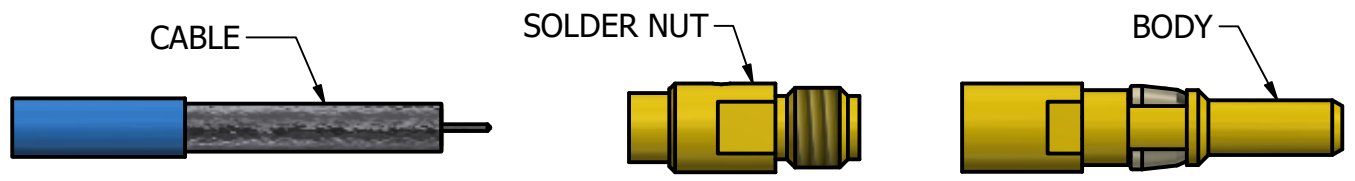


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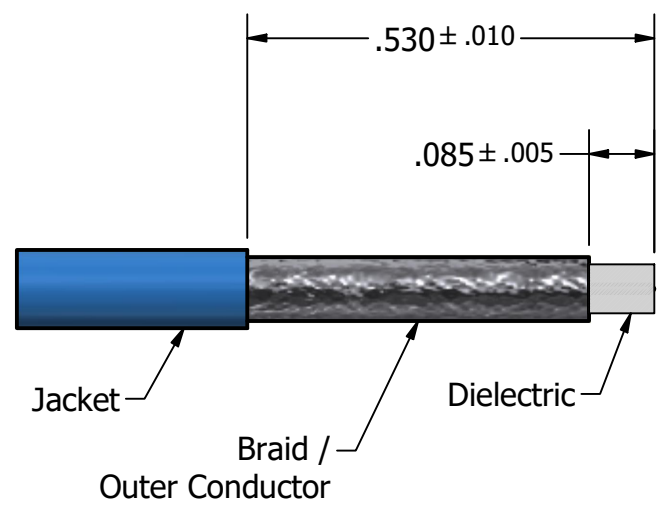
**STEP 1 (PER CABLE TYPE)**

**\*FOR FLEX CABLES: (Jacketed)**

- Flux and Tin Dip Cable to dimension -  $.500 \pm .010$
- Trim Jacket to dimension -  $.530 \pm .010$
- Trim for Dielectric to dimension -  $.085 \pm .005$

**\*FOR SEMI RIGID CABLES: (Non-Jacketed)**

- Trim for Dielectric to dimension -  $.085 \pm .005$

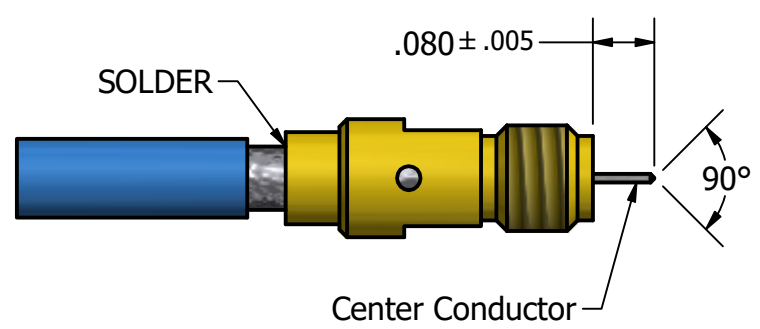


**STEP 2**

Insert Cable into Solder Nut until the cable bottoms and then solder.  
Clean solder joint.

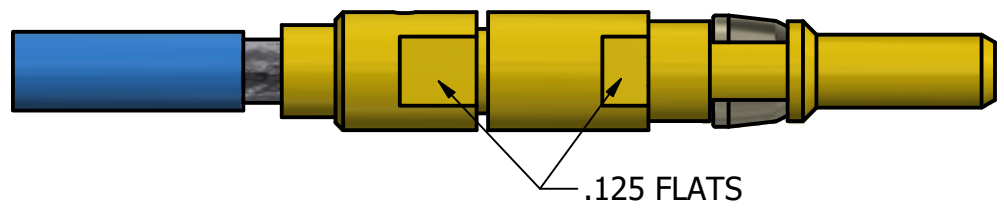
Using T0-0650-098 with dielectric trim shim T0650-159 trim dielectric completely.

Point the Center Conductor.



**STEP 3**

Torque the Cable Sub-Assembly to Body to 3 in-lbs. using two 1/8 wrenches.



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**MATERIAL:**

|   |  |  |  |  |  |           |             |           |
|---|--|--|--|--|--|-----------|-------------|-----------|
| UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR [METRIC] |  |  |  |  |  | APPROVALS |             | DATE      |
|   |  |  |  |  |  | DRAWN     | SPS         | 7/17/2024 |
| DO NOT SCALE PRINTS   |  |  |  |  |  | CHECKED   | SJG         | 7/17/2024 |
|   |  |  |  |  |  | QA        | FRR         | 8/19/2025 |
| TOLERANCES ARE:<br>FRACTIONS: ± 1/64<br>DECIMALS: .XX ± .01<br>.XXX ± .003<br>ANGLES: ± 1/2°      |  |  |  |  |  | MFG       | VAL         | 8/19/2025 |
|   |  |  |  |  |  | ENGINEER  | SPS         | 7/17/2024 |
|   |  |  |  |  |  | APPROVED  | SJG         | 7/17/2024 |
|   |  |  |  |  |  | REV.      | DESCRIPTION | BY        |

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TITLE  
**CABLE ASSEMBLY PROCEDURE FOR 756-0030-0860**

|          |                |               |              |              |
|----------|----------------|---------------|--------------|--------------|
| SIZE     | FSCM           | DWG NO        | REV          | PLATING OPT. |
| <b>A</b> | 58167          | 756-0030-0860 | <b>A</b>     |              |
| SCALE    | F.S.R. # 11718 |               | SHEET 1 OF 1 |              |
| 4 : 1    |                |               |              |              |

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