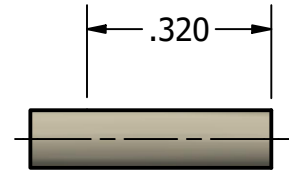
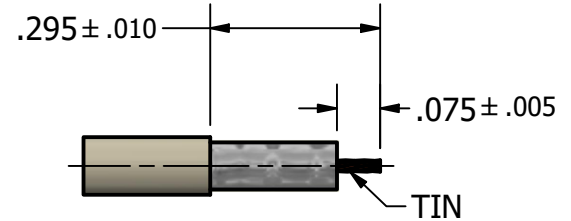


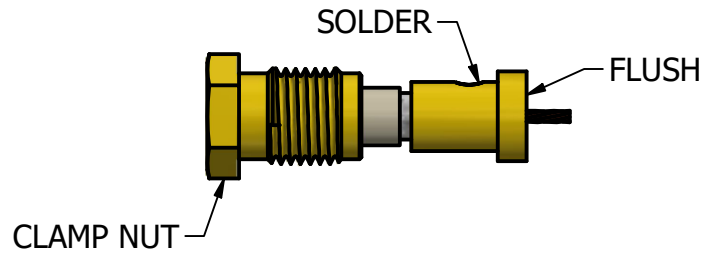
Step 1
Flux and tin dip the cable, to dimension shown.



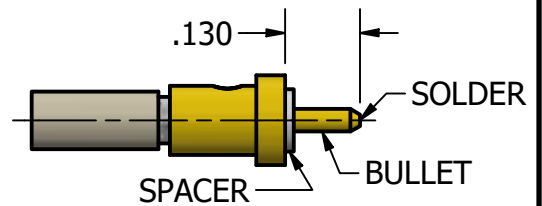
Step 2
Trim cable to the dimensions shown.



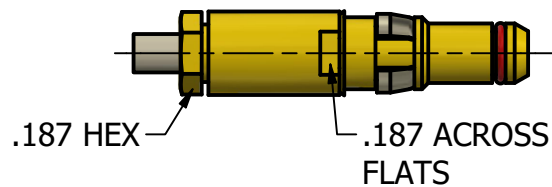
Step 3
Slide clamp nut and solder ferrule onto cable (slightly twisting). Set front shoulder of solder ferrule flush with cable and solder. Clean solder joint.



Step 4
Slide spacer and bullet over center conductor of cable. Solder bullet to cable. Clean solder joint



Step 5
Insert cable assembly into body and tighten clamp nut to 90-100 in-ozs



CAD DRAWING - NO MANUAL REVISIONS
filename:h:\Palco-Phoenix\Palco_A-B-C_Sizes_11-26-2018.rdw

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MATERIAL:

REV.	DESCRIPTION	DATE	APPR.
G	PER ECN 13838	9/15/2020	SS
F	PER ECN 11007	06/24/11	JEM
E	PER ECN 10789	12/13/10	JEM
D	PER ECN 10298	04/21/10	JEM
C	PER ECN 9524	09/22/08	JEM
B	PER ECN 7570	08/06/04	JEM

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC).
DO NOT SCALE PRINTS
TOLERANCES ARE:
FRACTIONS: ± 1/64
DECIMALS: .XX ± .01
XXX ± .003
ANGLES: ± 1/2°

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APPROVALS		DATE
DRAWN	EK	04/30/97
CHECKED	JEM	04/30/97
QA		
MFG		
ENGINEER	EY	04/30/97
APPROVED	JEM	04/30/97

The **PHOENIX** Company of Chicago, Inc.
22 GREAT HILL RD., NAUGATUCK, CT 06770
WWW.PHOENIXOFCHICAGO.COM

TITLE
CABLE ASSEMBLY PROCEDURE FOR PKZ, PLUG SOLDER/CLAMP

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	26-003X-2670	G	
SCALE	F.S.R. #	SHEET 1 OF 1		