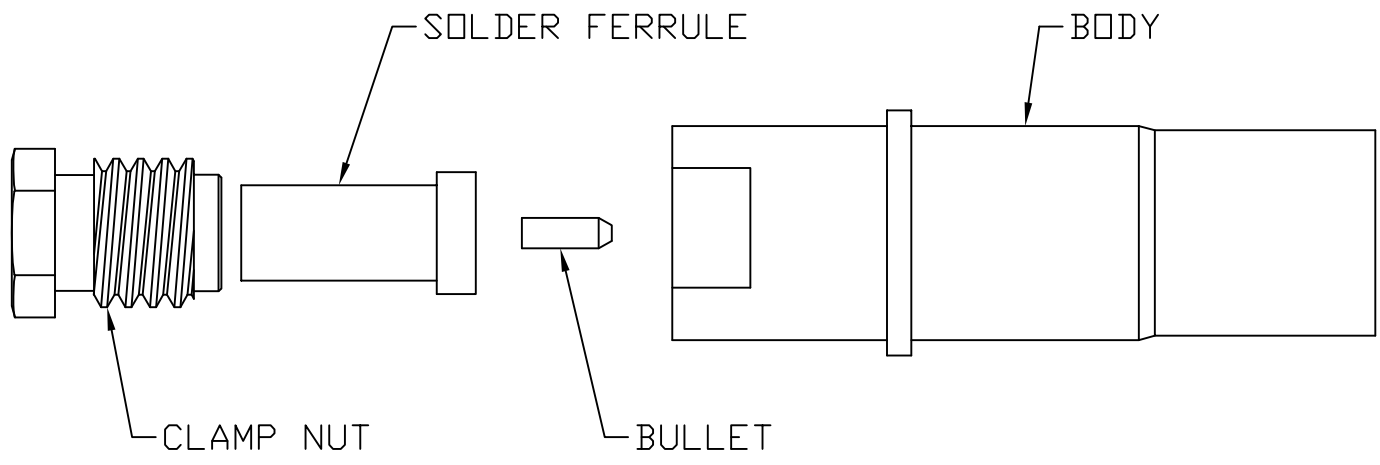


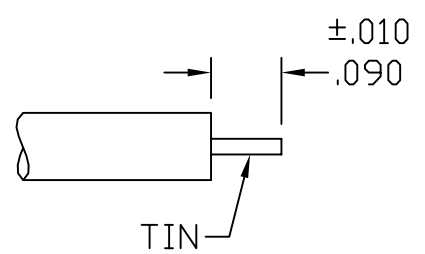
CABLE ASSEMBLY PROCEDURE	
P/N	78-1030-0860
PAGE 1 OF 1	DATE: 08/06/98
DRAWN: JEM	APPROVED: HN
FOR USE WITH M17/133 CABLE	

The **PHOENIX** Company of Chicago™
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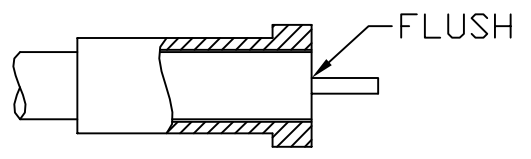
REV	DESCRIPTION	DATE	APPR
B	PER ECN 5535	07/18/00	HN
C	PER ECN 9682	12/08/08	JEM
D	PER ECN 11021	06/28/11	JEM
E	PER ECN 13482	9/4/19	JEM



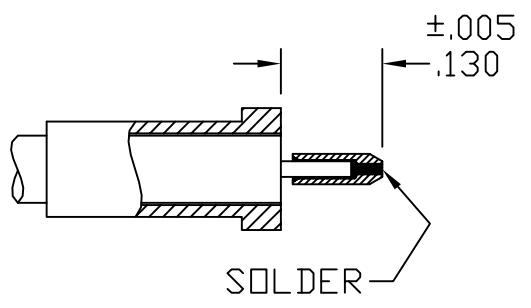
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN DIP CENTER CONDUCTOR ONLY.



STEP 2
 SLIDE CLAMP NUT AND SOLDER FERRULE
 ONTO CABLE. SET COUNTERBORE IN
 SOLDER FERRULE FLUSH WITH CABLE
 AND SOLDER. CLEAN SOLDER JOINT.



STEP 3
 SLIDE SPACER AND BULLET OVER CENTER
 CONDUCTOR OF CABLE. SOLDER BULLET
 TO CABLE. CLEAN SOLDER JOINT.



STEP 4
 INSERT CABLE ASSEMBLY INTO
 BODY AND TIGHTEN CLAMP
 NUT TO 90-100 IN-OZS.

