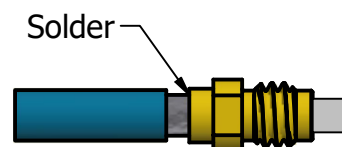
Tin Dip fluxed end of cable into solder pot to a depth of  $.385 \pm .010$ , for a maximum of 3 seconds.

**STEP 2**

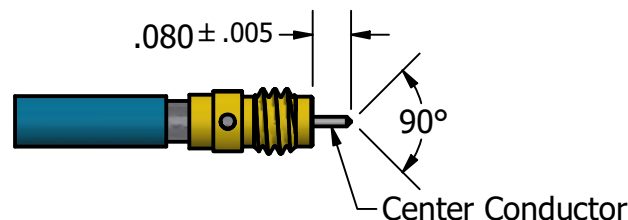
Trim cable to dimensions shown, ( $.385 \pm .010$  dimension for jacketed cables only).

**STEP 3**

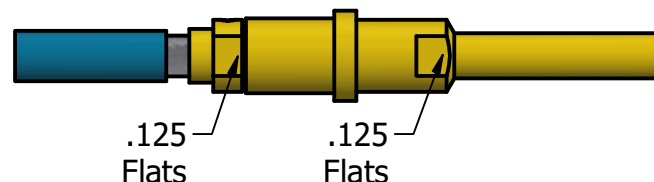
Install cable into solder nut until cable bottoms out. Solder the cable as shown. Clean solder joint.

**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.



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**MATERIAL:**

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]				APPROVALS		DATE	
DO NOT SCALE PRINTS				DRAWN	SPS	7/1/2019	
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ XXX $\pm .003$ ANGLES: $\pm 1/2^\circ$				CHECKED	JEM	7/1/2019	
				QA			
				MFG			
				ENGINEER	SPS	7/1/2019	
				APPROVED	JEM	7/1/2024	
C	PER ECN 14466	11/26/2024	DW				
B	PER ECN 14384	4/8/2024	SPS				
A	REL. PER ECN 13509	4/7/2020	JEM				
01	PRILIMINARY	07/01/2019	JEM				
REV.	DESCRIPTION	DATE	APPR.				

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TITLE  
**CABLE ASSEMBLY PROCEDURE  
FOR 168-0030-0860**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	168-0030-0860	C	
SCALE 2.5:1		F.S.R. #		SHEET 1 OF 1