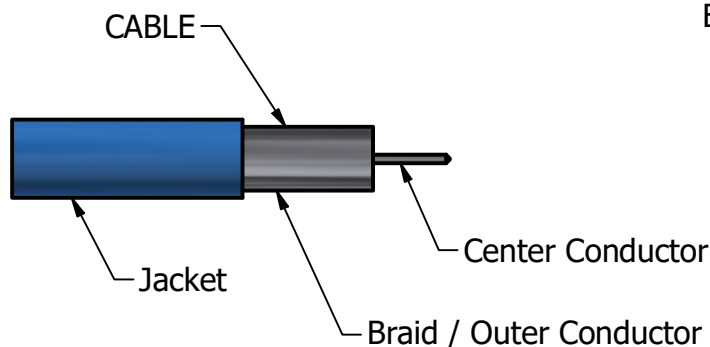


STEP 1 (PER CABLE TYPE)

*FOR FLEX CABLES: (Jacketed)

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

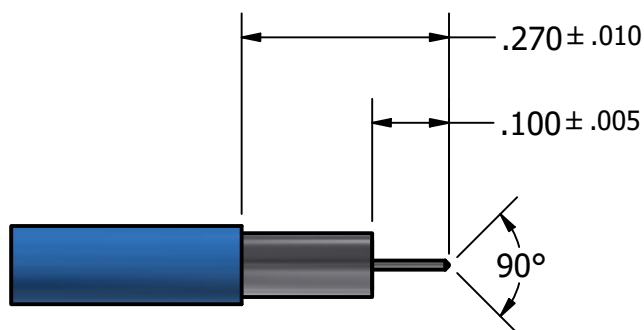
Trim Jacket to dimension - $.270 \pm .010$

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

*FOR SEMI RIGID CABLES: (Non-Jacketed)

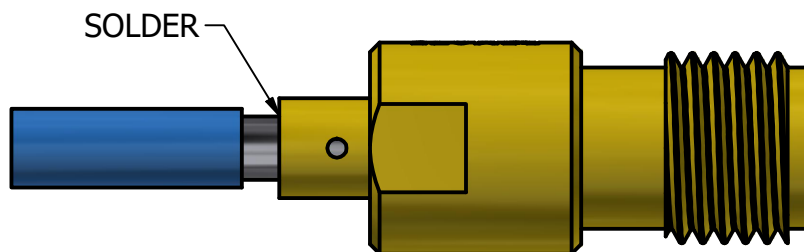
Trim for Center Conductor to dimension - $.100 \pm .005$

Point the Center Conductor.



STEP 2

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

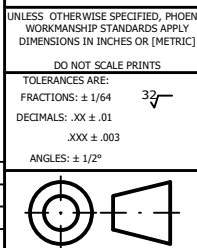


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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
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



APPROVALS	DATE
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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CABLE ASSEMBLY PROCEDURE FOR 19-1200-0860

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	19-1200-0860	B	
SCALE	4 : 1	F.S.R. #	SHEET	1 OF 1