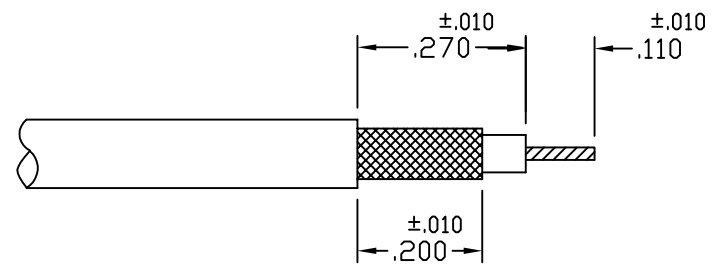


CABLE ASSEMBLY PROCEDURE	
P/N	76-1580-0670
PAGE 1 OF 1	DATE: 08/07/19
DRAWN: SST	APPROVED: JEM
USE WITH RG-179 CABLE	

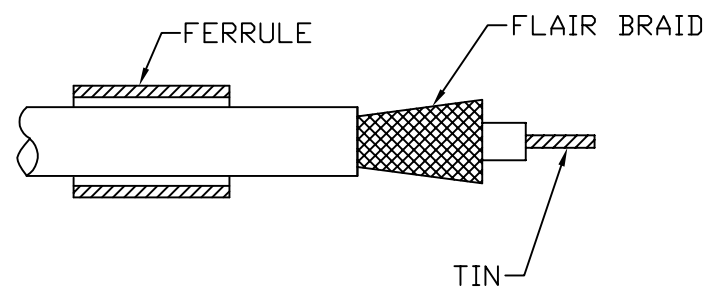
The **PHOENIX** Company of Chicago™  
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REV	DESCRIPTION	DATE	APPR
A	PER ECN 13444	08/07/19	JEM
B	PER ECN 13645	1/17/20	JEM

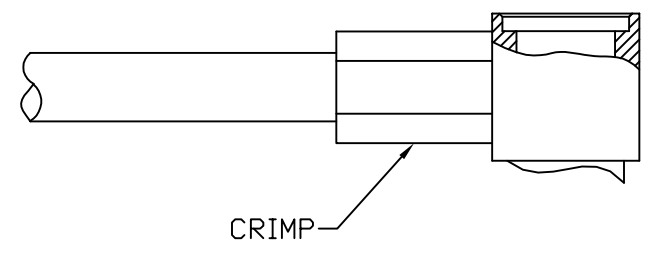
STEP 1  
 STRIP CABLE TO DIMENSIONS SHOWN.  
 TIN CENTER CONDUCTOR.



STEP 2  
 SLIDE FERRULE OVER CABLE.  
 FLAIR BRAID BY ROTATING DIELECTRIC.



STEP 3  
 INSERT CABLE INTO WEDGE.  
 SLIDE FERRULE OVER BRAID AND  
 CRIMP WITH (M22520/5-03) .128 HEX DIE.



STEP 4  
 SOLDER CENTER CONDUCTOR INTO CONTACT  
 SLOT THROUGH BACK HOLE.  
 CLEAN SOLDER JOINT. PRESS CAP  
 INTO BODY.

