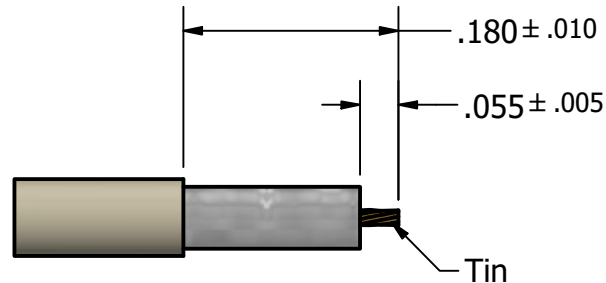
**STEP 1**

Trim cable to dimensions shown.
Tin Center Conductor.

**STEP 2**

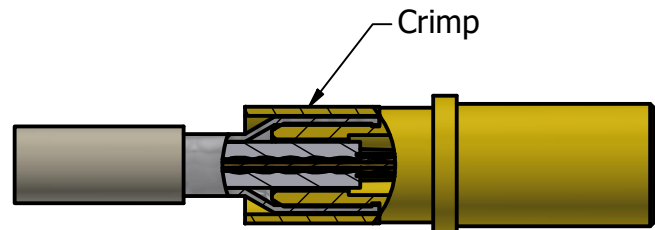
Solder bullet as shown.
Clean excess solder.

**STEP 3**

Slide Ferrule over cable.
Flare Braid by rotating dielectric.

**STEP 4**

Insert the cable into connector until cable bottoms. Slide ferrule against the shoulder of the body. Crimp Ferrule using a .128 HEX DIE (M22520/5-03)

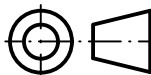


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MATERIAL:

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]				APPROVALS		DATE	
DO NOT SCALE PRINTS				DRAWN	SPS	7/10/2019	
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ $.XXX \pm .003$ ANGLES: $\pm 1/2^\circ$				CHECKED	JEM	7/10/2019	
				QA			
				MFG			
				ENGINEER	SPS	7/10/2019	
				APPROVED	JEM	7/10/2019	

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TITLE
**CABLE ASSEMBLY PROCEDURE
FOR 178-1083-0670**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	178-1083-0670	B	
SCALE	3:1	F.S.R. #	SHEET	1 OF 1