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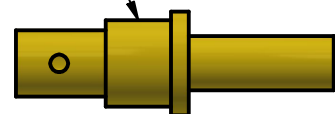
Shrink Tubing



Cable



Body



## STEP 1 (PER CABLE TYPE)

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

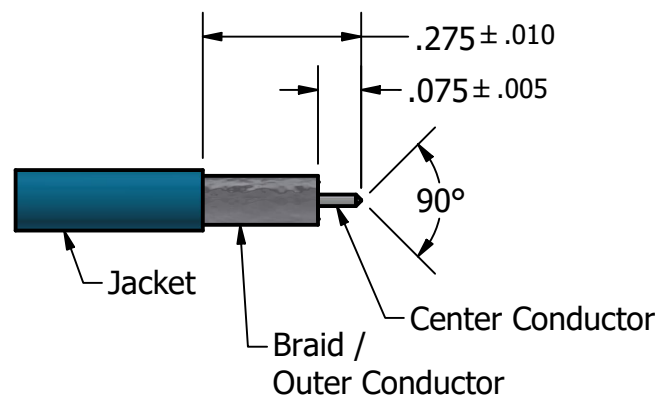
Flux and Tin Dip Cable to dimension:  $.300 \pm .010$

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

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

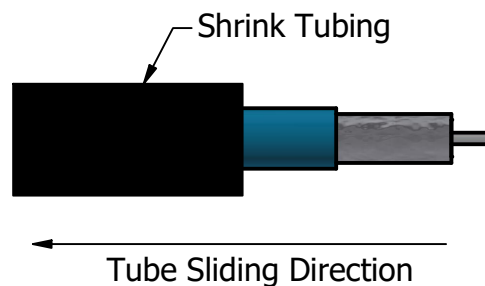
### \*FOR SEMI RIGID CABLES: (Non-Jacketed)

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



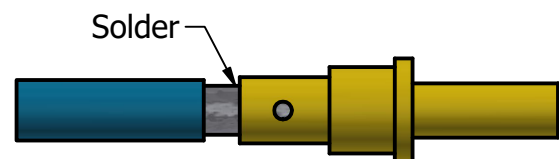
## STEP 2

Load Shrink Tubing on to the cable as shown.



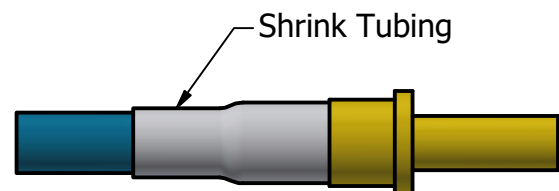
## STEP 3

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.



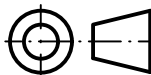
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## MATERIAL:

| B    | PER ECN 14331      | RA | 10/25/2024 | DW    | 11/27/2024 |
|------|--------------------|----|------------|-------|------------|
| A    | REL. PER ECN 14391 |    |            | SPS   | 4/18/2024  |
| REV. | DESCRIPTION        | BY | DATE       | APPR. | DATE       |

|   |              |           |
|---|--------------|-----------|
| UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY<br>DIMENSIONS IN INCHES OR (METRIC)               | APPROVALS    | DATE      |
| DO NOT SCALE PRINTS   | DRAWN RA     | 4/11/2024 |
| TOLERANCES ARE:<br>FRACTIONS: $\pm 1/64$<br>DECIMALS: $.XX \pm .01$<br>.XXX $\pm .003$<br>ANGLES: $\pm 1/2^\circ$ | CHECKED SPS  | 4/11/2024 |
|   | QA           |           |
|   | MFG          |           |
|   | ENGINEER SPS | 4/11/2024 |
|   | APPROVED SPS | 4/12/2024 |



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TITLE  
**CABLE ASSEMBLY PROCEDURE  
FOR 178L-0021-0863**

|       |       |                |       |              |
|-------|-------|----------------|-------|--------------|
| SIZE  | FSCM  | DWG NO         | REV   | PLATING OPT. |
| A     | 58167 | 178L-0021-0863 | B     |              |
| SCALE | 3 : 1 | F.S.R. #       | SHEET | 1 OF 1       |

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