

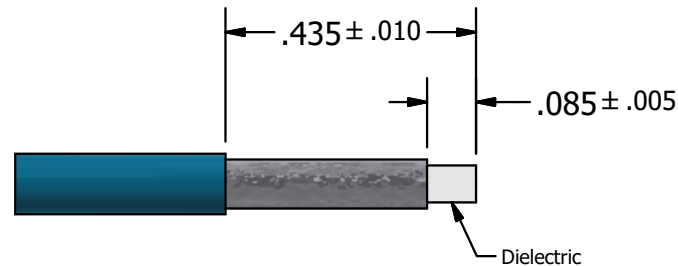
STEP 1 (PER CABLE TYPE)

***FOR FLEX CABLES: (Jacketed)**

Flux and Tin Dip Cable to dimension $.450 \pm .010$
 Trim Jacket to dimension - $.435 \pm .010$
 Trim Braid to dimension - $.085 \pm .005$

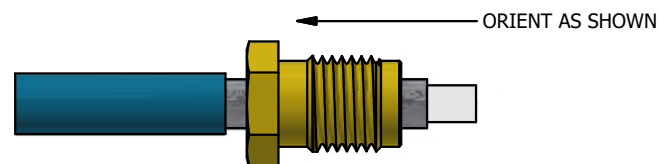
***FOR SEMI RIGID CABLES: (Non-Jacketed)**

Trim Outer Conductor to dimension - $.085 \pm .005$



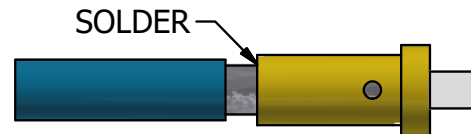
STEP 2

Slide the Clamp Nut over the Cable.
 Orient as shown.



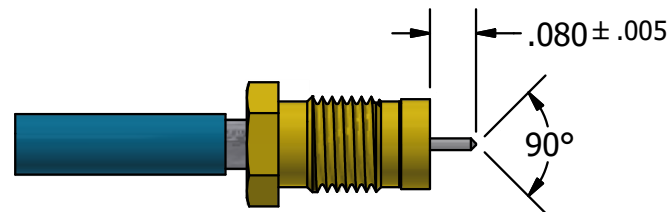
STEP 3

Insert Cable into Ferrule and Solder as shown.
 Clean solder joint.



STEP 4

Now Trim:
 -Dielectric completely.
 -Center Conductor Length: $.080 \pm .005$.

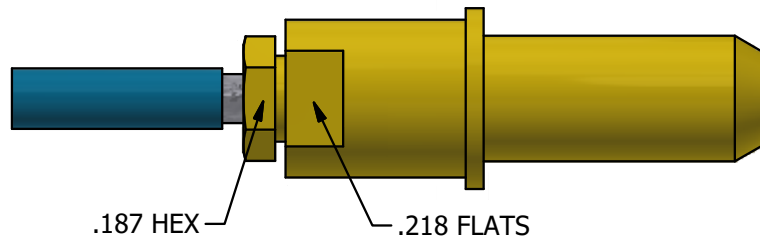


Point the Center Conductor.

Slide Clamp Nut into position as shown.

STEP 5

Screw body onto above cable assembly
 using $\frac{3}{16}$ & $\frac{7}{32}$ wrenches and tighten Clamp
 Nut to 90-100 in-oz.



WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

THE INFORMATION AND DESIGNS DISCLOSED IN THIS DOCUMENT ARE CONFIDENTIAL AND/OR PROPRIETARY TO THE PHOENIX COMPANY OF CHICAGO INC. AND MAY NOT BE USED FOR MANUFACTURING, REPRODUCED, DISCLOSED TO OTHERS OR FOR ANY OTHER PURPOSE WITHOUT THE EXPRESS WRITTEN CONSENT OF THE PHOENIX COMPANY OF CHICAGO INC.

MATERIAL:

REV	DESCRIPTION	BY	DATE	APPR.	DATE
F	PER ECN 14088	SPS	03/08/2022	SJG	03/08/2022
E	PER ECN 13452	CA	08/13/2019	HN	08/13/2019
D	PER ECN 11018	SS	06/28/2011	JEM	06/28/2011
C	PER ECN 10099	SS	12/03/2009	JEM	12/03/2009
B	PER ECN 6696	JEM	08/04/1998	HN	08/01/2002
A	PER ECN 4621	JEM	08/04/1998	HN	08/04/1998

Filename: ver2\Autodesk Inventor Data Base\Assemblies\78 Series\78-0030-0860-CAP.idw 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 DRAWN JEM 08/04/1998 CHECKED HN 08/04/1998 QA MFG ENGINEER JEM 08/04/1998 APPROVED HN 08/04/1998	DATE 08/04/1998 08/04/1998
---	--	--	----------------------------------

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 78-0030-0860

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-0030-0860	F	

SCALE 3 : 1 F.S.R. # SHEET 1 OF 1