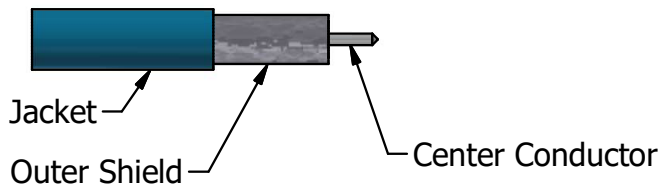
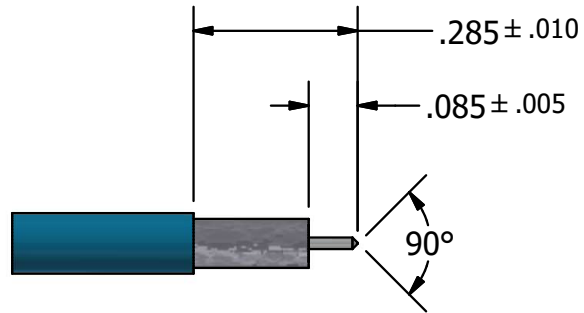


CABLE

PKZ ASSEMBLY

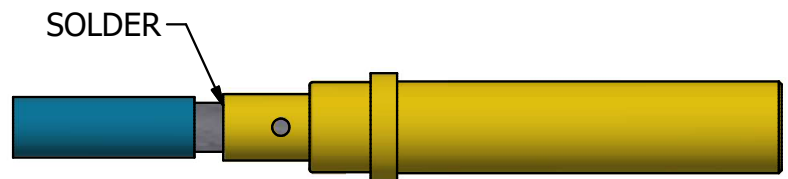


Step 1 (for Flex style cable only)
Dip end of cable into flux and then tip dip cable to $.30 \pm .02$ into solder pot for 3 second max.



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

WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

MATERIAL:				CATALOG ITEM		<i>The PHOENIX Company of Chicago</i> TM 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM							
<small>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR (METRIC)</small> <small>DO NOT SCALE PRINTS</small> <small>TOLERANCES ARE:</small> FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ $.XXX \pm .003$ ANGLES: $\pm 1/2$				APPROVALS		DATE		TITLE CABLE ASSEMBLY PROCEDURE FOR 168L-1020-0860					
				DRAWN		4/2/2024							
				CHECKED		4/1/2024							
				QA									
<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>				MFG				SIZE FSCM DWG NO A 58167 168L-1020-0860					
				ENGINEER		4/1/2024				REV		PLATING OPT.	
				APPROVED		4/1/2024				A			
REV.		DESCRIPTION		DATE		APPR.		SCALE 3 : 1		F.S.R. #		SHEET 1 OF 1	