

### STEP 1 (PER CABLE TYPE)

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

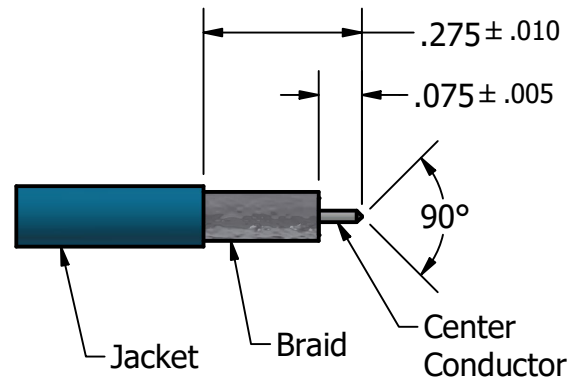
Flux and Tin Dip Cable to dimension:  $.300 \pm .010$

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:  $.075 \pm .005$

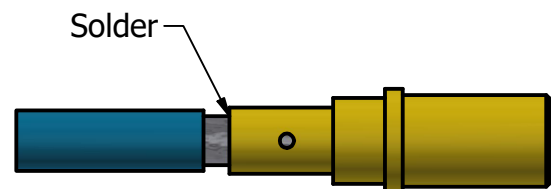


Point the Center Conductor.

### STEP 2

Insert cable into PkZ® Assembly until cable bottoms and solder as shown.


Clean solder joint.



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### MATERIAL:

<div>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]</div> <div>DO NOT SCALE PRINTS</div> <div>TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°</div> <div></div>						APPROVALS		DATE		<div>The PHOENIX Company of Chicago, Inc.</div> <div>22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (800) 323-9562 FAX: (630) 206-1801</div> <div>TITLE</div> <div>CABLE ASSEMBLY PROCEDURE FOR 178L-1023-0863</div>								
						DRAWN		RA						4/12/2024				
						CHECKED		SPS						4/12/2024				
						QA												
						MFG												
						ENGINEER		SPS						4/12/2024				
APPROVED		SPS		4/12/2024		SIZE	FSCM	DWG NO		REV	PLATING OPT.							
A		58167		178L-1023-0863		B												
REV.		DESCRIPTION		BY		DATE		APPR.		DATE		SCALE	3 : 1		F.S.R. #		SHEET 1 OF 1	