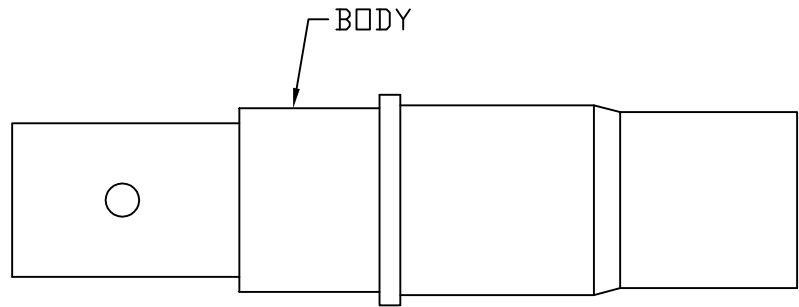


CABLE ASSEMBLY PROCEDURE	
P/N	78-1020-1412
PAGE 1 OF 1	DATE: 09/18/98
DRAWN: JEM	APPROVED: HN
FOR USE WITH HARBOUR LL142 CABLE	

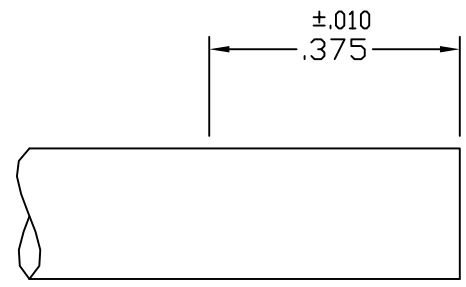
The **PHOENIX** Company of Chicago™  
 22 GREAT HILL RD., NAUGATUCK, CT 06770  
 WWW.PHOENIXOFCHICAGO.COM  
 PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
B	PER ECN 5534	07/18/00	HN
C	PER ECN 9415	06/02/08	JEM
D	PER ECN 9687	12/09/08	JEM
E	PER ECN 13519	10/3/19	JEM



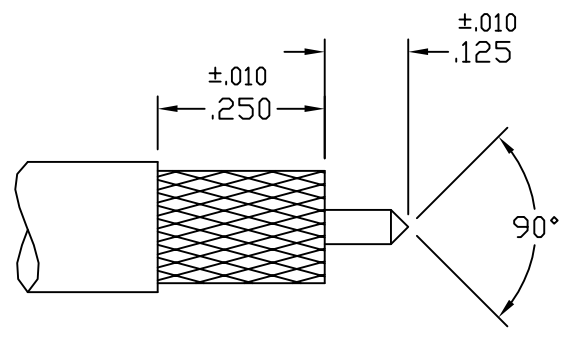
STEP 1

FLUX END OF CABLE. STICK CABLE INTO SOLDER POT TO DIMENSION SHOWN, FOR 3 SECONDS MAX.



STEP 2

TRIM CABLE TO DIMENSIONS SHOWN. POINT CENTER CONDUCTOR.



STEP 3

INSERT CABLE INTO BACK OF BODY AND SOLDER BRAID TO CONNECTOR THROUGH SIDE HOLE AND CLEAN SOLDER JOINT.

