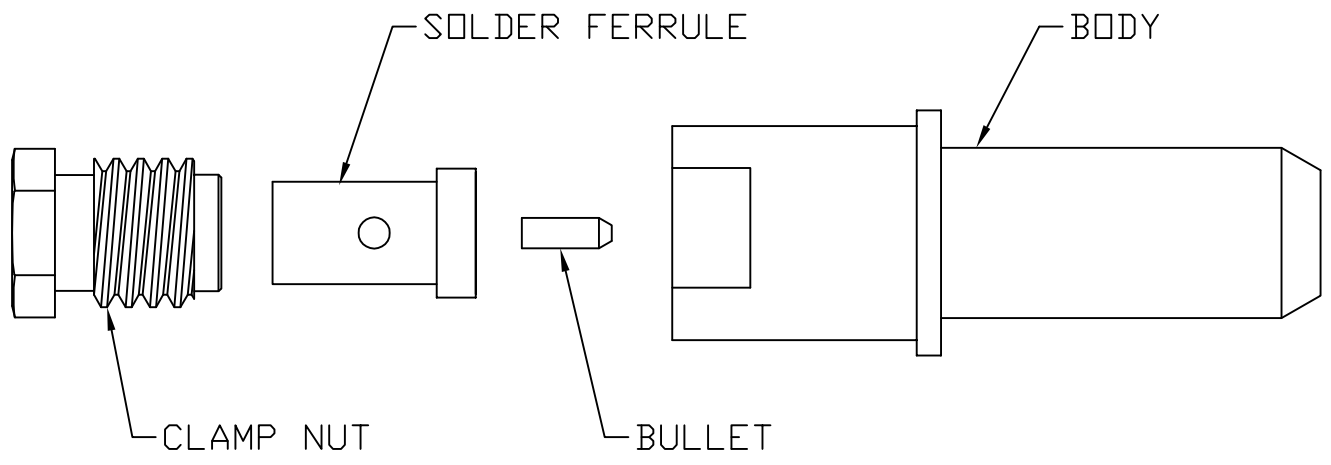


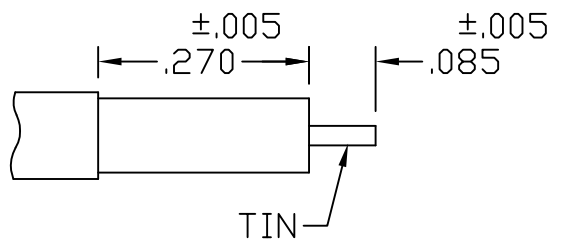
CABLE ASSEMBLY PROCEDURE	
P/N	78-0030-0861
PAGE 1 OF 1	DATE: 08/05/02
DRAWN: YT	APPROVED: HN
FOR USE WITH 21-1006-001 CABLE	

The **PHOENIX** Company of Chicago™  
 22 GREAT HILL RD., NAUGATUCK, CT 06770  
 WWW.PHOENIXOFCHICAGO.COM  
 PHONE: (203) 729-9090 FAX: (203) 723-1794

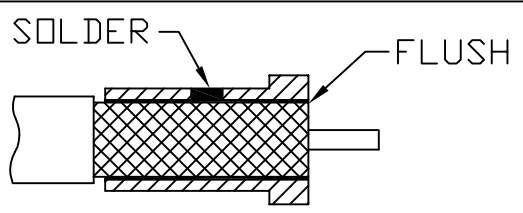
REV	DESCRIPTION	DATE	APPR
A	REL. ECN 6700	08/06/02	HN
B	PER ECN 11018	06/28/11	JEM
C	PER ECN 13508	9/20/19	JEM



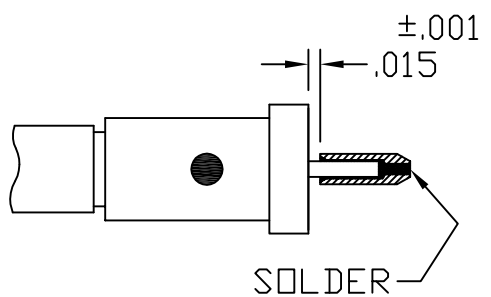
STEP 1  
 TRIM CABLE TO DIMENSIONS SHOWN.  
 TIN DIP CENTER CONDUCTOR ONLY.



STEP 2  
 SLIDE CLAMP NUT AND SOLDER FERRULE  
 ONTO CABLE. SET COUNTERBORE IN  
 SOLDER FERRULE FLUSH WITH CABLE  
 AND SOLDER. CLEAN SOLDER JOINT.



STEP 3  
 SLIDE SPACER AND BULLET OVER CENTER  
 CONDUCTOR OF CABLE. SOLDER BULLET  
 TO CABLE. CLEAN SOLDER JOINT.



STEP 4  
 INSERT CABLE ASSEMBLY INTO  
 BODY AND TIGHTEN CLAMP  
 NUT TO 90-100 IN-OZS.

