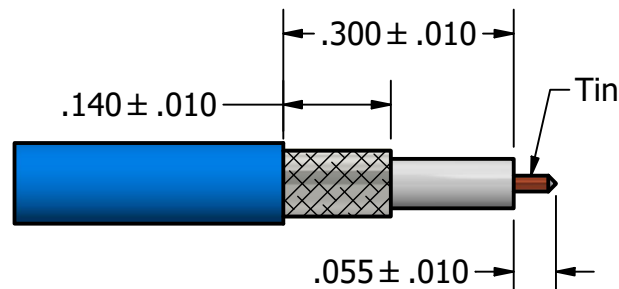
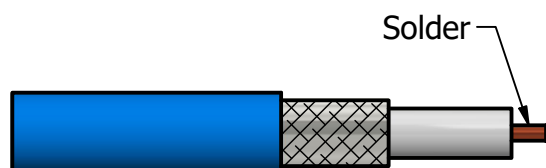
**STEP 1**

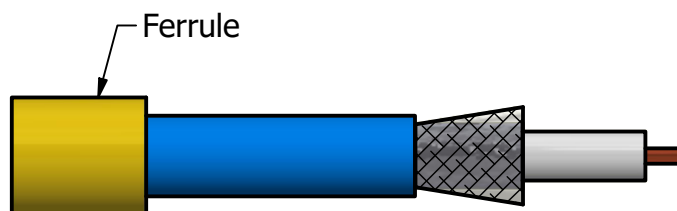
Trim cable to dimensions shown.
Tin center conductor.

**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).

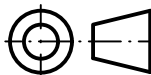


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MATERIAL:

				UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]		APPROVALS	DATE
				DO NOT SCALE PRINTS		DRAWN	
				TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ XXX $\pm .003$ ANGLES: $\pm 1/2^\circ$		SST	4/23/2019
						CHECKED	
						JEM	4/23/2019
						QA	
						MFG	
						ENGINEER	
						SST	4/23/2019
						APPROVED	
						JEM	4/23/2019
REV.	DESCRIPTION	DATE	APPR.				
E	PER ECN 14330	11/27/2024	DW				
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				

**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 178-1081-0670**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	178-1081-0670	E	
SCALE	4:1	F.S.R. #	SHEET 1	OF 1