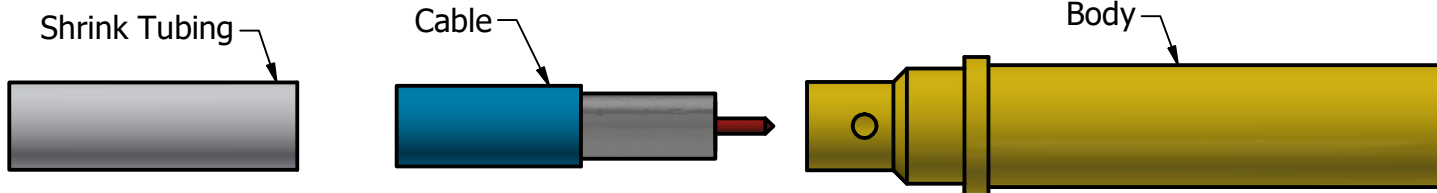


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### STEP 1 (PER CABLE TYPE)

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

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

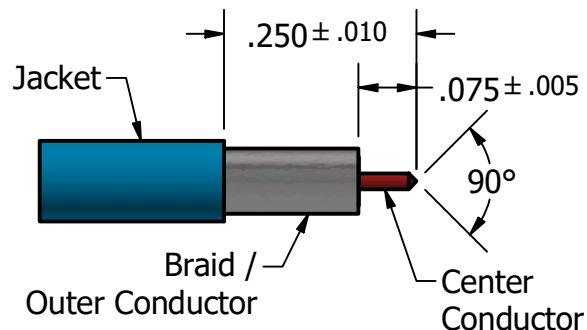
Trim Jacket to dimension -  $.250 \pm .010$

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

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

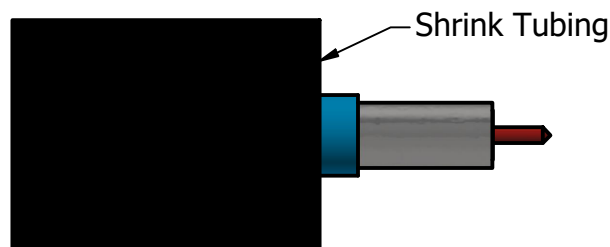
Trim Center Conductor to dimension -  $.075 \pm .005$

Point the Center Conductor.



### STEP 2

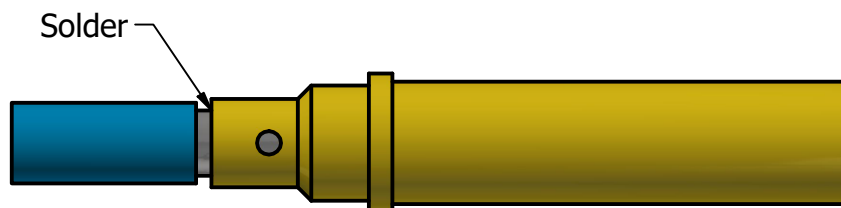
Load Shrink Tubing on to the cable as shown.



Tube Sliding Direction

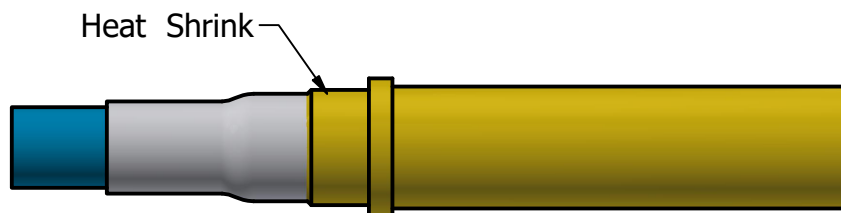
### STEP 3

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



### STEP 4

Bring Tubing back into position and heat shrink as shown.





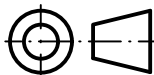
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### MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
G	PER ECN 14431	JEM	6/19/2024	DW	11/26/2024
F	PER ECN 13715	SPS	11/14/2022	SJG	11/14/2022
E	PER ECN 13292	SST	4/23/2019	JEM	4/23/2019
D	PER ECN 13022	JEM	6/29/2018	JEM	6/29/2018
C	PER ECN 12972	JEM	6/8/2018	JEM	6/8/2018
B	PER ECN 12745	JEM	12/18/2017	RMB	12/18/2017
A	REL. PER ECN 12662	JEM	10/11/2017	RMB	10/11/2017

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]			
DO NOT SCALE PRINTS			
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ XXX $\pm .003$ ANGLES: $\pm 1/2^\circ$			
			



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### CABLE ASSEMBLY PROCEDURE FOR 178-1021-0863

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	178-1021-0863	G	
SCALE	4:1	F.S.R. #	SHEET	1 OF 1

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