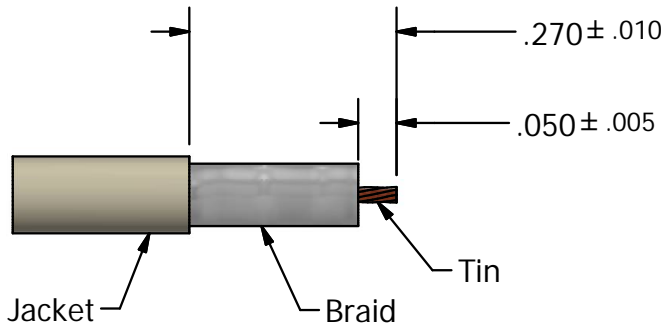


**Step 1**

Using flux EF-6100 and solder pot with 63/37 solder @ 500°F ±25°F:  
 Dip end of cable into flux.  
 Tin Dip fluxed end of cable into solder pot to a depth of .270±.010, for a maximum of 3 seconds.

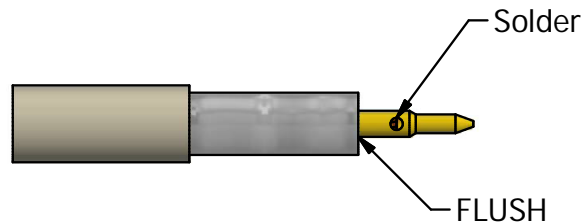


**Step 2**

Trim cable to dimensions shown.  
 Tin center conductor (.050) using above flux and solder.

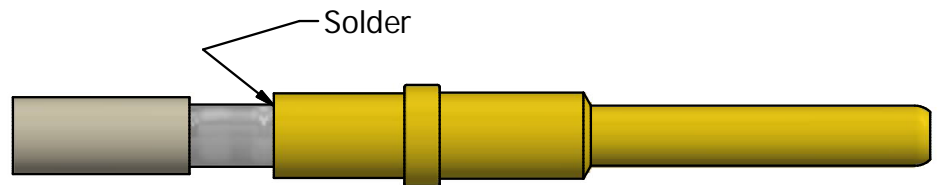
**Step 3**

Install bullet over center conductor of cable. Solder bullet to center conductor. Clean solder joint.



**Step 4**

Insert cable into body until cable bottoms. Solder body to cable braid. Clean solder joint.



CAD DRAWING - NO MANUAL REVISIONS  
 filename:h-Palco-Phoenix\Palco\_A-B-C\_Sizes\_11-26-2018.dwg

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**MATERIAL:**

<small>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS (PPF) DIMENSIONS IN INCHES OR (METRIC)</small>  <small>DO NOT SCALE PRINTS</small>  <small>TOLERANCES ARE:</small> <small>FRACTIONS: ± 1/64</small> <small>DECIMALS: .XX ± .01</small> <small>.XXX ± .003</small> <small>ANGLES: ± 1/2°</small>				<b>APPROVALS</b> <b>DATE</b>		<i>The PHOENIX Company of Chicago</i> <sup>TM</sup> 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM				
				DRAWN <b>JEM</b>	05/17/17					<b>TITLE</b> <b>CABLE ASSEMBLY PROCEDURE</b> <b>FOR 268-0021-0670</b>
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				MFG	ENGINEER <b>JEMaturo</b>	05/17/17	SCALE	F.S.R.# 11199	SHEET 1 OF 1	
				APPROVED <b>R.M.B.</b>	05/17/17					
<b>REV.</b>	<b>DESCRIPTION</b>	<b>DATE</b>	<b>APPR.</b>							