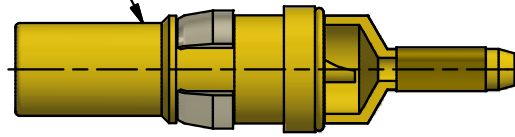


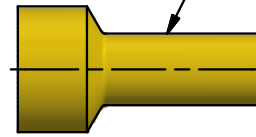
2

1

RECEPTACLE ASSEMBLY



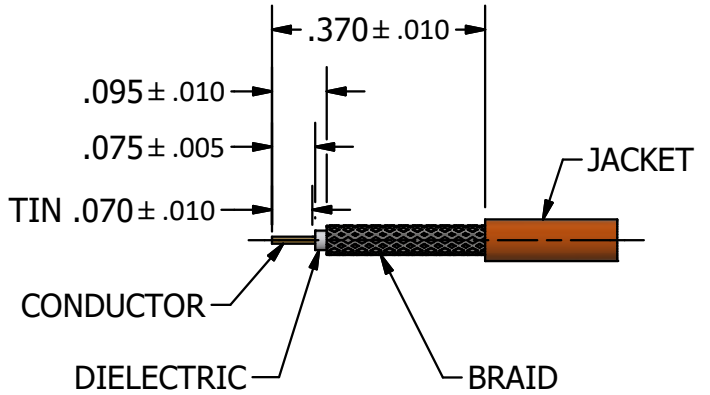
FERRULE



**CABLE ASSEMBLY PROCEDURE**

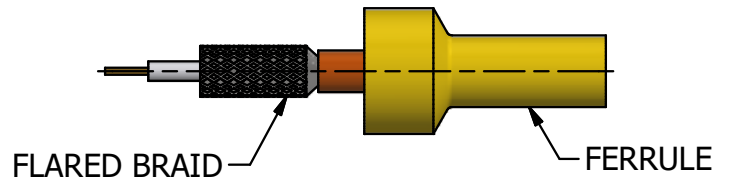
**Step 1**

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



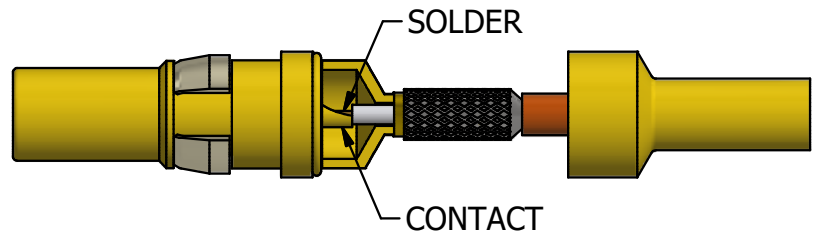
**Step 2**

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



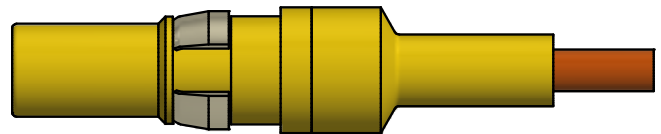
**Step 3**

Install cable into receptacle assembly.  
Insert the dielectric into wedge, beneath flared braid, as shown.  
Solder the conductor to the 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\28-1080-0400-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	5/4/2021
APPROVED JM	9/8/2021

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TITLE  
**CABLE ASSEMBLY PROCESS FOR:  
28-1080-0400**

REV.	DESCRIPTION	DATE	BY
D	ECN 13793	9/8/2021	JEM
C	ECN 1036	5/17/2010	JEM
B	ECN 5073	5/20/1999	HN
A	ECN 4902	1/28/1999	HN

SIZE <b>A</b>	FSCM 58167	DWG NO <b>28-1080-0400</b>	REV <b>D</b>	PLATING OPT.
SCALE		F.S.R. #	SHEET 1 OF 1	

2

1