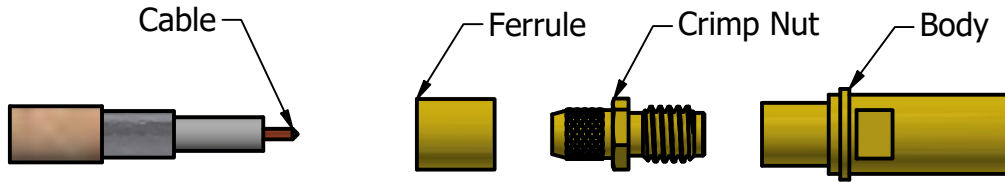
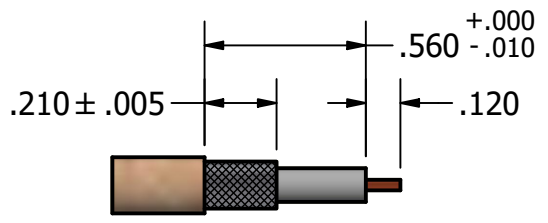


2

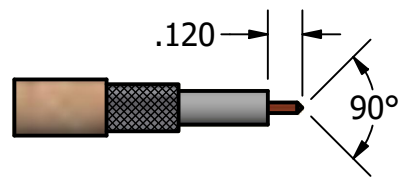
1



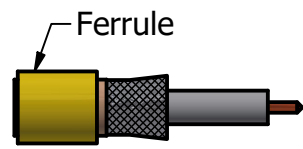
**STEP 1**  
Strip cable to dimensions shown.



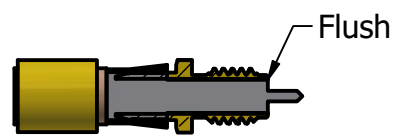
**STEP 2**  
Trim cable to new dimensions.  
Point center conductor as shown.



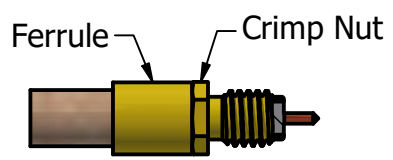
**STEP 3**  
Slide ferrule over cable.  
Flare braid by rotating dielectric.



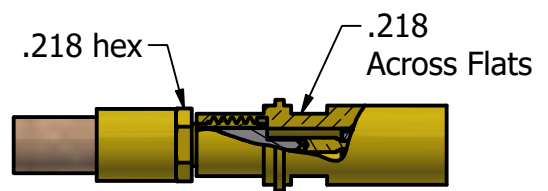
**STEP 4**  
Insert the barrel of the crimp nut between the cable braid and dielectric. Position so that the end of the cable dielectric is flush with the end of the crimp nut.



**STEP 5**  
Slide ferrule against shoulder and crimp using .213 hex die set Y-197 (M22520/5-05).



**STEP 6**  
Thread the connector body onto crimp nut assembly.  
Tighten to 7-10 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:**

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR [METRIC]						APPROVALS		DATE																															
DO NOT SCALE PRINTS						DRAWN		6/21/2005																															
TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°						CHECKED																																	
<table border="1"> <tr> <td>G</td> <td>PER ECN 14466</td> <td>JLZ</td> <td>12/12/2024</td> <td>DW</td> <td>1/13/2025</td> </tr> <tr> <td>F</td> <td>PER ECN 13445</td> <td></td> <td></td> <td>JEM</td> <td>8/5/2019</td> </tr> <tr> <td>E</td> <td>PER ECN 12693</td> <td></td> <td></td> <td>JEM</td> <td>11/9/2017</td> </tr> <tr> <td>D</td> <td>PER ECN 9689</td> <td></td> <td></td> <td>JEM</td> <td>12/9/2008</td> </tr> <tr> <td>C</td> <td>PER ECN 8040</td> <td></td> <td></td> <td>JEM</td> <td>6/21/2005</td> </tr> </table>						G	PER ECN 14466	JLZ	12/12/2024	DW	1/13/2025	F	PER ECN 13445			JEM	8/5/2019	E	PER ECN 12693			JEM	11/9/2017	D	PER ECN 9689			JEM	12/9/2008	C	PER ECN 8040			JEM	6/21/2005	QA			
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ENGINEER																																							
APPROVED		JEM																																					
REV.		DESCRIPTION		BY		DATE		APPR.		DATE																													

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**CABLE ASSEMBLY PROCEDURE FOR 68-1080-1200**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	68-1080-1200	G	
SCALE	1.5:1	F.S.R. #	SHEET 1 OF 1	

2

1