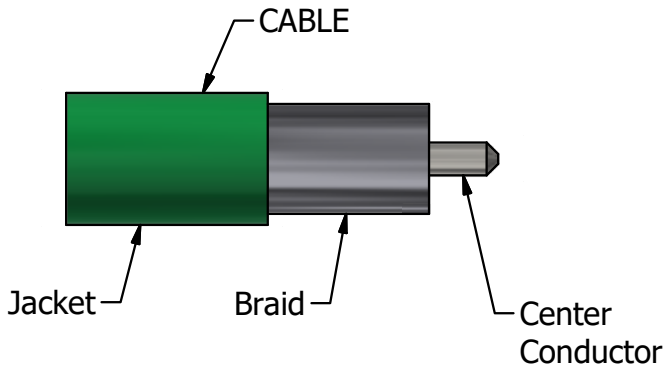
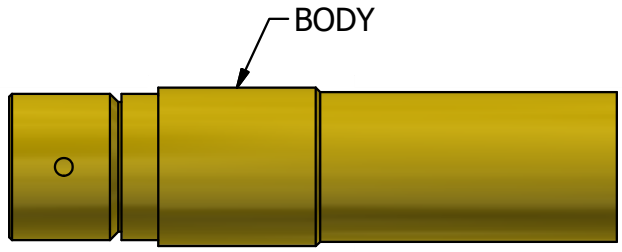
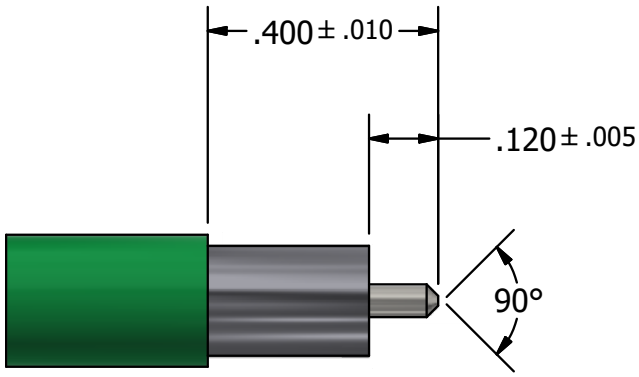




STEP 1

***FOR FLEX CABLES: (Jacketed)**
Flux and Tin Dip Cable to dimension - .400±.010
(Lead Free Solder Recommended)
Trim Jacket to dimension - .400±.010
Trim for Center Conductor to dimension - .120±.005

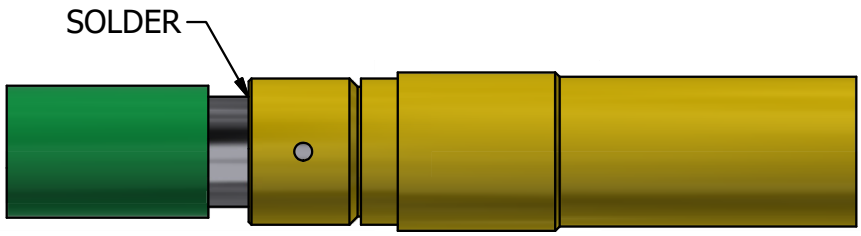
Point the Center Conductor.



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: ± 1/64
DECIMALS: .XX ± .01
.XXX ± .003
ANGLES: ± 1/2°

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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PHONE: (800) 323-9562 FAX:(630) 206-1801

TITLE
CABLE ASSEMBLY PROCEDURE FOR 65-1020-1910

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	65-1020-1910	A	

SCALE 4 : 1 | F.S.R. # 11757 | SHEET 1 OF 1

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
A	REL. PER ECN 14506	SPS	6/9/2025	SJG	6/9/2025
01	PRELIMINARY	SPS	9/24/2024	SJG	9/24/2024