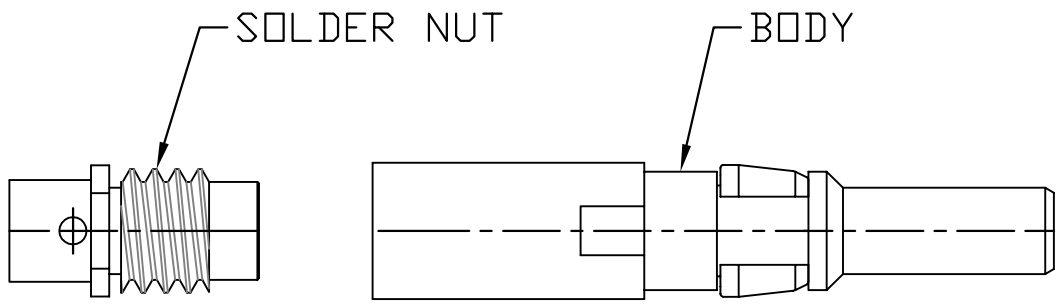


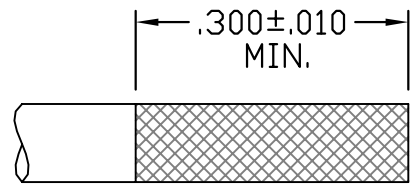
CABLE ASSEMBLY PROCEDURE	
P/N	56-0302-0865
PAGE 1 OF 1	DATE: 04/24/09
DRAWN: EK	APPROVED: JEM
FOR USE WITH GORE TYPE 89 CABLE	

The **PHOENIX** Company of Chicago™
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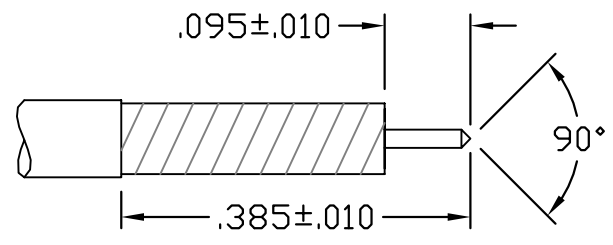
REV	DESCRIPTION	DATE	APPR
D	PER ECN 12312	05/12/16	RMB
E	PER ECN 12709	11/22/17	JEM
F	PER ECN 12997	06/20/18	BH
G	PER ECN 13105	09/17/18	JEM



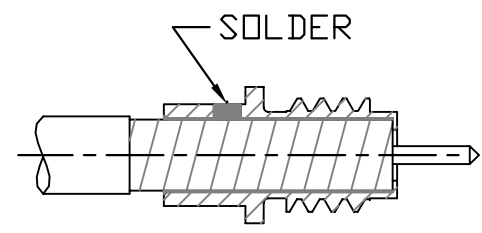
STEP 1
 TIN DIP CABLE TO
 DIMENSIONS SHOWN.



STEP 2
 TRIM CABLE TO DIMENSIONS SHOWN.
 POINT END AS SHOWN.



STEP 3
 SLIDE SOLDER NUT ONTO CABLE
 UNTIL CABLE BOTTOMS IN
 SOLDER NUT. APPLY HEAT TO
 SOLDER NUT USING RESISTANCE
 STYLE TWEEZER. ADD ADDITIONAL
 SOLDER IF NEEDED.



STEP 4
 THREAD SIZE 12
 PKZ® BODY ONTO
 PREPARED CABLE.
 TIGHTEN TO 3.0 ± 0.5
 IN-LBS. PALCO WRENCHES
 T0640 MAY BE USED.

