

STEP 1 (Per cable type)

*FOR FLEX CABLES: (Jacketed)

Flux and Tin Dip Cable to dimension: $.300 \pm .010$

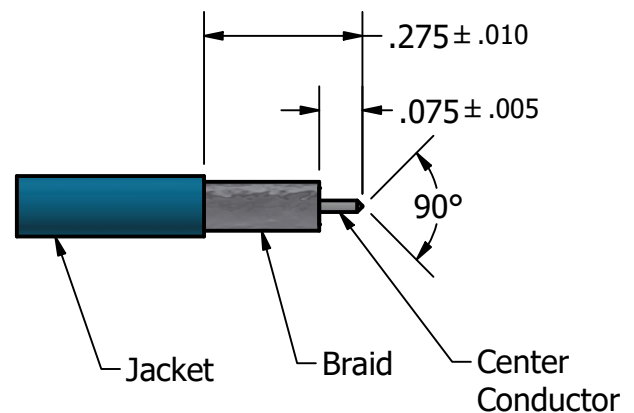
Trim Jacket to dimension: $.275 \pm .010$

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

*FOR SEMI RIGID CABLES: (Non-Jacketed)

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

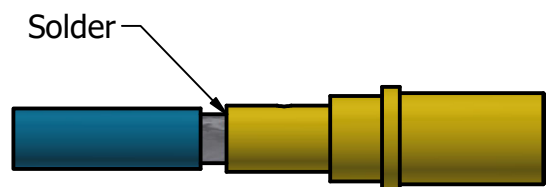
Point the Center Conductor.



STEP 2

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

Clean solder joint.



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MATERIAL:

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: $\pm 1/2^\circ$						APPROVALS		DATE		The PHOENIX Company of Chicago, Inc. 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (800) 323-9562 FAX: (630) 206-1801 TITLE CABLE ASSEMBLY PROCEDURE FOR 178-1023-0863			
						DRAWN		7/10/2019					
						CHECKED		7/10/2019					
						QA							
						MFG				SIZE FSCM DWG NO A 58167 178-1023-0863 REV B PLATING OPT. SCALE 3 : 1 F.S.R. # SHEET 1 OF 1			
						ENGINEER		7/10/2019					
						APPROVED		7/10/2019					
						SPS							
B	PER ECN 14332	RA	10/29/2024	DW	12/19/2024								
A	REL. PER ECN 13396			JEM	07/10/2019								
REV.	DESCRIPTION	BY	DATE	APPR.	DATE								