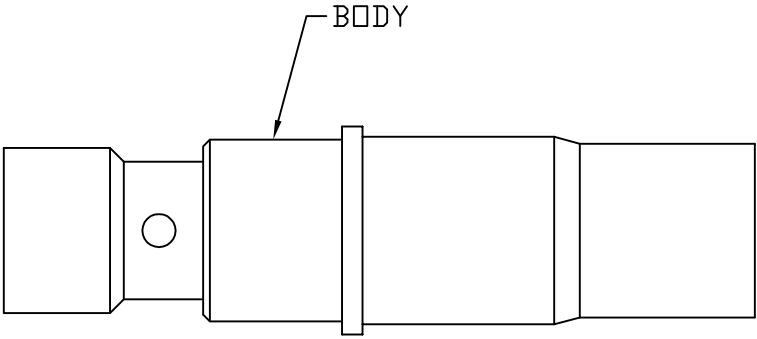
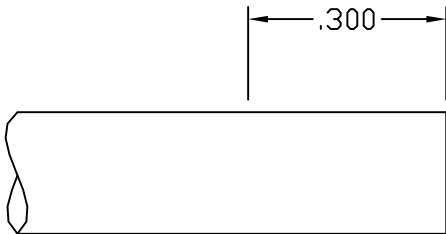


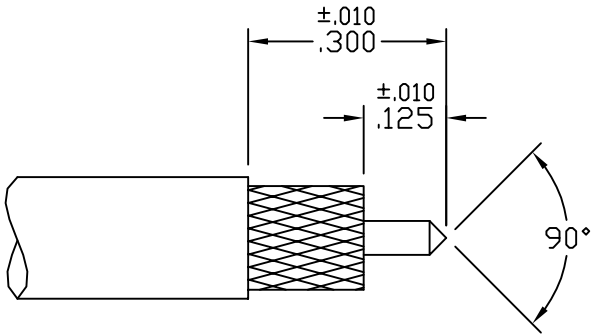
CABLE ASSEMBLY PROCEDURE		<i>The PHOENIX Company of Chicago™</i> 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM PHONE: (203) 729-9090 FAX: (203) 723-1794	REV	DESCRIPTION	DATE	APPR
P/N	78-1020-1481		B	PER ECN 5487	06/06/00	HN
PAGE 1 OF 1	DATE: 05/18/00		C	PER ECN 9684	12/08/08	JEM
DRAWN: JEM	APPROVED: HN		D	PER ECN 12755	01/03/18	JEM
FOR USE WITH IW 1801-C CABLE			E	PER ECN 13529	10/14/19	JEM



STEP 1  
 FLUX END OF CABLE. STICK CABLE INTO  
 SOLDER POT TO DIMENSIONS SHOWN, FOR  
 3 SECONDS MAX.



STEP 2  
 TRIM CABLE TO DIMENSIONS  
 SHOWN. POINT CENTER CONDUCTOR.



STEP 3  
 SLIDE CONNECTOR ONTO CABLE  
 UNTIL CABLE BOTTOMS IN  
 BODY. SOLDER BODY TO CABLE  
 BRAID THRU SIDE HOLE.  
 CLEAN SOLDER JOINT.

