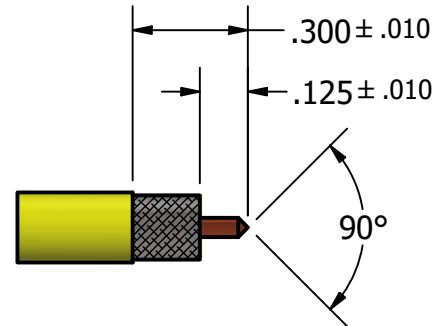


STEP 1

Flux end of cable. Stick cable into solder pot to dimensions shown, for 3 seconds maximum.

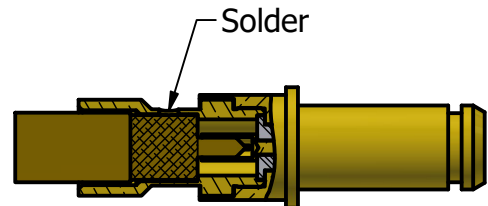
STEP 2

Trim cable to dimensions shown. Point center conductor.



STEP 3

Slide connector onto cable until cable bottoms in body. Solder body to cable braid thru side hole. Clean solder joint.



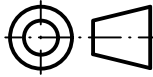
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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
F	PER ECN 14229	BAK	9/30/2024	DW	11/26/2024
E	PER ECN 13494			JEM	9/16/2019
D	PER ECN 13091			JEM	9/11/2018
C	PER ECN 12755			JEM	1/3/2018
B	PER ECN 5487			HN	6/6/2000

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]	APPROVALS	DATE
DO NOT SCALE PRINTS	DRAWN	JEM
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ ANGLES: $\pm 1/2^\circ$	CHECKED	5/18/2000
	QA	
	MFG	
	ENGINEER	
	APPROVED	HN



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TITLE			
CABLE ASSEMBLY PROCEDURE FOR 78-0020-1481			
SIZE	FSCM	DWG NO	REV
A	58167	78-0020-1481	F
SCALE	2:1	F.S.R. #	SHEET 1 OF 1