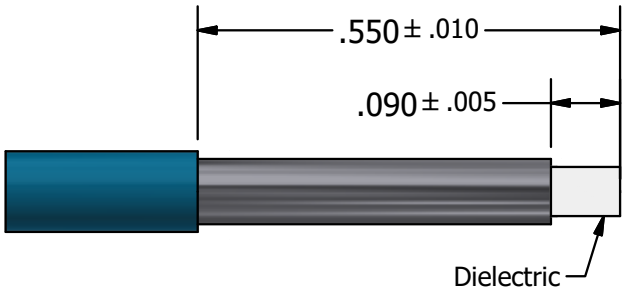


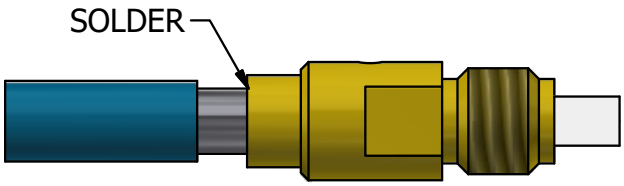
STEP 1 (PER CABLE TYPE)

***FOR FLEX CABLES: (Jacketed)**
Flux and Tin Dip Cable to dimension .600±.010
Trim Jacket to dimension - .550±.010
Trim Braid to dimension - .090±.005



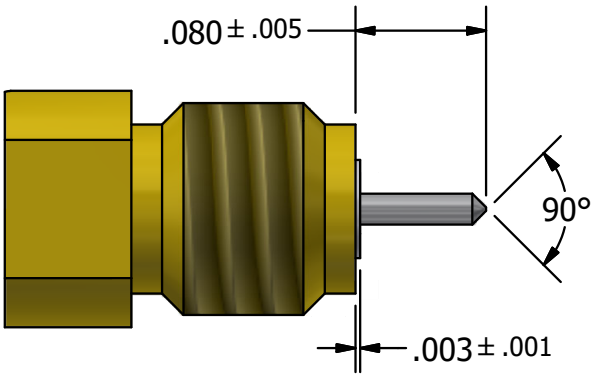
***FOR SEMI RIGID CABLES: (Non-Jacketed)**
Trim Outer Conductor to dimension - .090±.005

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

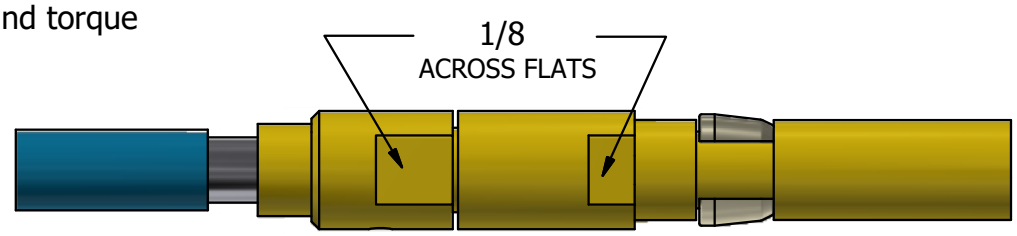


STEP 3
Trim cable to dimensions shown.
Center Conductor - Solder Nut Dimension : .080±.005
Dielectric - Solder Nut Dimension : .003±.001

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
DECIMALS: .XX ± .01
.XXX ± .003
ANGLES: ± 1/2°

APPROVALS		DATE
DRAWN	SPS	10/29/2025
CHECKED	SJG	10/29/2025
QA		
MFG		
ENGINEER	SPS	10/29/2025
APPROVED	SPS	10/29/2025

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
A	REL. PER ECN 14573	SPS	10/29/2025	SJG	8/31/2026

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TITLE
CABLE ASSEMBLY PROCEDURE FOR 556-1030-0861/J

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	556-1030-0861	A	

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