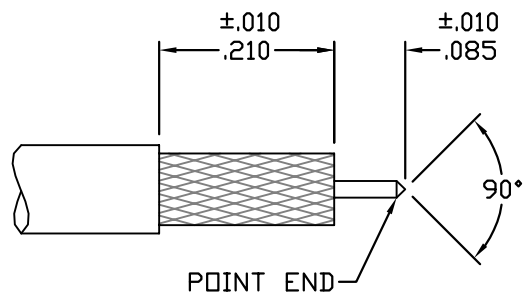
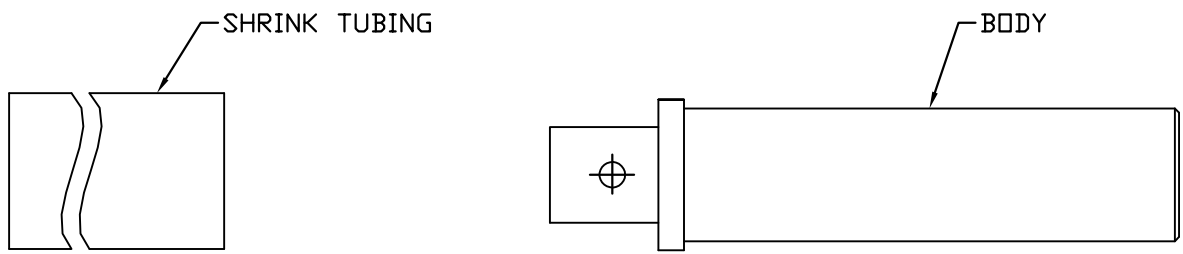


CABLE ASSEMBLY PROCEDURE	
P/N	178-1021-0863
PAGE 1 OF 1	DATE: 10/11/17
DRAWN: JEM	APPROVED: RMB
FOR USE WITH FLEX 405 CABLE	

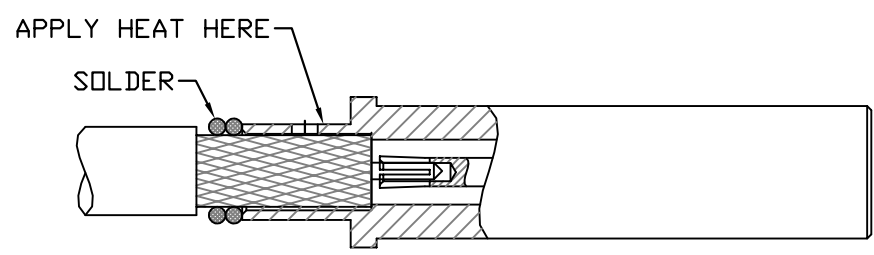
The **PHOENIX** Company of Chicago™
 22 GREAT HILL RD., NAUGATUCK, CT 06770
 WWW.PHOENIXOFCHICAGO.COM

REV	DESCRIPTION	DATE	APPR
B	PER ECN 12745	12/18/17	RMB
C	PER ECN 12972	06/04/18	JEM
D	PER ECN 13022	06/29/18	JEM
E	PER ECN 13292	04/23/19	JEM

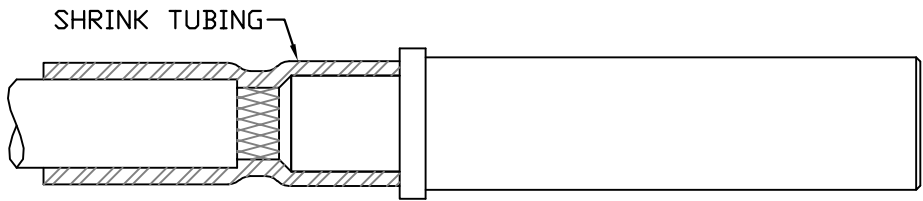
*NOTES:
 1) DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].



STEP 1
 DIP END OF CABLE INTO FLUX AND THEN INTO A SOLDER POT (KESTER 60/40) MAINTAINED AT 500°F TO A DEPTH OF .295 FOR THREE SECOND MAX. SLIDE SHRINK TUBING OVER CABLE. TRIM CABLE TO DIMENSIONS SHOWN, POINT CENTER CONDUCTOR.



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.