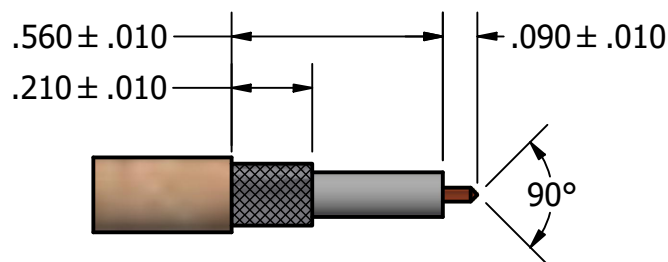
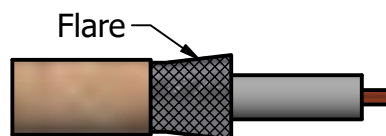
**STEP 1**

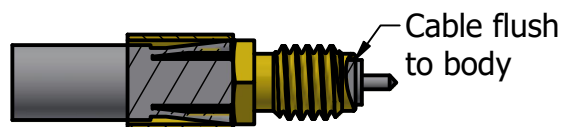
Strip cable to dimension shown, and point center conductor.

**STEP 2**

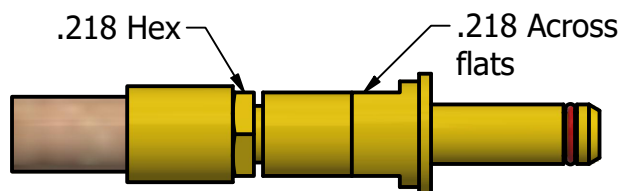
Slide ferrule over cable. Flare braid by rotating dielectric.

**STEP 3**

Slide crimp nut onto cable and under braid, be sure dielectric is flush to body. Slide ferrule up to crimp nut shoulder and crimp using .213 hex die (M22520/5-05).

**STEP 4**

Thread connector body onto crimp nut assembly, tighten to 7 IN-LBS



WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

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MATERIAL:

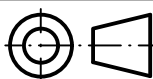
REV.	DESCRIPTION	BY	DATE	APPR.	DATE
J	PER ECN 14466	JLZ	12/10/2024	DW	1/13/2025
H	PER ECN 13749			JEM	4/8/2020
G	PER ECN 13397			JEM	7/15/2019
F	PER ECN 13062			JEM	8/3/2018

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: $\pm 1/2^\circ$

**APPROVALS****DATE**

DRAWN

JEM

6/30/1997

CHECKED

QA

MFG

ENGINEER

APPROVED

HN

6/30/1997

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

TITLE

**CABLE ASSEMBLY PROCEDURE
FOR 68-008X-1201**

SIZE

A

FSCM

58167

DWG NO

68-008X-1201

REV

J

PLATING OPT.

SCALE 2:1

F.S.R. #

SHEET 1 OF 1