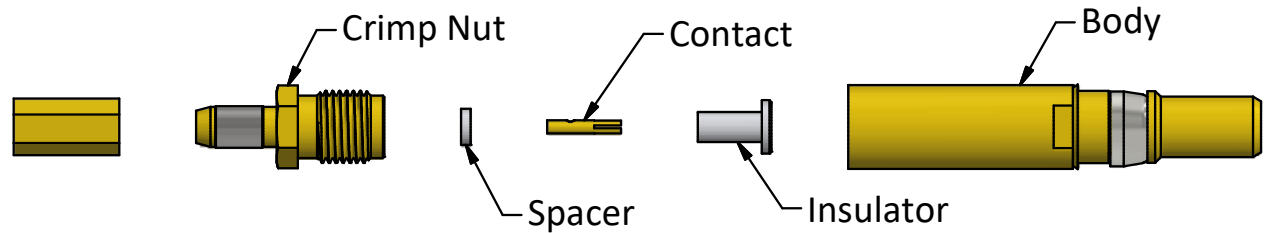
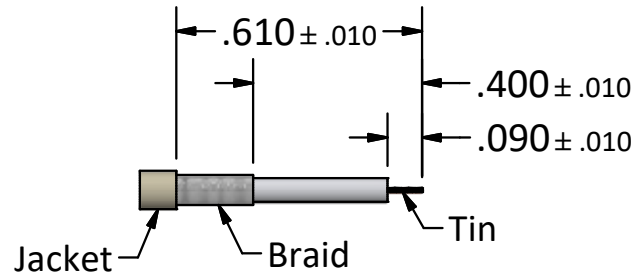


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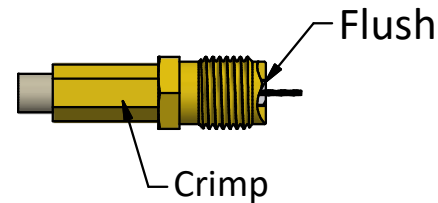
1



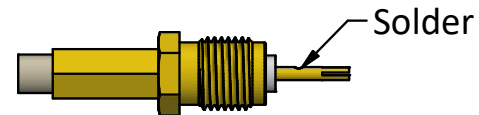
1. Trim cable to dimensions shown.  
Tin center conductor.



2. Install ferrule onto cable. Flare braid by rotating cable dielectric. Install crimp nut onto cable and under braid. Cable dielectric must be flush with end of crimp nut. Slide ferrule up to crimp nut shoulder and crimp using .128 hex die (M22520/5-03).



3. Install spacer and contact onto cable assembly. Solder bullet to cable center conductor. Clean solder joint.



4. Install insulator over contact.



5. Install body onto above sub-assembly and torque to 7-10 in-lbs.



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Filename: \\Autodesk Inventor Data Base\Assemblies\78 Series\78-1080-0670-CU-Layout for C Sized Drawing.idw

UNLESS OTHERWISE SPECIFIED,  
PHOENIX WORKMANSHIP STANDARDS APPLY  
DIMENSIONS IN INCHES OR (METRIC)

DO NOT SCALE PRINTS

TOLERANCES ARE:

FRACTIONS:  $\pm 1/64$

DECIMALS:  $\pm .01$

$\pm .003$

ANGLES:  $\pm 1/2^\circ$

32

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COMPANY OF CHICAGO INC.

APPROVALS	DATE
DRAWN JEM	5/22/19
CHECKED B.H.	5/22/2019
QA	
MFG	
ENGINEER JEMaturo	5/22/19
APPROVED B.H.	5/22/2019

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TITLE  
**Cable Assembly Procedure  
(CAP) for 76-0080-0671**

REV.	DESCRIPTION	DATE	BY
A	Release Per ECN 13883	10/27/2020	RMB
03	Added Crimp	10/22/2020	RMB
02	Revised	10/21/2020	BH
01	Preliminary	10/15/2020	BH

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	<b>76-0080-0671-CAP</b>	A	
SCALE		F.S.R. #	SHEET 1 OF 1	

2

1