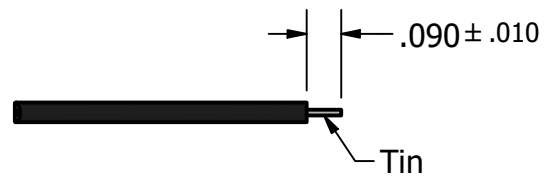


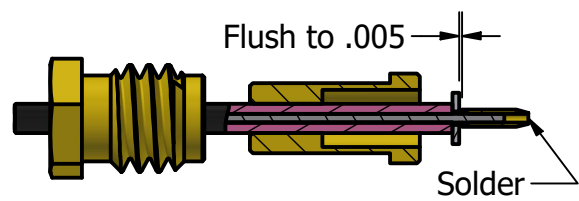
STEP 1

Trim cable to dimensions shown.
Tin dip center conductor only.



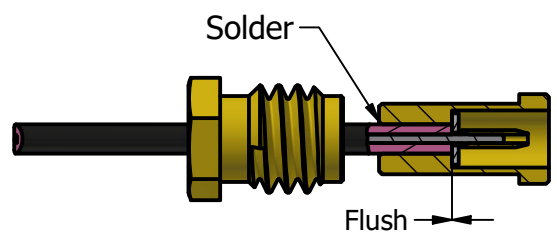
STEP 2

Slide clamp nut and solder ferrule onto cable.
Slide spacer and bullet over center conductor of cable so that spacer is flush against cable jacket.
Solder bullet to cable.
Clean solder joint.



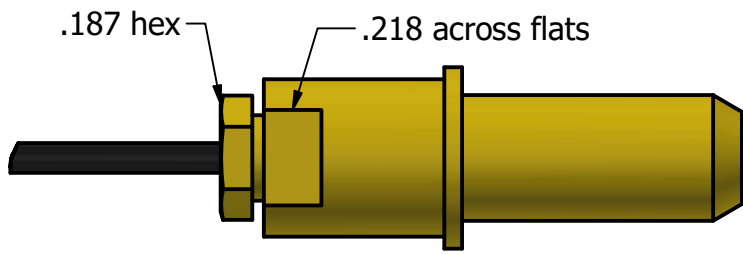
STEP 3

Slide solder ferrule over bullet spacer sub-assembly and solder at rear of ferrule.
Clean solder joint.



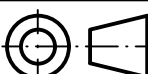
STEP 4

Insert cable assembly into sub-assembly and tighten clamp nut to 90-100 in-ozs.



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MATERIAL:				<div>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]</div> <div>DO NOT SCALE PRINTS</div> <div>TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°</div> <div></div>	APPROVALS	DATE
					DRAWN BGW	11/5/2019
					CHECKED JEM	11/5/2019
					QA	
					MFG	
D	PER ECN 14229	11/26/2024	DW		ENGINEER BGW	11/5/2019
C	Release Per ECN 13506	11/5/2019	BGW		APPROVED BGW	11/5/2019
B	Release Per ECN 11018	06/28/11	JEM			
A	Release Per ECN 6333	11/26/01	HN			
REV.	DESCRIPTION	DATE	APPR.			

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TITLE
**CABLE ASSEMBLY PROCEDURE
FOR 78-0030-0470**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-0030-0470	D	
SCALE	3:1	F.S.R. #	SHEET	1 OF 1