

STEP 1 (PER CABLE TYPE)

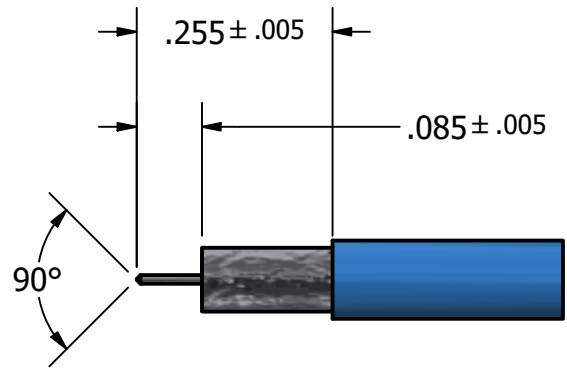
***FOR FLEX CABLES: (Jacketed)**

Flux and Tin Dip Cable to dimension - $.300 \pm .010$
 Trim Jacket to dimension - $.255 \pm .010$
 Trim for Center Conductor to dimension - $.085 \pm .005$

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

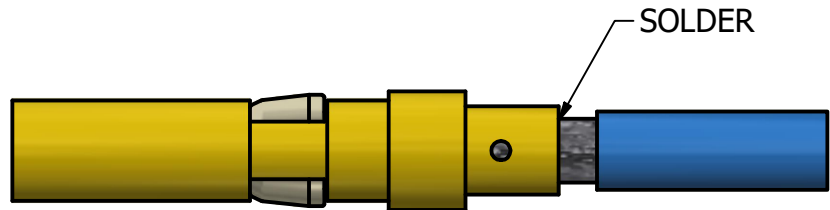
Trim for Center Conductor to dimension - $.085 \pm .005$

Point the Center Conductor.



STEP 2

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



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MATERIAL:

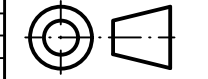
UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR [METRIC].
 DO NOT SCALE PRINTS
 TOLERANCES ARE:
 FRACTIONS: $\pm 1/64$
 DECIMALS: $.XX \pm .01$
 $.XXX \pm .003$
 ANGLES: $\pm 1/2^\circ$

APPROVALS	DATE
DRAWN SPS	7/22/2024
CHECKED SJG	7/22/2024
QA FRR	8/19/2025
MFG VAL	8/19/2025
ENGINEER SPS	7/22/2024
APPROVED SJG	7/22/2024

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TITLE
**CABLE ASSEMBLY PROCEDURE FOR
 756-1020-0860**

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
A	REL. PER ECN 14477	SPS	3/11/2025	DRW	8/22/2025
01	PRELIMINARY	SPS	7/22/2024	SJG	7/18/2024



SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	756-1020-0860	A	

SCALE 4 : 1 F.S.R. # 11718 SHEET 1 OF 1