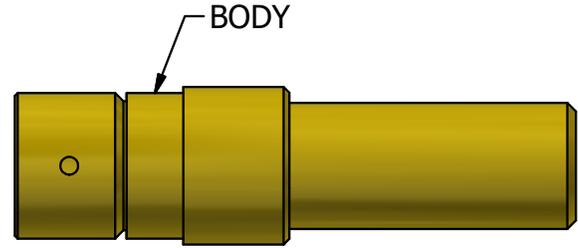
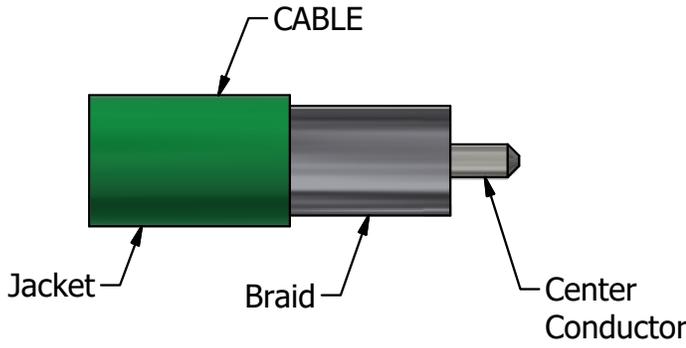


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STEP 1

*FOR FLEX CABLES: (Jacketed)

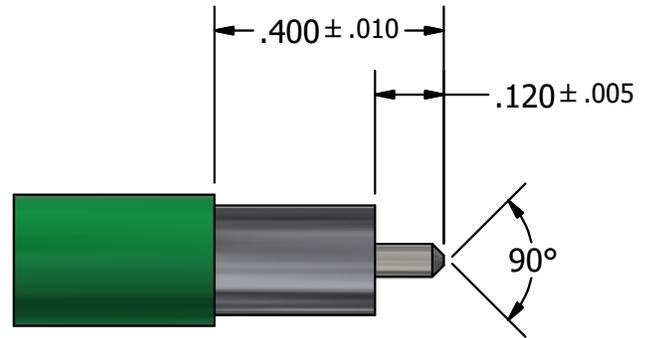
Flux and Tin Dip Cable to dimension - $.400 \pm .010$

(Lead Free Solder Recommended)

Trim Jacket to dimension - $.400 \pm .010$

Trim for Center Conductor to dimension - $.120 \pm .005$

Point the Center Conductor.

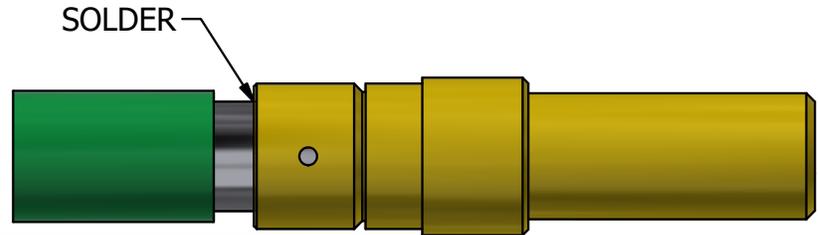


STEP 2

Insert Cable into Body until the cable bottoms and then solder.

(Lead Free Solder Recommended)

Clean solder joint.



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MATERIAL:

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: $\pm 1/2^\circ$					
A	REL. PER ECN 14506	SPS	6/9/2025	SJG	6/9/2025
01	PRELIMINARY	SPS	9/24/2024	SJG	9/24/2024
REV.	DESCRIPTION	BY	DATE	APPR.	DATE

APPROVALS	DATE
DRAWN SPS	9/24/2024
CHECKED SJG	9/24/2024
QA	
MFG	
ENGINEER SPS	9/24/2024
APPROVED SJG	9/24/2024

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TITLE
**CABLE ASSEMBLY PROCEDURE FOR
 65-0020-1910**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	65-0020-1910	A	
SCALE	4 : 1		F.S.R. #	11757
			SHEET	1 OF 1

2

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