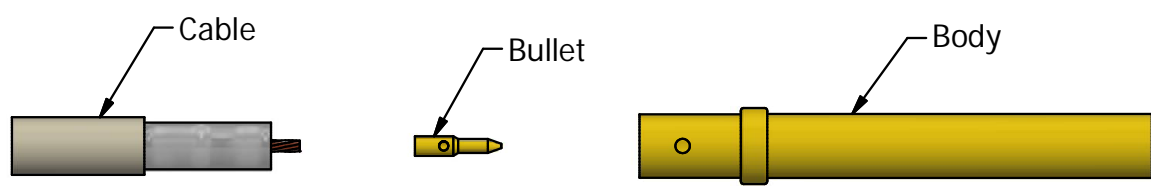


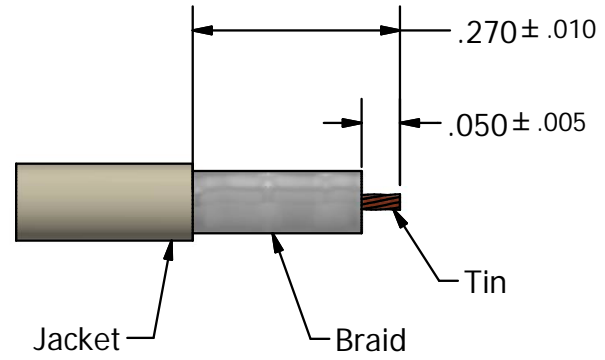
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Step 1

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.

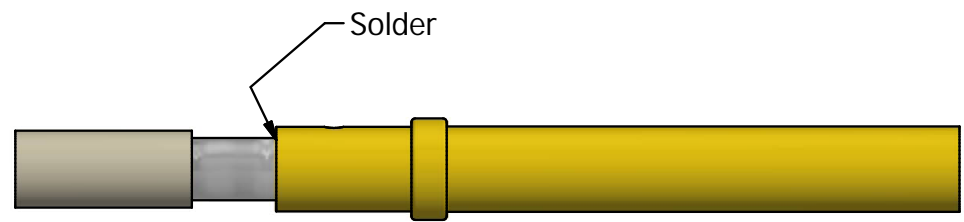
Step 3

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.idw

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MATERIAL:				UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS (PPF) DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°		APPROVALS DRAWN JEM CHECKED R.M.B. OA MFG ENGINEER JEM APPROVED R.M.B.		DATE 06/01/2017 06/01/2017 06/01/2017 06/01/2017		The PHOENIX Company of Chicago, Inc. 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM			
				THE INFORMATION DISCLOSED IN THIS DOCUMENT IS CONFIDENTIAL AND PROPRIETARY TO PHOENIX CO. INC. AND MAY NOT BE USED FOR MANUFACTURE OR ANY OTHER PURPOSE WITHOUT THE WRITTEN CONSENT OF THE PHOENIX CO. OF CHICAGO INC.				TITLE CABLE ASSEMBLY PROCESS FOR 268-1021-0670		SIZE FSCM DWG NO A 58167 268-1021-0670-CAP		REV PLATING OPT. E	
E	PER ECN 13319	8/15/2019	JEM					SCALE		F.S.R. # 11199		SHEET 1 OF 1	
D	PER ECN 13077	8/28/2018	SST										
C	PER ECN 12981	6/7/2018	JEM										
B	PER ECN 12952	5/22/2018	JEM										
A	REL. PER ECN 12524	6/1/2017	RMB										
REV.	DESCRIPTION	DATE	APPR.										

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