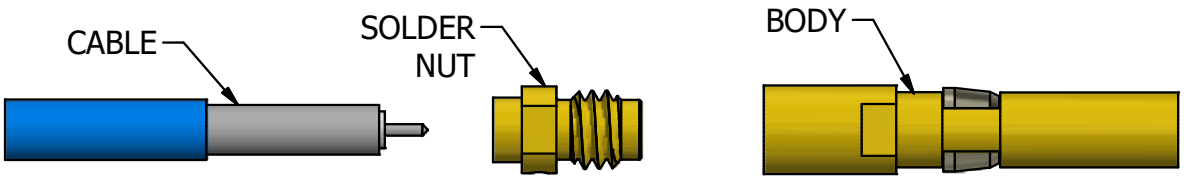
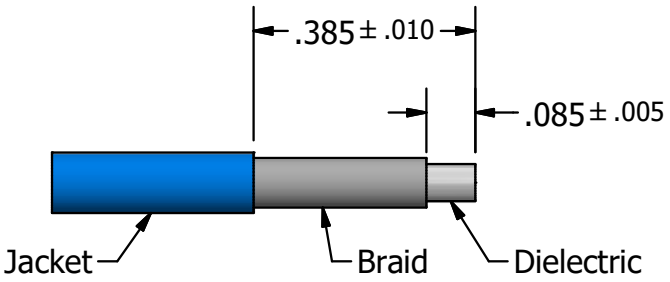
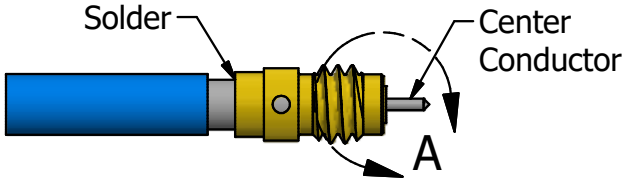


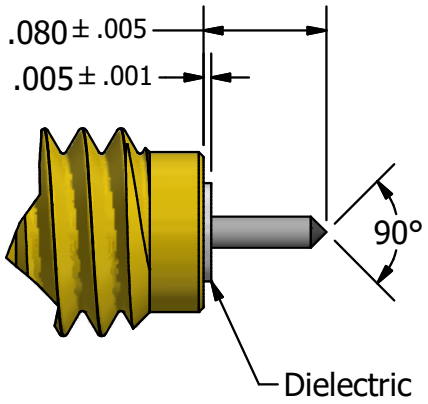


Step 1 (for Flex style cable only)
Flux and tin dip cable into solder pot to a depth of .385±.010.
Trim cable to dimensions shown, (.385±.010 dimension for jacketed cables only).

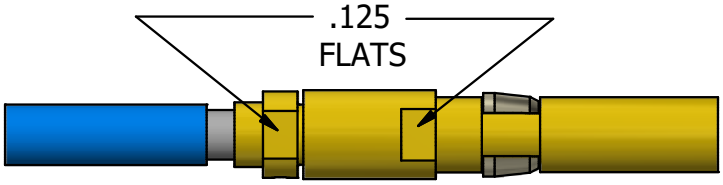


Step 2
Install cable into solder nut until cable bottoms out. Solder the cable as shown.
Clean solder joint.
Trim Dielectric to the dimensions shown. (.003 Min. extrusion) using Palco #T650-098 & Razor/ X-ACTO blade and point the center conductor maintaining the dimension shown.

DETAIL A



Step 3
Install solder nut into the body, and Torque to 3.0 in-lbs.



CAD DRAWING - NO MANUAL REVISIONS
filename:h-Palco-Phoenix\Palco_A-B-C_Sizes_11-26-2018.idw

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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°
32

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APPROVALS		DATE
DRAWN	SPS	04/21/2020
CHECKED	JEM	04/21/2020
QA		
MFG		
ENGINEER	SPS	04/21/2020
APPROVED	JEM	04/21/2020

REV.	DESCRIPTION	DATE	APPR.
K	PER ECN 13835	9/10/2020	JEM
J	PER ECN 13553	11/21/2019	JEM
I	PER ECN 13048	7/30/18	BH
H	PER ECN 12590	8/22/17	JEM
G	PER ECN 12393	11/2/16	RMB
F	PER ECN 11539	1/11/13	JEM
E	PER ECN 11456	9/25/12	JEM

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WWW.PHOENIXOFCHICAGO.COM

TITLE
CABLE ASSEMBLY PROCEDURE FOR 56-1302-0866

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	56-1302-0866	K	

SCALE | F.S.R. # | SHEET 1 OF 1