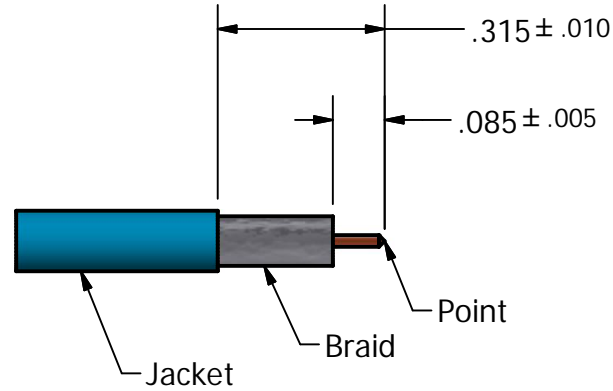
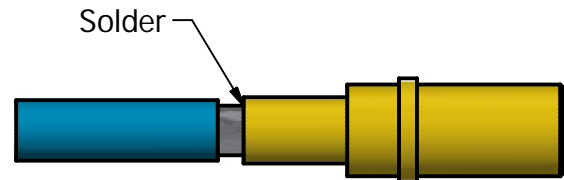


Step 1 (for flex style cable only)
 Flux EF6100 end of cable then tin dip
 into 500° ± 25°F solder pot 63/37
 for three seconds maximum.

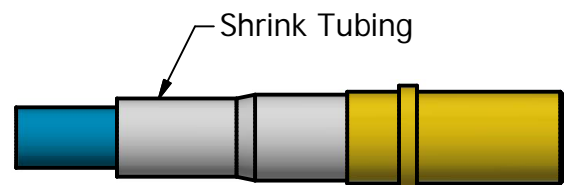


Step 2
 Trim cable to dimensions shown.
 Point center conductor.
 (.315 dimension for jacketed
 cables only.)

Step 3
 Insert cable into body until cable
 bottoms. Solder 63/37 body to cable
 braid. Clean solder joint.



Step 4
 Slide Shrink Tubing into position and
 apply heat.



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

WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

MATERIAL:				UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS (PPF) DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°		APPROVALS DATE DRAWN SPS 07/10/2019 CHECKED JEM 07/10/2019 QA MFG ENGINEER SPS 07/10/2019 APPROVED JEM 07/10/2019		The PHOENIX Company of Chicago, Inc. 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM TITLE CABLE ASSEMBLY PROCEDURE FOR 178-1023-0863			
A	REL. PER ECN 13396	07/10/2019	JEM	SIZE	FSCM	DWG NO	REV	PLATING OPT.			
REV.	DESCRIPTION	DATE	APPR.	A	58167	178-1023-0863-CAP	A				
				SCALE	F.S.R. #		SHEET 1 OF 1				