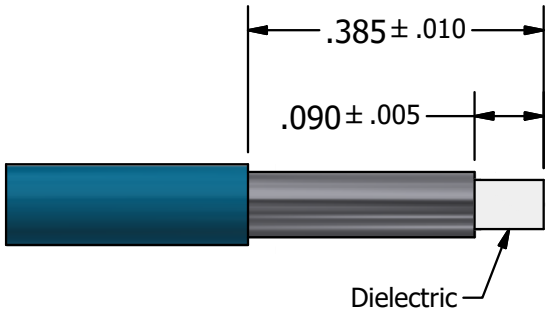
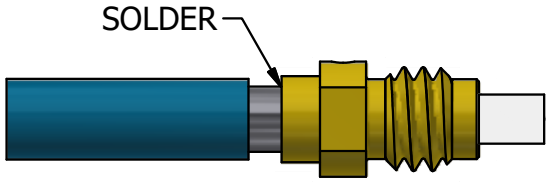




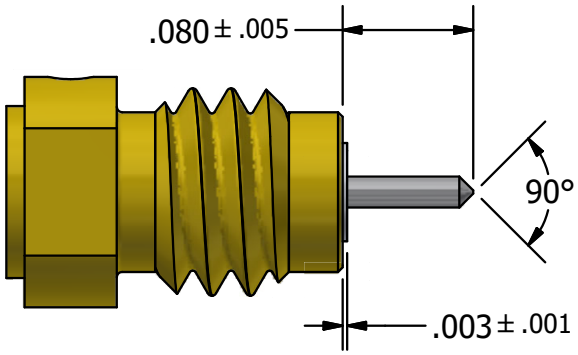
STEP 1 (PER CABLE TYPE)

***FOR FLEX CABLES: (Jacketed)**
Flux and Tin Dip Cable to dimension .400±.010
Trim Jacket to dimension - .385±.010
Trim Braid to dimension - .090±.005

***FOR SEMI RIGID CABLES: (Non-Jacketed)**
Trim Outer Conductor to dimension - .090±.005



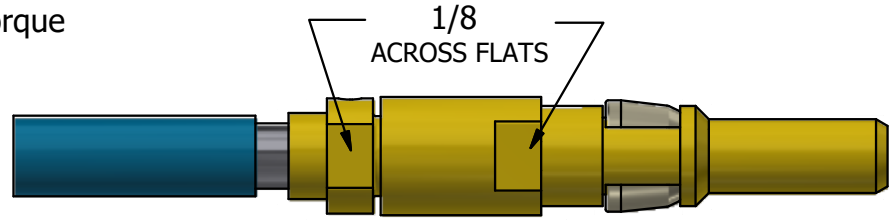
STEP 2
Slide cable into solder nut until cable bottoms.
Solder cable braid to solder nut. Clean solder joint.



STEP 3
Trim cable to dimensions shown.
Center Conductor - Solder Nut Dimension : .080±.005
Dielectric - Solder Nut Dimension : .003±.001

Point center conductor as shown.

STEP 4
Install the cable into the body and torque to 3.0 ±.5 in-lbs.



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MATERIAL:

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY
DIMENSIONS IN INCHES OR [METRIC]
DO NOT SCALE PRINTS
TOLERANCES ARE:
FRACTIONS: ± 1/64 32
DECIMALS: .XX ± .01
.XXX ± .003
ANGLES: ± 1/2°

APPROVALS	DATE
DRAWN SPS	03/25/2024
CHECKED SJG	03/25/2024
QA	
MFG	
ENGINEER JEM	12/22/2021
APPROVED SPS	03/25/2024

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
A	REL. PER ECN 14211	SPS	3/25/2024	SJG	8/31/2026
01	PRELIMINARY	JEM	12/22/2021	SPS	12/22/2021

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TITLE
CABLE ASSEMBLY PROCEDURE FOR 556-0030-0860/J

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	556-0030-0860	A	

SCALE 4 : 1 | F.S.R. # 11532 | SHEET 1 OF 1