

CABLE ASSEMBLY PROCEDURE

P/N 33-2800-0400

PAGE 1 OF 1 DATE: 10/30/98

DRAWN: YS APPROVED: HN

USE WITH RG-178 / RG-196 CABLES

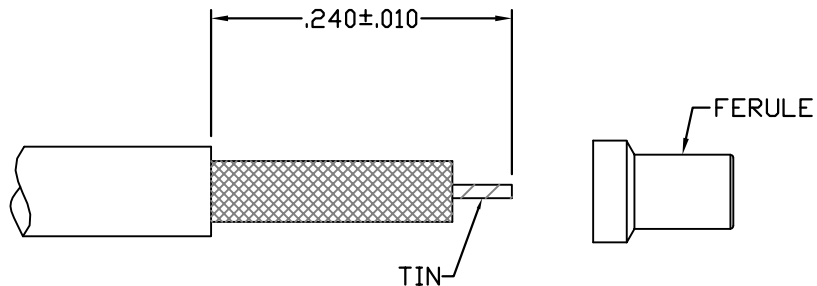
The *PHOENIX* Company of Chicago™

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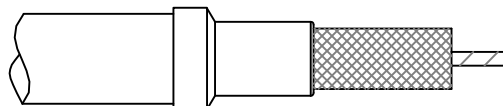
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
U	PER ECN 10915	03/30/11	JEM
V	PER ECN 11367	06/15/12	JEM
W	PER ECN 12513	05/10/17	JEM
X	PER ECN 13634	1/14/20	JEM

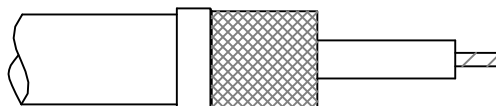
STEP 1.  
TRIM CABLE TO DIMENSIONS  
SHOWN. TIN CENTER CONDUCTOR.



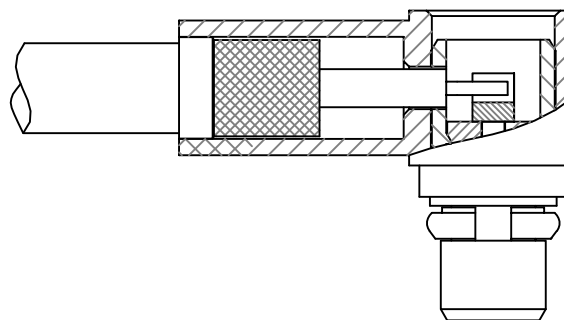
STEP 2.  
SLIDE FERRULE OVER CABLE  
UNTIL CABLE JACKET BUTTS  
AGAINST SHOULDER INSIDE  
FERRULE.



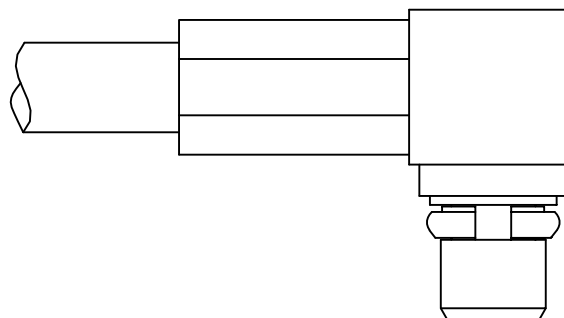
STEP 3.  
FOLD BRAID BACK OVER FERRULE.



STEP 4.  
INSERT CABLE/FERRULE  
ASSEMBLY INTO CONNECTOR.  
LOCATE SO THAT SHOULDER  
OF FERRULE IS FLUSH WITH  
END OF CONNECTOR.



STEP 5.  
CRIMP USING .105 HEX DIE  
(M22520/5-03).



STEP 6.  
SOLDER CABLE CENTER  
CONDUCTOR TO CONNECTOR  
CENTER CONTACT THROUGH  
BACK HOLE. CLEAN.  
PRESS CAP INTO BACK HOLE  
UNTIL FLUSH.

