

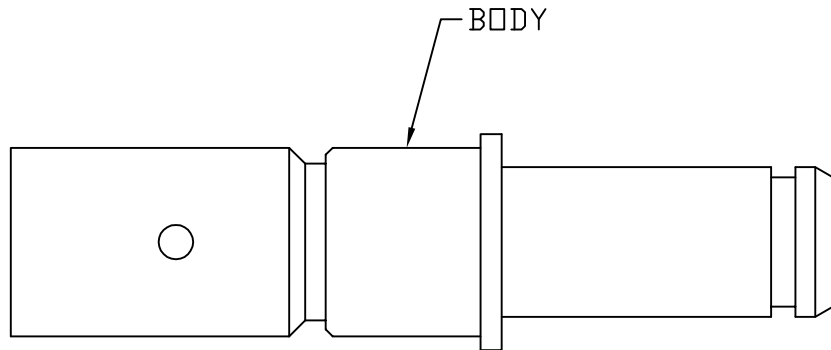
CABLE ASSEMBLY PROCEDURE	
P/N	78-0020-1911
PAGE 1 OF 1	DATE: 05/18/00
DRAWN: JEM	APPROVED: HN
FOR USE WITH IW 2301-C CABLE	

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REV	DESCRIPTION	DATE	APPR
A	REL. ECN 5473	05/18/00	HN
B	PER ECN 5487	06/06/00	HN
C	PER ECN 13091	09/11/18	JEM
D	PER ECN 13497	9/16/19	JEM

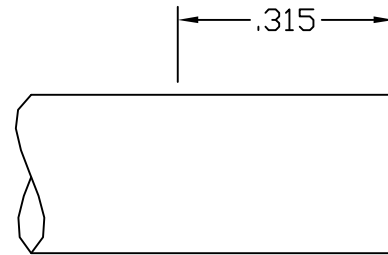
NOTES:

1) DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].



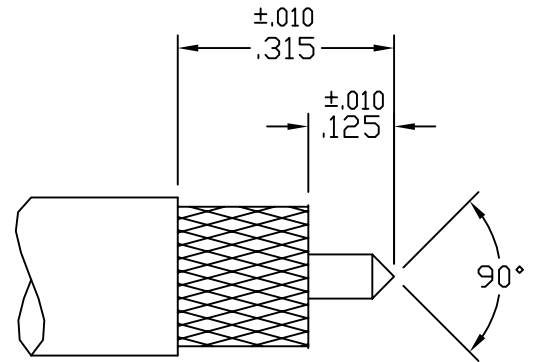
STEP 1

FLUX END OF CABLE. STICK CABLE INTO SOLDER POT TO DIMENSIONS SHOWN, FOR 7-10 SECONDS. (NOTE: SOLDER POT TEMPERATURE SHOULD BE 500°F)



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.

