

STEP 1 (PER CABLE TYPE)

***FOR FLEX CABLES: (Jacketed)**

- Flux and Tin Dip Cable to dimension $.450 \pm .010$
- Trim Jacket to dimension $-.405 \pm .010$
- Trim Braid to dimension $-.085 \pm .005$

***FOR SEMI RIGID CABLES: (Non-Jacketed)**

- Trim Outer Conductor to dimension $-.085 \pm .005$

STEP 2

Slide the Clamp Nut over the Cable.
Orient as shown.

STEP 3

Insert Cable into Ferrule and Solder as shown.
Clean solder joint.

STEP 4

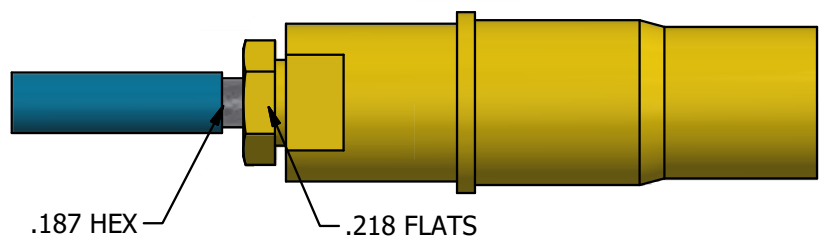
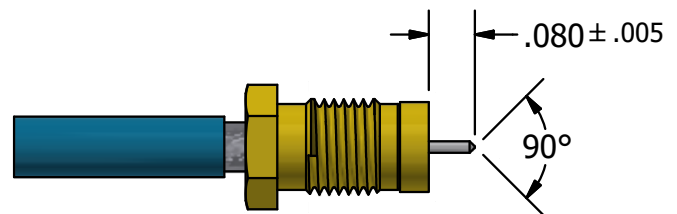
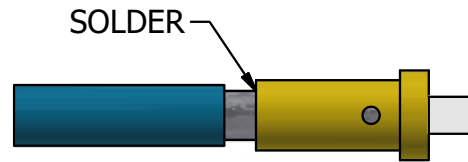
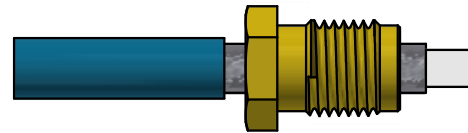
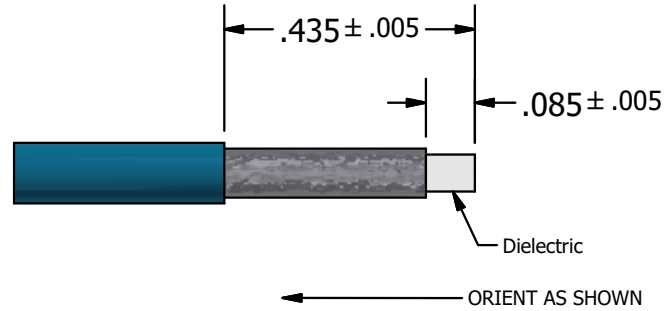
- Now Trim:
- Dielectric completely.
 - Center Conductor Length: $.080 \pm .005$.

Point the Center Conductor.

Slide Clamp Nut into position as shown.

STEP 5

Screw Body onto above cable assembly
using $\frac{3}{16}$ & $\frac{7}{32}$ wrenches and tighten Clamp
Nut to 90-100 in-oz.



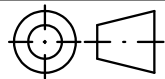
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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
F	PER ECN 14088	SPS	3/14/2022	SJG	3/14/2022
E	PER ECN 13482	CA	9/4/2019	JEM	9/4/2019
D	PER ECN 11021	SS	06/28/11	JEM	06/28/11
C	PER ECN 9682	SS	12/08/08	JEM	12/08/08
B	PER ECN 5535	JEM	07/18/00	HN	07/18/00
A	PER ECN 4621	JEM	08/04/98	HN	08/04/98

Filename: ver2\Autodesk Inventor Data Base\Assemblies\78 Series\78-1030-0860-CAP.ipt 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 DRAWN JEM 08/04/1998 CHECKED HN 08/04/1998 QA MFG ENGINEER JEM 08/04/1998 APPROVED HN 08/04/1998	DATE 08/04/1998 08/04/1998
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TITLE
CABLE ASSEMBLY PROCEDURE FOR 78-1030-0860

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-1030-0860	F	

SCALE 3 : 1 F.S.R. # SHEET 1 OF 1