

Step 1 (PER CABLE TYPE)

***FOR FLEX CABLES: (Jacketed)**

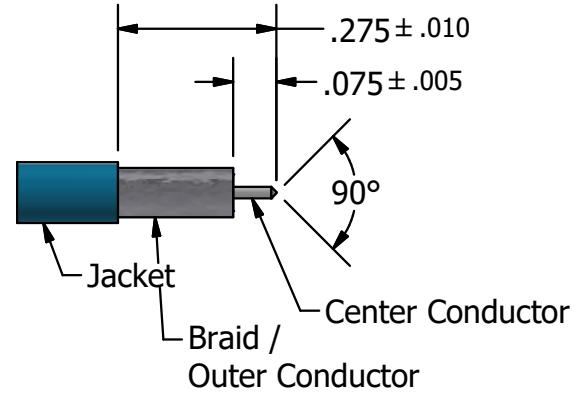
Flux and Tin Dip Cable to dimension: $.300 \pm .010$

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

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

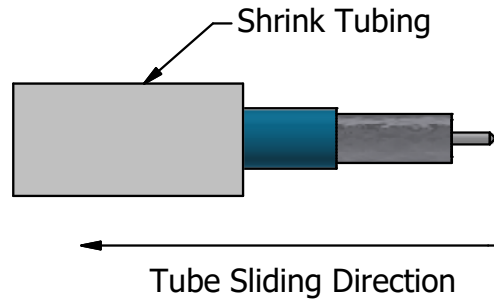
***FOR SEMI RIGID CABLES: (Non-Jacketed)**

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



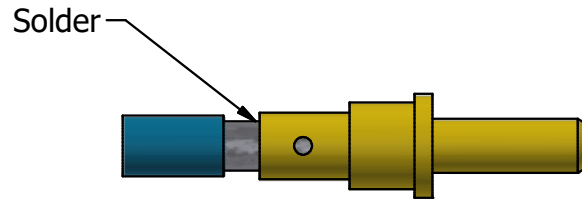
Step 2

Load Shrink Tubing on to the cable as shown.



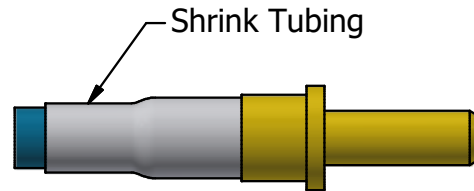
Step 3

Insert cable into PkZ® assembly until cable bottoms and solder as shown. Clean solder joint.



Step 4

Slide Shrink Tubing into position and heat shrink as shown.



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MATERIAL:

<small>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°</small>				APPROVALS		DATE		<i>The PHOENIX Company of Chicago, Inc.</i> 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM TITLE CABLE ASSEMBLY PROCEDURE FOR 178L-0021-0863											
				DRAWN		RA						4/12/2024							
				CHECKED		SPS						4/12/2024							
				<small>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.</small>				QA				SIZE		FSCM		DWG NO		REV	
MFG										A		58167		178L-0021-0863		A			
ENGINEER		SPS						4/12/2024		SCALE				F.S.R. #		SHEET 1 OF 1			
APPROVED		SPS		4/12/2024															