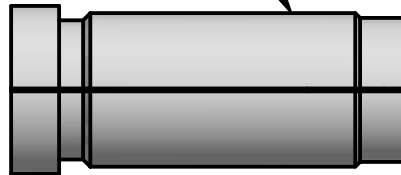


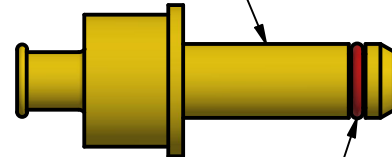
# RG405 SR CABLE

Stabilizing ring  
(68-0022-0861 only)

Cable



Body



O-Ring  
(optional)

## STEP 1

Strip cable to dimension shown.  
Point end 90°.

\*Note: on 68-0022-0861 slide stabilizing ring on first.

.090 ± .010

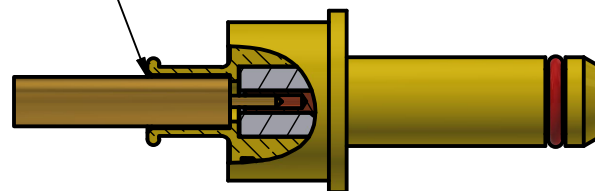


Point end

## STEP 2

Slide prepared cable into connector  
body and solder, clean solder joint.

Solder



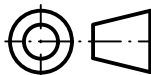
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## MATERIAL:

| REV. | DESCRIPTION   | BY  | DATE      | APPR. | DATE       |
|------|---------------|-----|-----------|-------|------------|
| N    | PER ECN 14358 | BAK | 12/5/2024 | DW    | 12/19/2024 |
| M    | PER ECN 14451 | RA  | 9/20/2024 | DW    | 9/26/2024  |
| L    | PER ECN 14357 |     |           | RMB   | 3/6/24     |
| K    | PER ECN 13383 |     |           | JEM   | 7/2/19     |
| J    | PER ECN 1362  |     |           | JEM   | 8/3/18     |
| I    | PER ECN 12694 |     |           | JEM   | 11/14/17   |

|   |    |
|---|----|
| UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY<br>DIMENSIONS IN INCHES OR [METRIC] |    |
| DO NOT SCALE PRINTS   |    |
| TOLERANCES ARE:   | 32 |
| FRACTIONS: ± 1/64   |    |
| DECIMALS: .XX ± .01   |    |
| .XXX ± .003   |    |
| ANGLES: ± 1/2°  |    |



| APPROVALS | DATE      |
|-----------|-----------|
| DRAWN     |           |
| EK        | 10/6/1997 |
| CHECKED   |           |
| QA        |           |
| MFG       |           |
| ENGINEER  |           |
| APPROVED  |           |
| JEM       | 10/6/1997 |

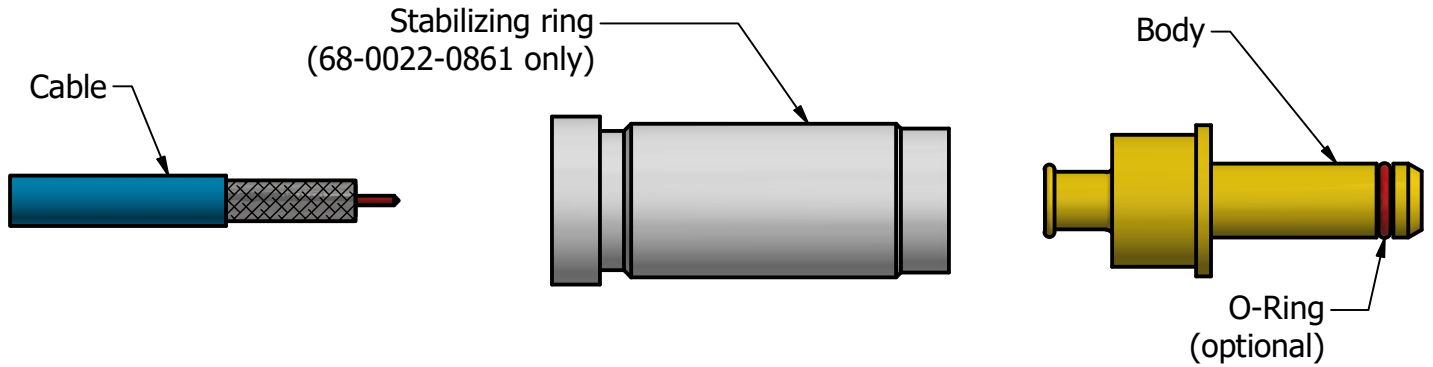
The **PHOENIX** Company of Chicago, Inc.

