

STEP 1 (PER CABLE TYPE)

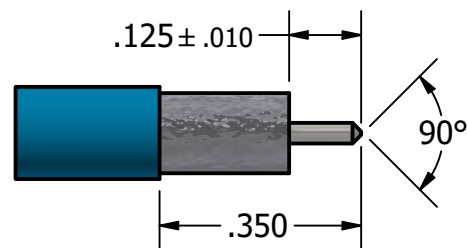
*FOR FLEX CABLES: (Jacketed)

Flux and Tin Dip Cable to dimension

.400±.010

Trim Jacket to dimension - .350±.010

Trim Braid to dimension - .125±.010



*FOR SEMI RIGID CABLES:

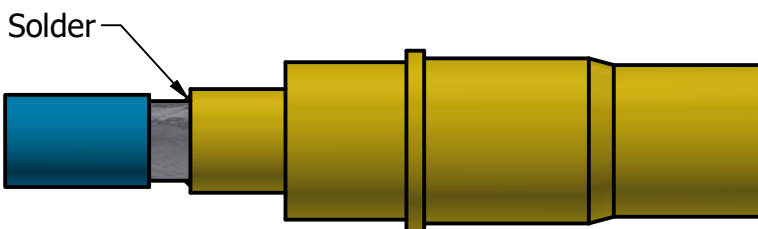
(Non-Jacketed)

Trim Outer Conductor to dimension -

.125±.010

STEP 2

Insert Cable into back of Body and solder Tube to Connector as shown. Clean Solder joint.



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.

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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
D	PER ECN 14233	RA	10/7/2024	DW	11/26/2024
C	PER ECN 13468			JEM	8/22/2019
B	PER ECN 12956			JEM	5/24/2018
A	PER ECN 10074			JEM	11/3/2009

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]	
DO NOT SCALE PRINTS	
TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003	
ANGLES: ± 1/2°	

APPROVALS	DATE
DRAWN	MS
CHECKED	
QA	
MFG	
ENGINEER	
APPROVED	JEM
	11/3/2009

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 78-1020-1410			
SIZE	FSCM	DWG NO	REV
A	58167	78-1020-1410	D
SCALE	3:1	F.S.R. #	SHEET 1 OF 1