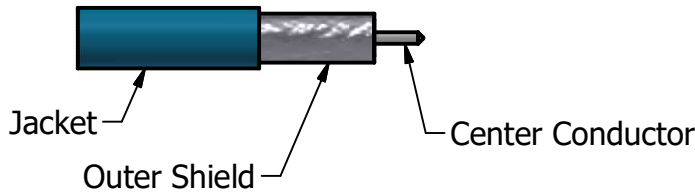
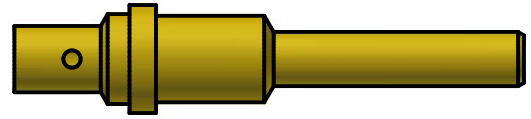


### CABLE

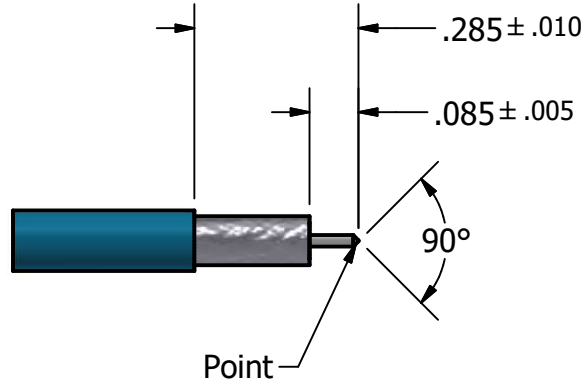


### PKZ ASSEMBLY

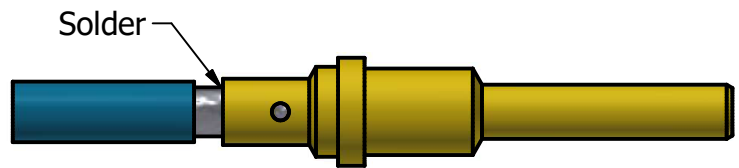


Step 1 (for Flex style cable only)  
Dip end of cable into flux and then tip dip cable to  $.30 \pm .02$  into solder pot for 3 second max.

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.



CAD DRAWING - NO MANUAL REVISIONS  
filename:h-Palco-Phoenix\Palco\_A-B-C\_Sizes\_11-26-2018.idw

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#### MATERIAL:

<small>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC).</small>  <small>DO NOT SCALE PRINTS</small>  <small>TOLERANCES ARE:</small> <small>FRACTIONS: <math>\pm 1/64</math></small> <small>DECIMALS: <math>.XX \pm .01</math></small> <small>          <math>.XXX \pm .003</math></small> <small>ANGLES: <math>\pm 1/2^\circ</math></small>  <small>32</small>  <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>				APPROVALS		DATE	
				DRAWN		RA	4/1/2024
				CHECKED		SPS	4/1/2024
				QA			
MFG							
ENGINEER		JEM	4/1/2024				
APPROVED		SPS	4/1/2024				

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TITLE  
**CABLE ASSEMBLY PROCEDURE  
FOR 168L-0020-0860**

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