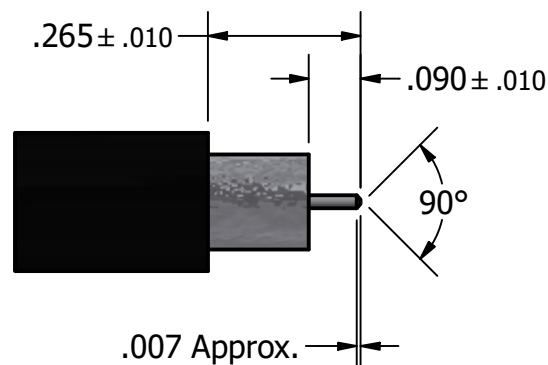


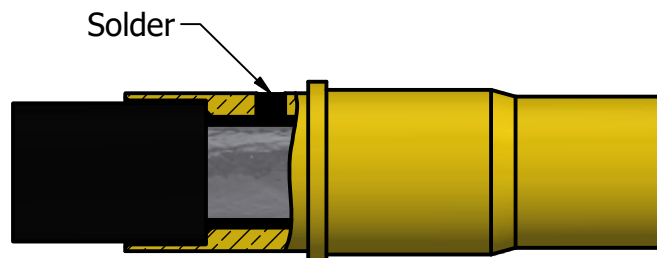
STEP 1

Dip end of Cable into Flux and then into a Solder Pot (Kester 60/40) maintained at 500°F to a depth of .715 for 3 seconds maximum. Trim Cable to dimensions shown.



STEP 2

Insert Cable into Connector as shown until Cable bottoms in Connector. Solder Body to Cable and clean Solder joint.

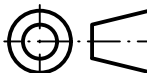


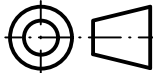
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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
E	PER ECN 14326	RA	10/22/2024	DW	11/26/2024
D	PER ECN 13523			JEM	10/8/2019
C	PER ECN 9685			JEM	12/8/2008
B	PER ECN 5534			HN	7/18/2000
A	PER ECN 5167			HN	7/29/1999

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: $\pm 1/2^\circ$			
			



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CABLE ASSEMBLY PROCEDURE FOR 78-1020-1480

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-1020-1480	E	
SCALE	3 : 1	F.S.R. #	SHEET	1 OF 1