

Cable



Ferrule



Bullet



Body

 $.125 \pm .005$  $.055 \pm .005$ **STEP 1**

Trim cable to dimensions shown.
Tin center conductor.

STEP 2

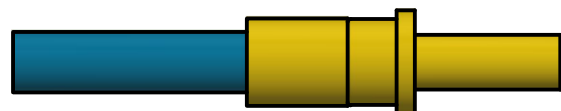
Solder bullet as shown.
Remove excessive solder.

STEP 3

Slide ferrule over cable.
Flare braid by rotating dielectric.

STEP 4

Insert cable into connector body until cable bottoms.
Slide ferrule against the shoulder of body.
Crimp ferrule using a .128 hex die (M22520/5-03).

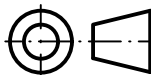


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MATERIAL:

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]						APPROVALS		DATE	
DO NOT SCALE PRINTS						DRAWN	SST	4/22/2019	
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ XXX $\pm .003$ ANGLES: $\pm 1/2^\circ$						CHECKED	JEM	4/22/2019	
						QA			
						MFG			
						ENGINEER	SST	4/22/2019	
						APPROVED	JEM	4/22/2019	
C	PER ECN 14330	BAK	10/25/2024	DW	11/27/2024				
B	PER ECN 13292			JEM	8/14/2019				
A	REL. PER ECN 13097			JEM	09/13/18				
REV.	DESCRIPTION	BY	DATE	APPR.	DATE				



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TITLE

**CABLE ASSEMBLY PROCEDURE
FOR 178-0081-0670**

SIZE

FSCM

A

58167

DWG NO

178-0081-0670

REV

C

PLATING OPT.

SCALE

3:1

F.S.R. #

SHEET

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OF

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