



STEP 1

Flux end of cable, Stick cable into solder pot to dimensions shown, for 3 seconds maximum.

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.

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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
F	PER ECN 14232	BAK	10/14/2024	DW	11/26/2024
E	PER ECN 13529			JEM	10/14/2019
D	PER ECN 12755			JEM	1/3/2018
C	PER ECN 9684			JEM	12/8/2008
B	PER ECN 5487			HN	6/6/2000

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]	
DO NOT SCALE PRINTS	
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ ANGLES: $\pm 1/2^\circ$	

APPROVALS	DATE
DRAWN JEM	5/18/2000
CHECKED QA	
MFG	
ENGINEER	
APPROVED HN	5/18/2000

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TITLE CABLE ASSEMBLY PROCEDURE FOR 78-1020-1481					
SIZE A	FSCM 58167	DWG NO 78-1020-1481	REV F	PLATING OPT.	
SCALE 2:1	F.S.R. #	SHEET 1 OF 1			