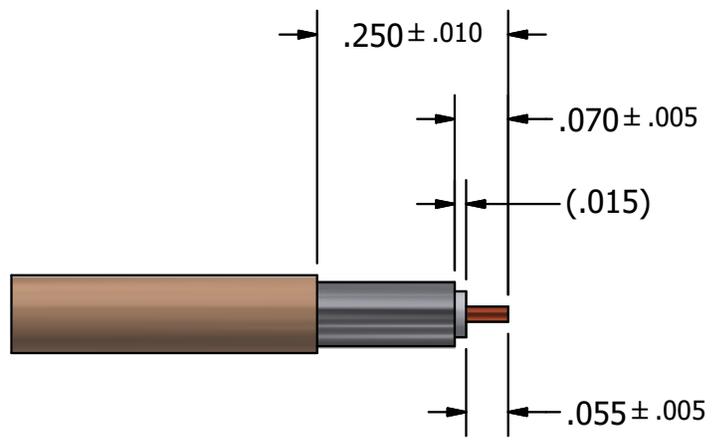


B

B

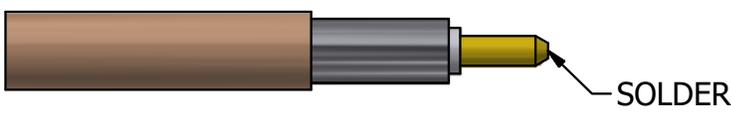
STEP 1 (PER CABLE TYPE)

**\*FOR FLEX CABLES: (Jacketed)**  
 Flux and Tin Dip Cable to dimension -  $.250 \pm .010$   
**(Lead Free Solder Recommended)**  
 Trim Jacket to dimension -  $.250 \pm .010$   
 Trim Braid to dimension -  $.070 \pm .005$   
 Trim Dielectric to dimension -  $.055 \pm .005$   
 (Center Conductor Length)



STEP 2

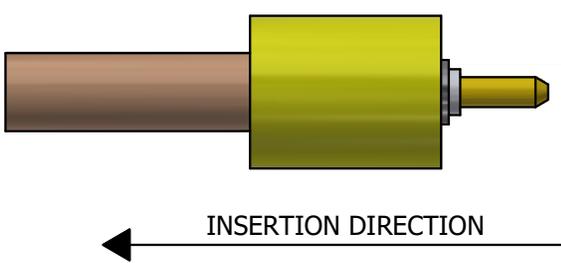
Insert Cable into Bullet until the it bottoms and then solder as shown.  
**(Lead Free Solder Recommended)**



Clean solder joint.

STEP 3

Load the shrink tubing on to the cable as shown.



A

A

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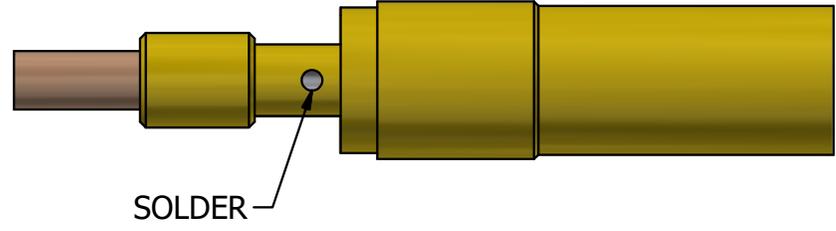
MATERIAL:						<b>The PHOENIX Company of Chicago, Inc.</b> 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (800) 323-9562 FAX:(630) 206-1801							
UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR [METRIC]  DO NOT SCALE PRINTS  TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°						APPROVALS		DATE		TITLE <b>CABLE ASSEMBLY PROCEDURE FOR 65-1020-0670</b>			
						DRAWN		9/18/2024					
						CHECKED		9/18/2024					
						QA							
MFG				SIZE		FSCM		DWG NO		REV		PLATING OPT.	
ENGINEER		9/18/2024		A		58167		65-1020-0670		A			
APPROVED		9/18/2024		SCALE		4 : 1		F.S.R. # 11836		SHEET		1 OF 2	
SJK													

STEP 4

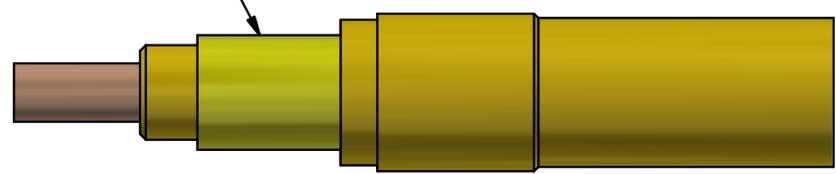
Insert the Cable S/A into Body until the cable bottoms and then solder the hole as shown.

**(Lead Free Solder Recommended)**

Clean solder joint.



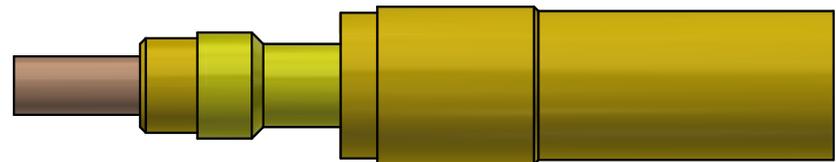
HEAT SHRINK



STEP 5

Slide back the shrink tube and heat shrink it with heat gun.

**NOTE:  
HEAT SHRINKING SHOULD BE PLACED  
AS SHOWN.**



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	DRAWN	
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TITLE  
**CABLE ASSEMBLY PROCEDURE  
 FOR 65-1020-0670**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
<b>A</b>	58167	65-1020-0670	<b>A</b>	
SCALE	4 : 1		F.S.R. # 11836	SHEET 2 OF 2