

### STEP 1 (PER CABLE TYPE)

#### \*FOR FLEX CABLES: (Jacketed)

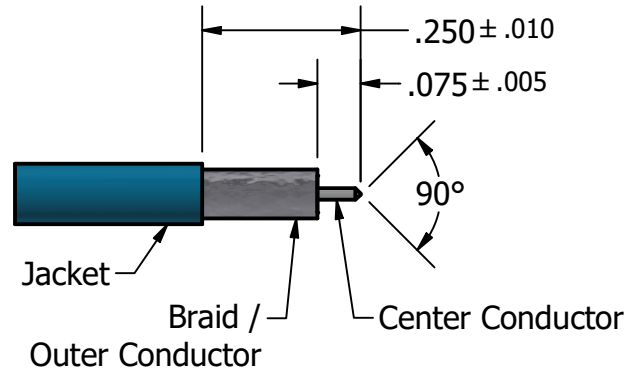
Flux and Tin Dip Cable to dimension:  $.275 \pm .010$

Trim Jacket to dimension:  $.250 \pm .010$

Trim Center Conductor to dimension:  $.075 \pm .005$

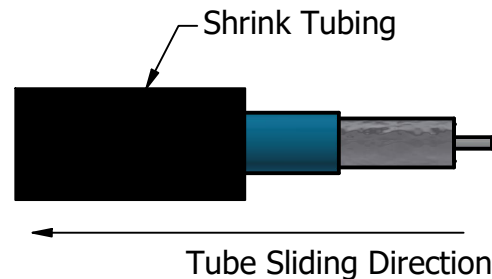
#### \*FOR SEMI RIGID CABLES: (Non-Jacketed)

Trim Center Conductor to dimension:  $.075 \pm .005$



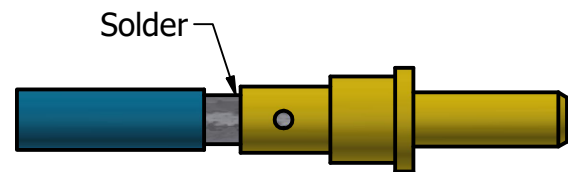
### STEP 2

Load Shrink Tubing on to the cable as shown.



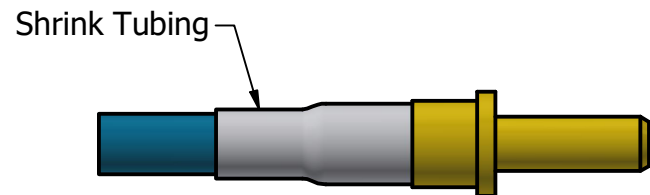
### STEP 3

Insert cable into PkZ® Assembly until cable bottoms and solder as shown.  
Clean solder joint.



### STEP 4

Slide Shrink Tubing into position and heat shrink as shown.



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### MATERIAL:

<div>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]</div> <div>DO NOT SCALE PRINTS</div> <div>TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 <div>.XXX ± .003</div> ANGLES: ± 1/2°</div> <div></div>						APPROVALS		DATE		<div>The PHOENIX Company of Chicago, Inc.</div> <div>22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (800) 323-9562 FAX:(630) 206-1801</div> <div>TITLE</div> <div>CABLE ASSEMBLY PROCEDURE FOR 178-0021-0863</div>											
						DRAWN		SPS						10/31/2022							
						CHECKED		SJG						10/31/2022							
						QA															
J	PER ECN 14330	BAK	10/29/2024	DW	11/27/2024	ENGINEER		SPS		10/31/2022		SIZE	FSCM	DWG NO	REV	PLATING OPT.					
H	PER ECN 13684			SJG	11/1/2022	MFG						A	58167	178-0021-0863	J						
G	PER ECN 13292			JEM	4/22/19	APPROVED		SJG		10/31/2022							SCALE	3 : 1	F.S.R. #	SHEET 1	OF 1
F	PER ECN 13167			JEM	10/26/18																
E	PER ECN 13103			JEM	9/14/18																
REV.	DESCRIPTION	BY	DATE	APPR.	DATE																