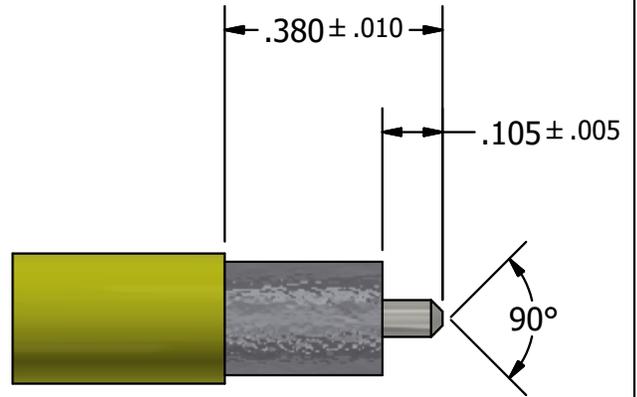


STEP 1

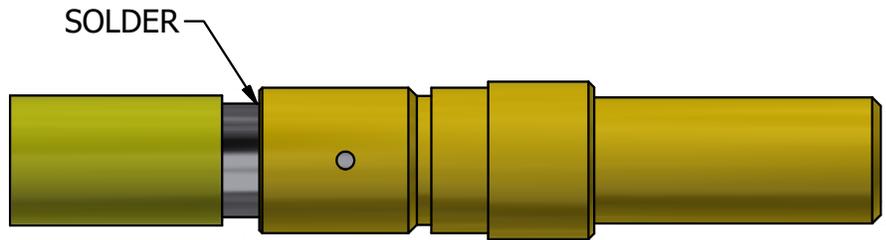
***FOR FLEX CABLES: (Jacketed)**
 Flux and Tin Dip Cable to dimension - $.400 \pm .010$
(LEAD FREE SOLDER RECOMMENDED)
 Trim Jacket to dimension - $.380 \pm .010$
 Trim for Center Conductor to dimension - $.105 \pm .005$

Point the Center Conductor.



STEP 2

Insert Cable into Body until the cable bottoms and then solder. Clean solder joint.
(LEAD FREE SOLDER RECOMMENDED)



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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 14507	SPS	10/2/2025	SJG	10/2/2025
01	PRELIMINARY	SPS	9/24/2024	SJG	9/24/2024
REV.	DESCRIPTION	BY	DATE	APPR.	DATE

APPROVALS	DATE
DRAWN SPS	10/10/2024
CHECKED SJG	10/10/2024
QA	
MFG	
ENGINEER SPS	10/10/2024
APPROVED SJG	9/24/2024

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TITLE
**CABLE ASSEMBLY PROCEDURE FOR
 65-0020-1911**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	65-0020-1911	A	
SCALE	4 : 1		F.S.R. #	11836
			SHEET	1 OF 1