

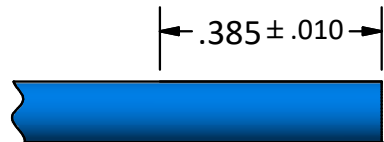
**CABLE ASSEMBLY PROCEDURE**

**Step 1 (for Flex style cable only)**

Using flux and solder pot with solder:

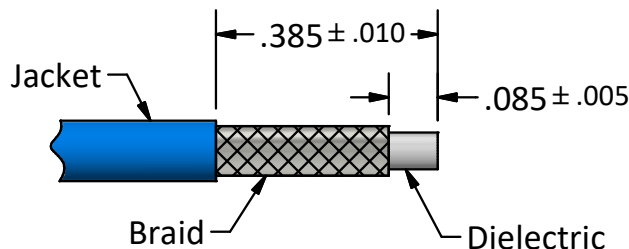
Dip end of cable into flux.

Tin Dip fluxed end of cable into solder pot a depth of  $.385 \pm .010$ , for a maximum of 3 seconds.



**Step 2**

Trim cable to dimensions shown, ( $.385 \pm .010$  dimension for jacketed cables only).

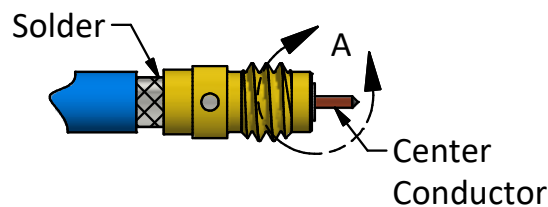


**Step 3**

Install cable into clamp nut until cable bottoms out.

Solder the cable as shown.

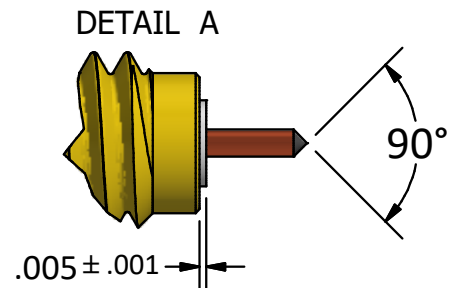
Clean solder joint.



**Step 4**

Trim Dielectric and point the center conductor to the dimensions shown.

Using Palco #T650-098 & Razor/ X-ACTO blade

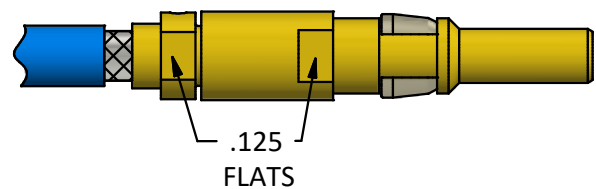


**Step 5**

Install body on to prepared cable.

Torque to 3.0 in-lbs.

Using one  $\frac{1}{8}$  wrench & one  $\frac{1}{8}$  torque wrench.



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Filename: ver2\Autodesk Inventor Data Base\Assemblies\56 Series\56-0302-0866-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:  $.XX \pm .01$

$.XXX \pm .003$

ANGLES:  $\pm 1/2^\circ$

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APPROVALS	DATE
DRAWN SPS	04/17/2020
CHECKED SG	04/17/2020
QA VI	04/17/2020
MFG VL	04/17/2020
ENGINEER SPS	04/17/2020
APPROVED JEM	04/17/2020

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TITLE  
**CABLE ASSEMBLY PROCEDURE  
FOR 56-0302-0866/J**

REV.	DESCRIPTION	DATE	BY
F	PER ECN 13746	4/17/2020	SPS
E	PER ECN 13553	11/21/2019	BGW
D	PER ECN 12997	6/20/2018	BH
C	PER ECN 12544	6/20/2017	RMB
B	PER ECN 12256	12/21/15	JEM
A	PER ECN9893	04/24/09	JEM

SIZE <b>A</b>	FSCM 58167	DWG NO <b>56-0302-0866</b>	REV <b>F</b>	PLATING OPT.
SCALE		F.S.R. #	SHEET 1 OF 1	