

**STEP 1 (PER CABLE TYPE)**

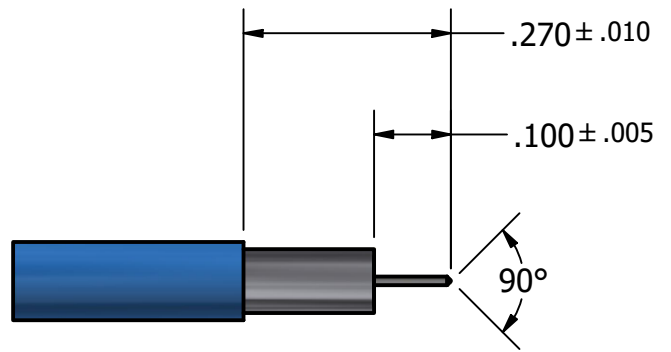
**\*FOR FLEX CABLES: (Jacketed)**

- Flux and Tin Dip Cable to dimension -  $.300 \pm .010$
- Trim Jacket to dimension -  $.270 \pm .010$
- Trim for Center Conductor to dimension -  $.100 \pm .005$

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

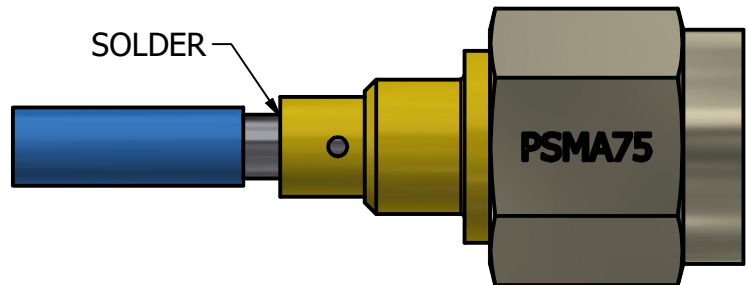
- Trim for Center Conductor to dimension -  $.100 \pm .005$

Point the Center Conductor.



**STEP 2**

Insert Cable into Body until the cable bottoms and then solder.  
Clean solder joint.



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**MATERIAL:**

B	PER ECN 14619	SPS	5/21/2026	SJG	5/22/2026
A	REL. PER ECN 14382	SPS	4/4/2024	SJG	4/4/2024
01	PRELIMINARY	SPS	07/25/2023	SPS	07/25/2023
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

DRAWN	SPS	07/25/2023
CHECKED	SJG	04/04/2024
QA		
MFG		
ENGINEER	SPS	07/25/2023
APPROVED	SJG	04/04/2024

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TITLE  
**CABLE ASSEMBLY PROCEDURE FOR 19-0200-0860**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	19-0200-0860	B	
SCALE	4 : 1		F.S.R. #	SHEET 1 OF 1