

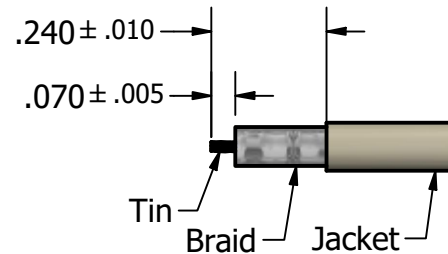
STEP 1

(For Flex style cable only)

Tin Dip the cable end into solder pot to a depth of $.250 \pm .010$, for a maximum of 3 seconds.

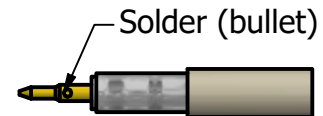
STEP 2

Trim cable to dimensions shown, ($.240 \pm .010$ dimension for jacketed cables only).



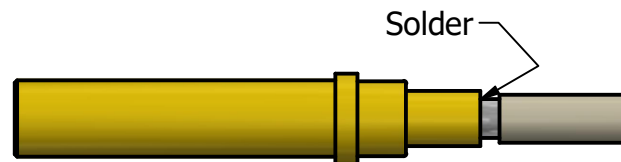
STEP 3

Install Spacer and Bullet onto above cable. Solder bullet to center conductor of cable. Clean solder joint.



STEP 4

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

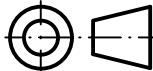


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MATERIAL:

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]				APPROVALS		DATE	
DO NOT SCALE PRINTS				DRAWN	SST	5/3/2019	
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ ANGLES: $\pm 1/2^\circ$				CHECKED	RMB	5/3/2019	
				QA			
				MFG			
				ENGINEER	SST	5/3/2019	
				APPROVED	RMB	5/3/2019	
REV.	DESCRIPTION	DATE	APPR.				
E	PER ECN 14468	1/9/2025	DW				
D	PER ECN 13332	04/09/2020	JEM				
C	PER ECN 13309	5/3/2019	JEM				
B	PER ECN 13163	10/26/2018	JEM				
A	REL. PER ECN 12554	7/11/2017	RMB				



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CABLE ASSEMBLY PROCEDURE FOR 168-1020-0670

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	168-1020-0670	E	
SCALE	2.5:1	F.S.R. #	SHEET 1	OF 1