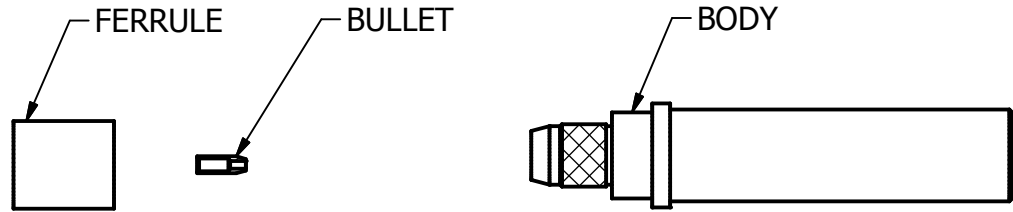


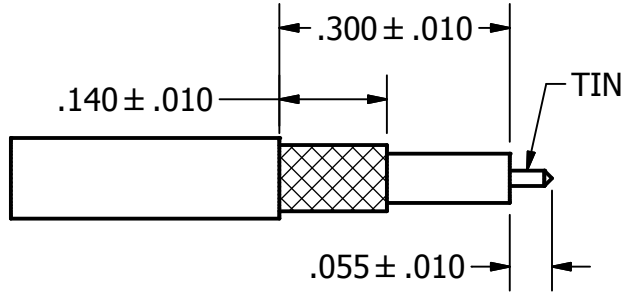
2

1



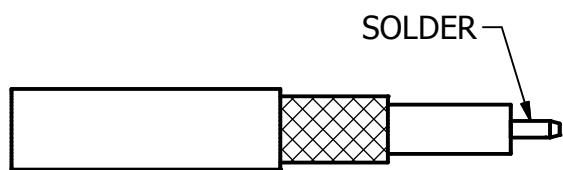
**STEP 1**

TRIM CABLE TO DIMENSIONS SHOWN.  
TIN CENTER CONDUCTOR.



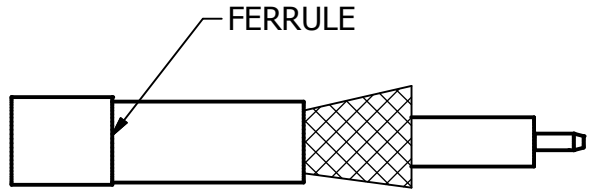
**STEP 2**

SOLDER BULLET AS SHOWN.  
REMOVE EXCESSIVE SOLDER.



**STEP 3**

SLIDE FERRULE OVER CABLE.  
FLARE BRAID BY ROTATING DIELECTRIC.



**STEP 4**

INSERT THE CABLE INTO REAR OF BODY UNTIL CABLE  
BOTTOMS. SLIDE FERRULE AGAINST THE SHOULDER OF  
BODY. CRIMP FERRULE USING A .128 HEX DIE  
(M22520/5-03).



CAD DRAWING - NO MANUAL REVISIONS  
filename:\Autodesk Inventor Data Base\Assemblies\178 Series\178-1081-0670-CAP.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:**

D	PER ECN 13292	4/23/2019	JEM
C	REDESIGN PER ECN 13097	9/13/2018	JEM
B	PER ECN 13085	9/7/2018	JS
A	REL. PER ECN 13051	07/27/18	JEM
REV.	DESCRIPTION	DATE	APPR.

UNLESS OTHERWISE SPECIFIED,  
PHOENIX WORKMANSHIP STANDARDS APPLY.  
DIMENSIONS IN INCHES OR (METRIC)

DO NOT SCALE PRINTS

TOLERANCES ARE:  
FRACTIONS: ± 1/64  
DECIMALS: .XX ± .01  
.XXX ± .003  
ANGLES: ± 1/2°

32

THE INFORMATION DISCLOSED IN  
THIS DOCUMENT IS CONFIDENTIAL  
AND PROPRIETARY TO  
PHOENIX CO. INC.  
AND MAY NOT BE USED FOR  
MANUFACTURE OR ANY OTHER  
PURPOSE WITHOUT THE WRITTEN  
CONSENT OF THE PHOENIX CO. OF  
CHICAGO INC.

APPROVALS	DATE
DRAWN SST	04/23/19
CHECKED JEM	04/23/19
QA	
MFG	
ENGINEER SST	04/23/19
APPROVED JEM	04/23/19

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

TITLE  
**CABLE ASSEMBLY  
 PROCEDURE**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	178-1081-0670	D	A
SCALE	F.S.R. #	SHEET	1 OF 1	

2

1