22 GREAT HILL RD., NAUGATUCK, CT 06770  
WWW.PHOENIXOFCHICAGO.COM  
PHONE: (800) 323-9562 FAX: (630) 206-1801

TITLE  
**CABLE ASSEMBLY PROCEDURE  
FOR 68-002X-0861**

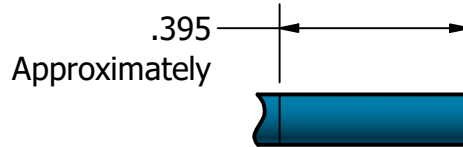
| SIZE  | FSCM  | DWG NO       | REV     | PLATING OPT. |
|-------|-------|--------------|---------|--------------|
| A     | 58167 | 68-002X-0861 | N       |              |
| SCALE | 2.5:1 | F.S.R. #     | SHEET 1 | OF 2         |

# TFLEX CABLE



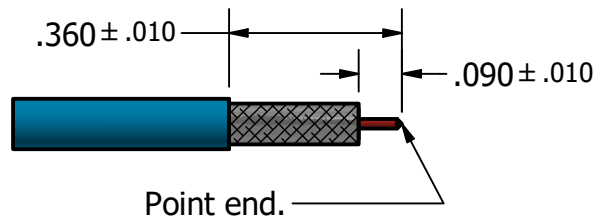
## STEP 1

Dip end of cable into flux EF-6100 and then tin dip cable to dimension shown using Kester 60/40 solder at 500°F for six seconds max.



## STEP 2

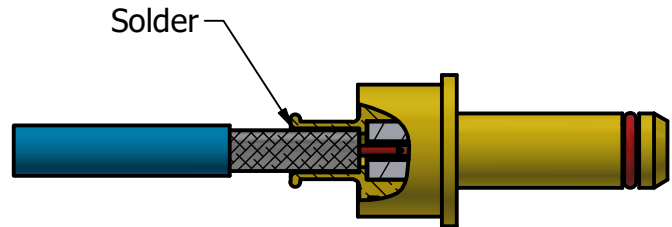
Trim cable to dimensions shown. Point tip of inner conductor as shown.



Note: on 68-0022-0861 slide stabilizing ring on first.

## STEP 3

Slide prepared cable into connector body and solder, clean solder joint.



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## MATERIAL:

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|  |
|--|
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| TOLERANCES ARE:<br>FRACTIONS: $\pm 1/64$<br>DECIMALS: $.XX \pm .01$<br>XXX $\pm .003$<br>ANGLES: $\pm 1/2^\circ$ |
|  |

| APPROVALS | DATE      |
|-----------|-----------|
| DRAWN     | EK        |
| CHECKED   | 10/6/1997 |
| QA        |           |
| MFG       |           |
| ENGINEER  |           |
| APPROVED  | JEM       |
|           | 10/6/1997 |

|  |               |                        |                 |              |
|--|---------------|------------------------|-----------------|--------------|
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| TITLE<br><b>CABLE ASSEMBLY PROCEDURE<br/>FOR 68-002X-0861</b>  |               |                        |                 |              |
| SIZE<br><b>A</b>   | FSCM<br>58167 | DWG NO<br>68-002X-0861 | REV<br><b>N</b> | PLATING OPT. |
| SCALE<br>2.5:1   | F.S.R. #      |                        | SHEET 2         | OF 2         |