

CABLE ASSEMBLY PROCEDURE

P/N 68-1080-1201 A/B/C/D

PAGE 1 OF 1

DATE: 2/12/97

DRAWN: IY

APPROVED: HN

FOR USE WITH RG-55A, 142, 223 CABLE

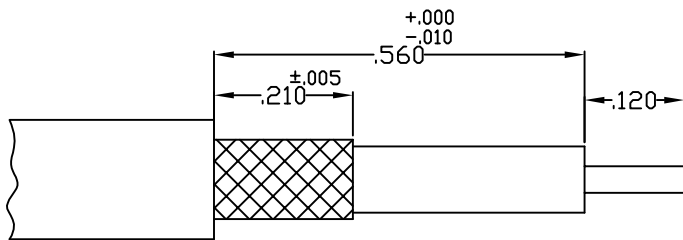
The **PHOENIX** Company of Chicago™

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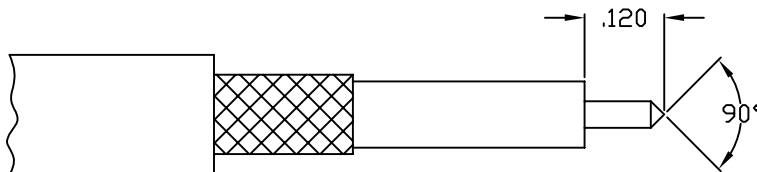
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
F	PER ECN 12693	11/09/17	JEM
G	PER ECN 13062	08/06/18	JEM
H	PER ECN 13447	08/7/19	JEM
J	PER ECN 13749	04/08/20	JEM

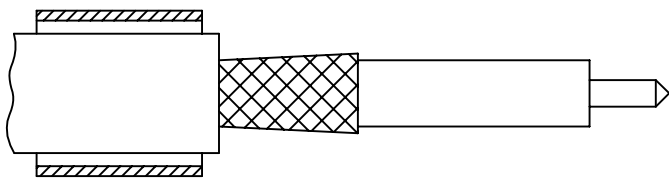
NOTES: 1) DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].



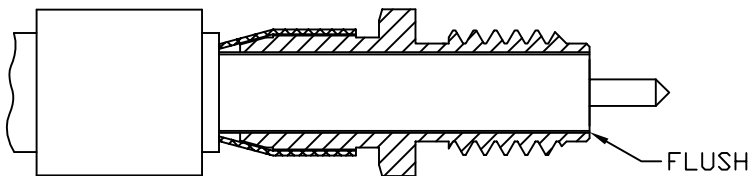
STEP 1.
STRIP CABLE TO DIMENSIONS SHOWN.



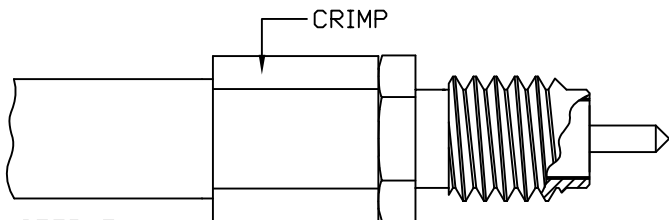
STEP 2.
TRIM CABLE TO NEW DIMENSIONS.
POINT CENTER CONDUCTOR AS SHOWN.



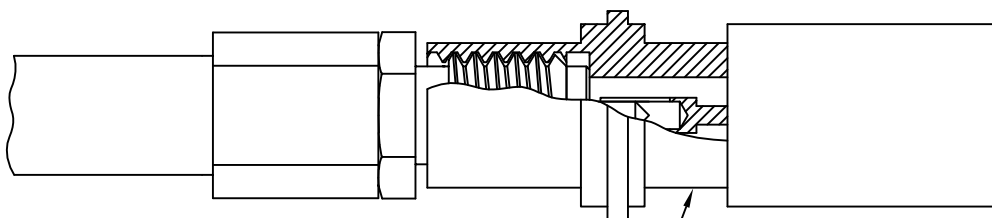
STEP 3.
SLIDE FERRULE OVER CABLE. FLARE BRAID BY ROTATING DIELECTRIC.



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
CRIMP NUT.



STEP 5.
SLIDE FERRULE AGAINST SHOULDER AND CRIMP USING .213 HEX DIE(M22520/5-05) AND Y-197 DIE SET.



STEP 6.
THREAD CONNECTOR BODY ONTO CRIMP NUT ASSEMBLY. TIGHTEN TO 7-10 IN-LBS.