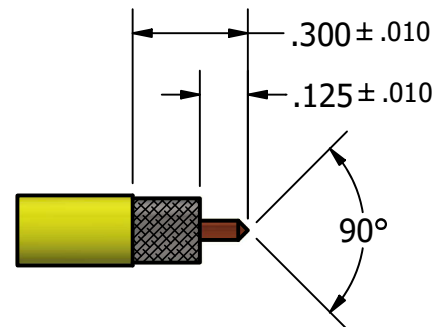


STEP 1

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

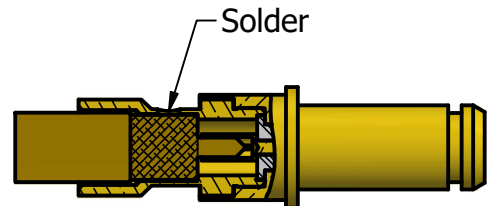
STEP 2

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
G	PER ECN 14600	EWM	3/30/2026	DRW	8/31/2026
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)	
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 JEM	5/18/2000
CHECKED	
QA	
MFG	
ENGINEER	
APPROVED HN	5/18/2000

The PHOENIX Company of Chicago, Inc.			
22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (800) 323-9562 FAX: (630) 206-1801			
TITLE CABLE ASSEMBLY PROCEDURE FOR 78-0020-1481			
SIZE A	FSCM 58167	DWG NO 78-0020-1481	REV G
SCALE 2:1	F.S.R. #	SHEET 1 OF 1	