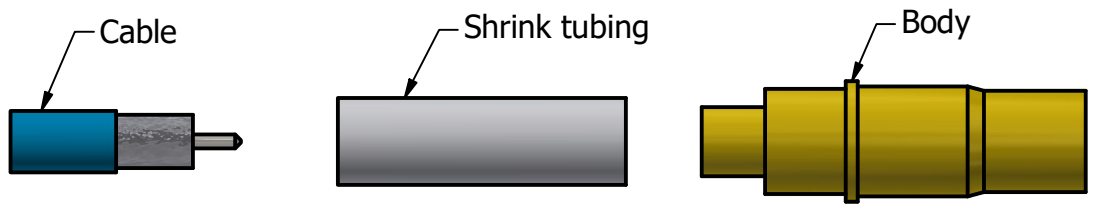


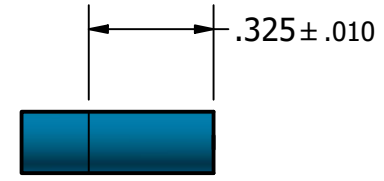
2

1



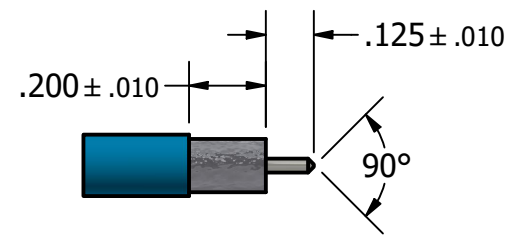
**STEP 1**

Flux end of Cable. Stick Cable into Solder Pot to dimension shown, for 3 seconds maximum.



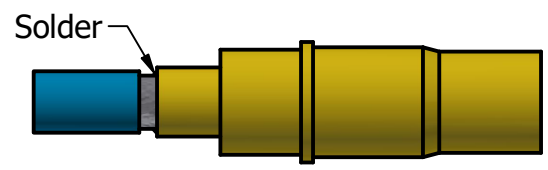
**STEP 2**

Trim Cable to dimensions shown. Point Center Conductor. Slide Shrink Tubing over Cable.



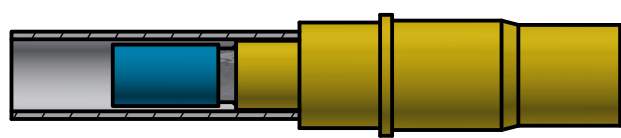
**STEP 3**

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



**STEP 4**

Slide Shrink Tubing into position over Body and shrink in place.



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**MATERIAL:**

| E    | PER ECN 14233 | RA | 10/8/2024 | DW    | 11/26/2024 |
|------|---------------|----|-----------|-------|------------|
| D    | PER ECN 13522 |    |           | JEM   | 10/3/2019  |
| C    | PER ECN 9686  |    |           | JEM   | 12/9/2008  |
| B    | PER ECN 5534  |    |           | JEM   | 7/18/2000  |
| A    | PER ECN 4696  |    |           | HN    | 9/18/1998  |
| REV. | DESCRIPTION   | BY | DATE      | APPR. | DATE       |

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      | DATE      |
|----------------|-----------|
| DRAWN<br>JEM   | 9/18/1998 |
| CHECKED        |           |
| QA             |           |
| MFG            |           |
| ENGINEER       |           |
| APPROVED<br>HN | 9/18/1998 |

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TITLE  
**CABLE ASSEMBLY PROCEDURE FOR 78-1020-1413**

|                  |               |                        |          |              |
|------------------|---------------|------------------------|----------|--------------|
| SIZE<br><b>A</b> | FSCM<br>58167 | DWG NO<br>78-1020-1413 | REV<br>E | PLATING OPT. |
| SCALE<br>2:1     | F.S.R. #      | SHEET 1 OF 1           |          |              |

2

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