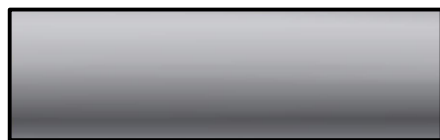


2

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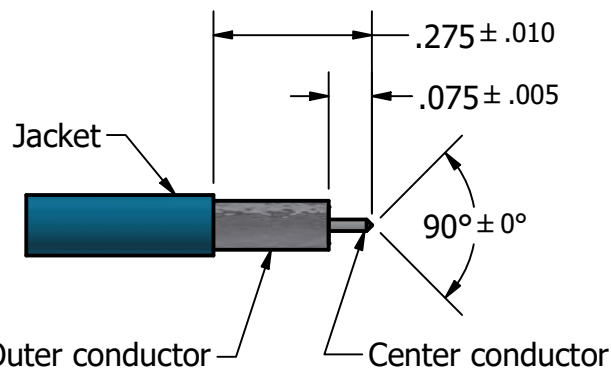
Shrink tubing



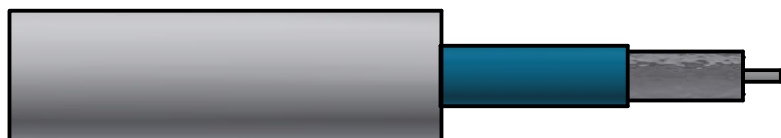
Cable



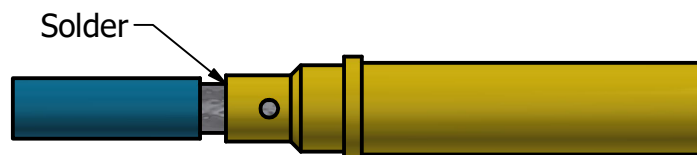
Body

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.



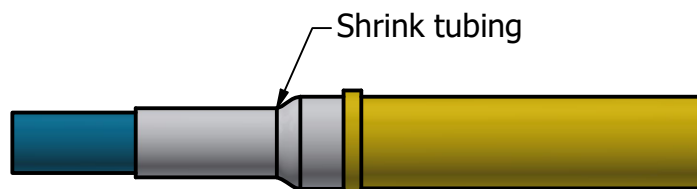
Tube Sliding Direction

STEP 3Insert cable into PkZ® Assembly until cable bottoms and solder as shown.
Clean solder joint.

Solder

STEP 4

Slide Shrink Tubing into position and heat shrink as shown.



Shrink tubing

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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 DIMENSIONS IN INCHES OR [METRIC]
DO NOT SCALE PRINTS
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ $.XXX \pm .003$ ANGLES: $\pm 1/2^\circ$

APPROVALS	DATE
DRAWN RA	4/11/2024
CHECKED SPS	4/11/2024
QA	
MFG	
ENGINEER SPS	4/11/2024
APPROVED SPS	4/11/2024

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WWW.PHOENIXOFCHICAGO.COM					
PHONE: (800) 323-9562 FAX: (630) 206-1801					
TITLE CABLE ASSEMBLY PROCEDURE FOR 178L-1021-0863					
SIZE A	FSCM 58167	DWG NO 178L-1021-0863	REV B	PLATING OPT.	
SCALE 3 : 1	F.S.R. #	SHEET 1 OF 1			

2

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