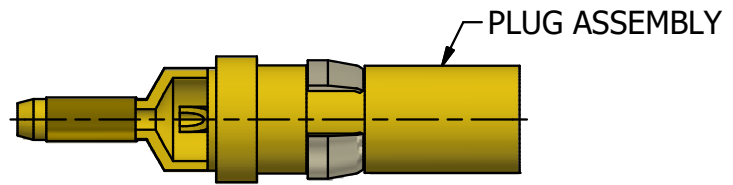
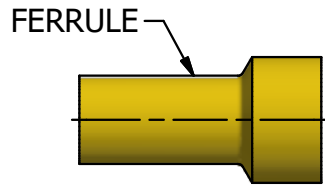


2

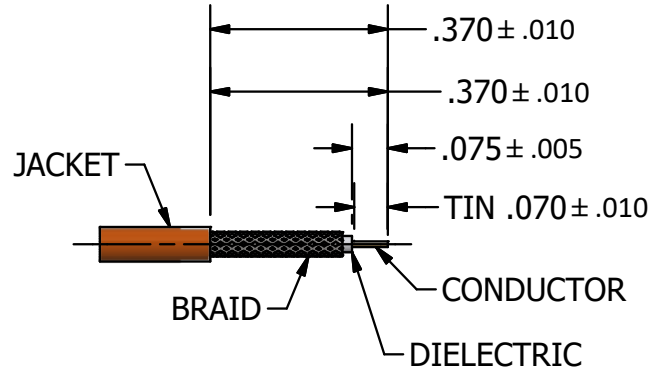
1



CABLE ASSEMBLY PROCEDURE

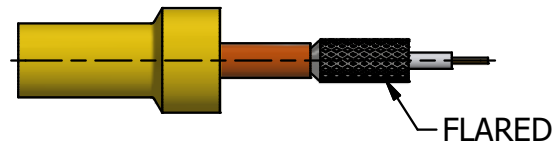
Step 1

Trim cable to dimensions shown.
Tin dip cable to dimension shown for three seconds maximum.



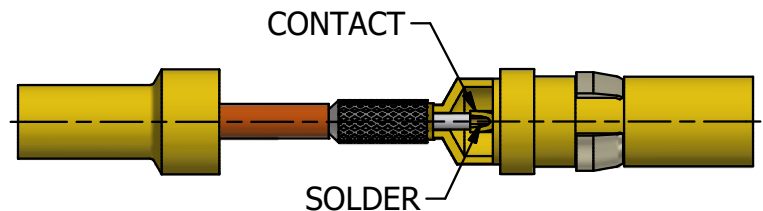
Step 2

Slide ferrule over jacket.
Flare the braid by rotating dielectric.



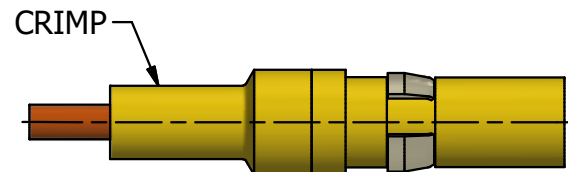
Step 3

Install the cable into the plug assembly by inserting the dielectric into the wedge and the flared braid over the wedge, as shown. Solder the conductor to the center contact. Clean.



Step 4

Seat ferrule on body, crimp ferrule with M22520/5-03 daniels Y-196, .128 hex.



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Filename: ver2\Autodesk Inventor Data Base\Assemblies\28 Series\28-0080-2400-CAP.idw

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR (METRIC)

DO NOT SCALE PRINTS

TOLERANCES ARE:

FRACTIONS: $\pm 1/64$

DECIMALS: $\pm .01$

$\pm .003$

ANGLES: $\pm 1/2^\circ$

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APPROVALS	DATE
DRAWN CA	6/19/2020
CHECKED SG	9/8/2021
QA VI	9/8/2021
MFG VL	9/8/2021
ENGINEER BW	5/3/2021
APPROVED JM	9/8/2021

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TITLE
CABLE ASSEMBLY PROCESS FOR:
28-0080-2400

REV.	DESCRIPTION	DATE	BY	SIZE	FSCM	DWG NO	REV	PLATING OPT.
C	ECN 13793	9/8/2021	JEM	A	58167	28-0080-2400	C	
A	PER ECN 4197	11/26/1997	HN					
B	PER ECN 9130	11/6/1907	HN					
				SCALE	F.S.R. #	SHEET 1 OF 1		

2

1