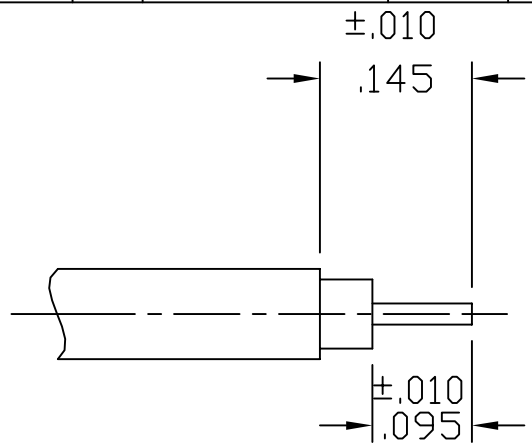


| | |
|----------------------------|----------------|
| CABLE ASSEMBLY PROCEDURE | |
| P/N | 26-1520-0860 |
| PAGE 1 OF 2 | DATE: 06/14/99 |
| DRAWN: MY | APPROVED: HN |
| FOR USE RG-405/U S/R CABLE | |

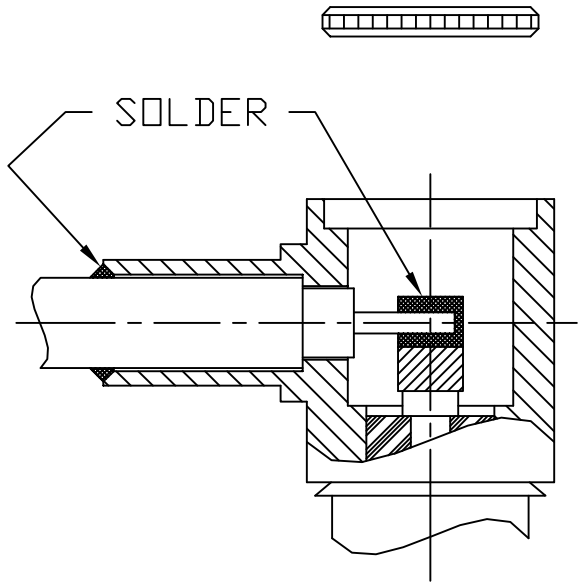
The **PHOENIX** Company of Chicago™
 22 GREAT HILL RD., NAUGATUCK, CT 06770
 WWW.PHOENIXOFCHICAGO.COM
 PHONE: (203) 729-9090 FAX: (203) 723-1794

| REV | DESCRIPTION | DATE | APPR |
|-----|---------------|----------|------|
| K | PER ECN 9410 | 05/28/08 | HN |
| L | PER ECN 10285 | 04/14/10 | JEM |
| M | PER ECN 11159 | 10/20/11 | JEM |
| N | PER ECN 16319 | 12/17/19 | JEM |

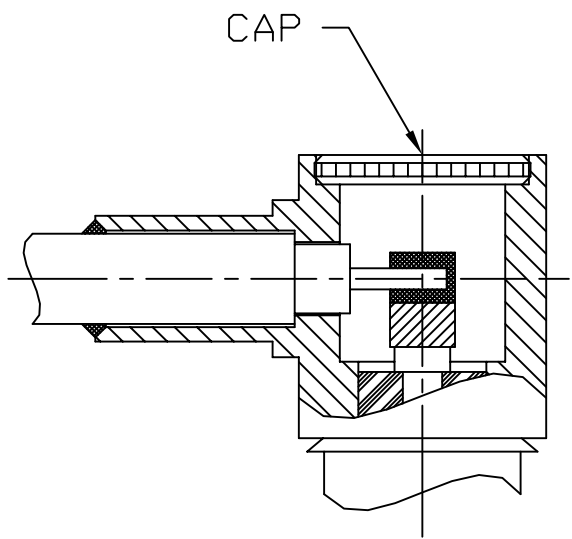
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN CENTER CONDUCTOR.



STEP 2
 INSERT CABLE INTO BODY UNTIL
 CABLE BOTTOMS IN BODY. SOLDER
 CABLE JACKET INTO BODY, THEN
 SOLDER CENTER CONDUCTOR TO
 CENTER CONTACT OF CONNECTOR.



STEP 3
 CLEAN AND INSPECT THE SOLDER
 JOINTS. FIXTURE BODY INTO A
 SMALL ARBOR PRESS, BEING CAREFUL
 NOT TO DAMAGE CONNECTOR AND
 PRESS CAP INTO BODY.

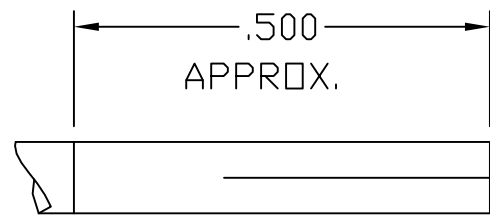


| | | | | | | |
|--------------------------|----------------|--|-----|---------------|----------|------|
| CABLE ASSEMBLY PROCEDURE | | <i>The PHOENIX Company of Chicago</i> TM 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (203) 729-9090 FAX: (203) 723-1794 | REV | DESCRIPTION | DATE | APPR |
| P/N | 26-1520-0860 | | K | PER ECN 9410 | 06/02/08 | JEM |
| PAGE 2 OF 2 | DATE: 05/25/06 | | L | PER ECN 10285 | 04/14/10 | JEM |
| DRAWN: MY | APPROVED: JEM | | M | PER ECN 11159 | 10/20/11 | JEM |
| FOR TFLEX-405 CABLE | | | N | PER ECN 13619 | 12/17/19 | JEM |

FOR USE WITH T-FLEX 405 CABLE

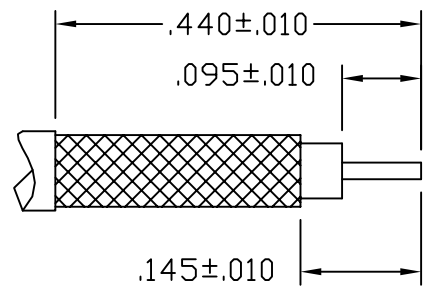
STEP 1

DIP END OF CABLE INTO FLUX AND THEN TIN DIP CABLE TO DIMENSION SHOWN USING KESTER 60/40 SOLDER @ 500° F FOR SIX SECONDS MAX.



STEP 2

TRIM CABLE TO DIMENSIONS SHOWN.



STEP 3

INSERT CABLE INTO BODY UNTIL CABLE BOTTOMS IN BODY. SOLDER CABLE JACKET INTO BODY, THEN SOLDER CENTER CONDUCTOR TO CENTER CONTACT OF CONNECTOR. CLEAN AND INSPECT THE SOLDER JOINTS. FIXTURE BODY INTO A SMALL ARBOR PRESS, BEING CAREFUL NOT TO DAMAGE CONNECTOR AND PRESS CAP INTO BODY.

