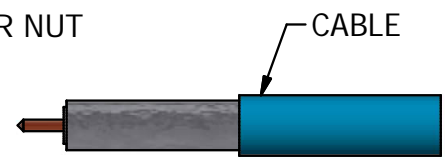
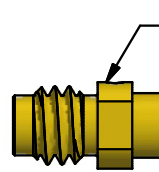
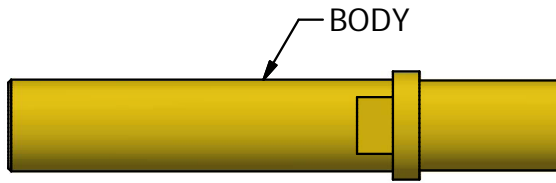
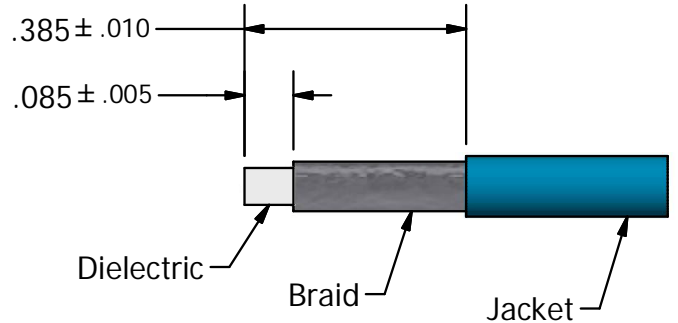


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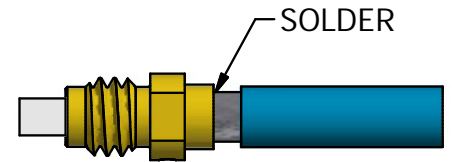
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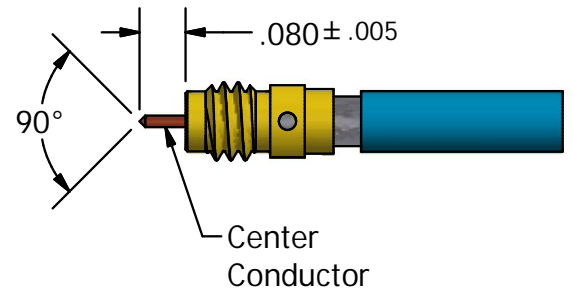
Step 1 (for Flex style cable only)
 Using flux EF-6100 and solder pot with 63/37 solder @ 500°F ±25°F:
 Dip end of cable into flux.
 Tin Dip fluxed end of cable into solder pot to a depth of .385±.010, for a maximum of 3 seconds.



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

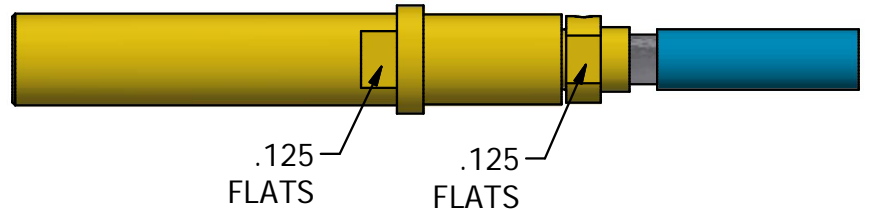


Step 3
 Install cable into solder nut until cable bottoms out. Solder the cable as shown. Clean solder joint.



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 $\frac{1}{8}$ 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:

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°				APPROVALS		DATE		The PHOENIX Company of Chicago, Inc. 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM				
				DRAWN		07/01/2019						
				CHECKED		07/01/2019		TITLE CABLE ASSEMBLY PROCEDURE FOR 168-1030-0860				
				OA								
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				ENGINEER		07/01/2019		A	58167	168-1030-0860	A	
				APPROVED		07/01/2019		SCALE		F.S.R. #		SHEET 1 OF 1

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