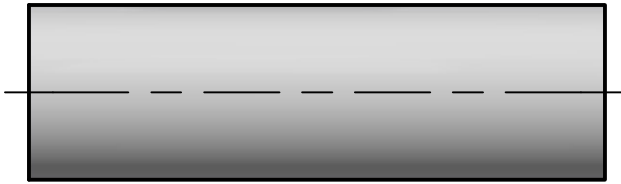
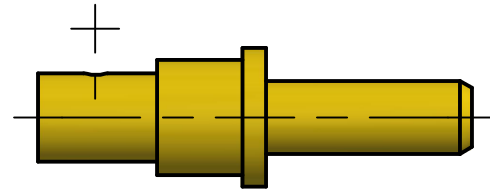


NOTES: DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].



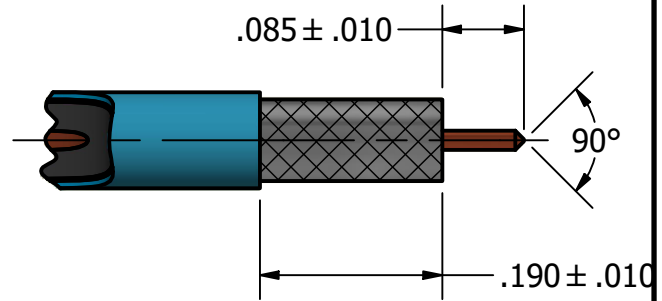
SHRINK TUBING, 3/16



178-0021-0863 ASSEMBLY

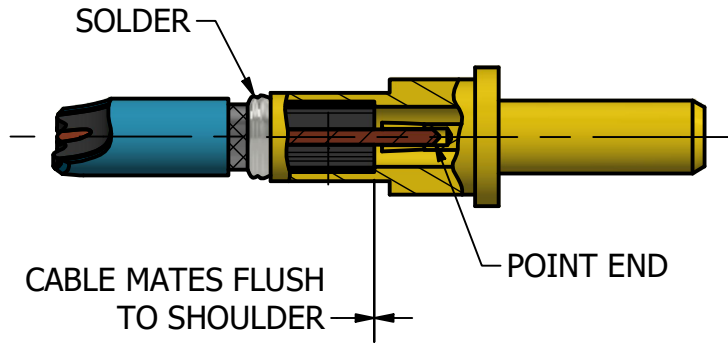
STEP 1

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 0.295", FOR A MAXIMUM OF 3 SECONDS.



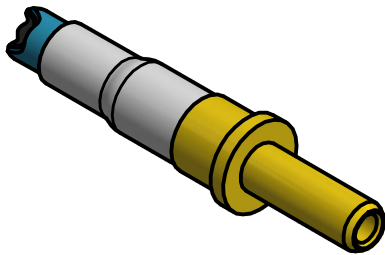
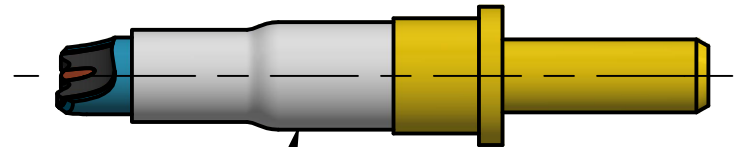
STEP 2

INSERT CABLE IN TO CONNECTOR BODY UNTIL CABLE BOTTOMS. WRAP TWO TURNS OF .020 SOLDER AROUND THE CABLE AT THE BACKSHELL, APPLY HEAT TO THE CONNECTOR BACKSHELL UNTIL THE SOLDER MELTS.



STEP 3

SLIDE SHRINK TUBING INTO POSITION AND APPLY HEAT TO SHRINK TUBING.



CAD DRAWING - NO MANUAL REVISIONS
filename:h:\Palco-Phoenix\Palco_A-B-C_Sizes_11-26-2018.iwd

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MATERIAL:

REV.	DESCRIPTION	DATE	APPR.
H	PER ECN 13684	2/20/20	BGW
G	PER ECN 13292	04/23/19	JEM
F	PER ECN 13167	06/29/18	JEM
E	PER ECN 13103	06/04/18	JEM
D	PER ECN 13022	12/18/17	JEM

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC)

DO NOT SCALE PRINTS

TOLERANCES ARE:
FRACTIONS: ± 1/64
DECIMALS: .XX ± .01
XXX ± .003
ANGLES: ± 1/2'

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APPROVALS	DATE
DRAWN BGW	02/20/20
CHECKED JEM	02/20/20
QA	
MFG	
ENGINEER BGW	02/20/20
APPROVED BGW	02/20/20

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WWW.PHOENIXOFCHICAGO.COM

TITLE
CABLE ASSEMBLY PROCEDURE FOR USE WITH FLEX 405 CABLE

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	178-0021-0863	H	
SCALE	F.S.R. #	SHEET 1 OF 1		