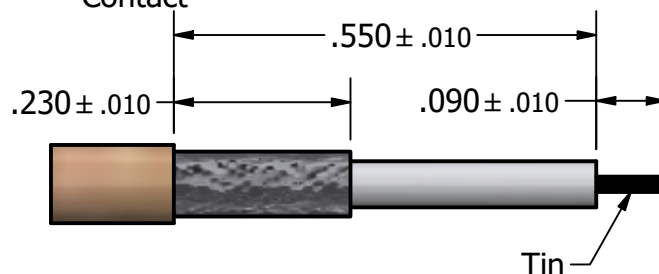
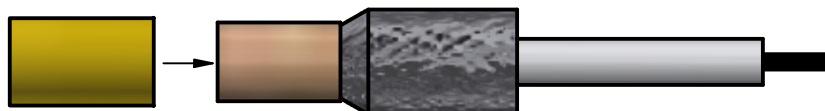
**STEP 1**

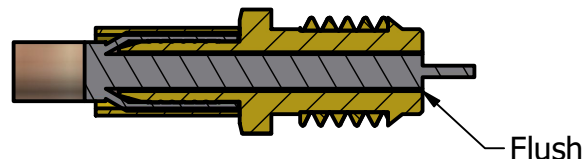
Trim Cable to dimensions shown.
Tin Center Conductor and clean
solder joint.

**STEP 2**

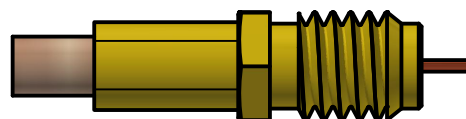
Slide Ferrule over Cable and
flare Braid by rotating Dielectric.

**STEP 3**

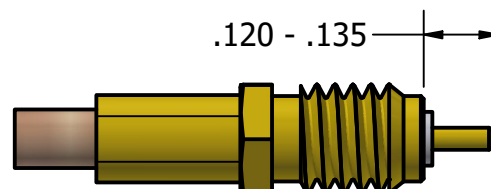
Insert the Barrel of the Crimp Nut between
the Braid and Dielectric, positioned so that
the end of the Cable Dielectric is flush with
the end of the Crimp Nut.

**STEP 4**

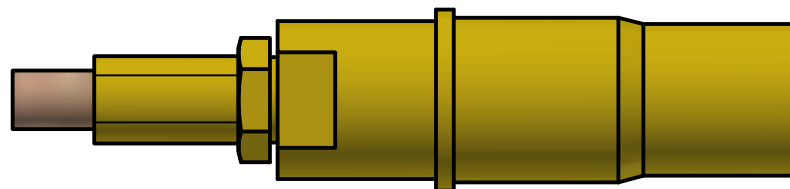
Slide the Ferrule against the shoulder
of the Crimp Nut and crimp using .128
Hex Die (M22520/5-03).

**STEP 5**

Place the Spacer against the Crimp Nut.
Slide the Bullet over the Center Conductor.
Using Resistance Soldering Tweezers, apply
heat to the Bullet to reflow the Solder. Clean
Solder joint.

**STEP 6**

Thread Connector Body onto the Crimp Nut
Assembly. Tighten to 7-10 IN-LBS.



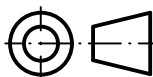
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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
G	PER ECN 14326	RA	10/22/2024	DW	11/26/2024
F	PER ECN 13489			JEM	9/11/2019
E	PER ECN 12958			JEM	5/24/2018
D	PER ECN 10928			JEM	4/11/2011
C	PER ECN 9681			JEM	12/8/2008

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]	APPROVALS	DATE
DO NOT SCALE PRINTS	DRAWN YT	7/22/2003
TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003	CHECKED	
ANGLES: ± 1/2°	QA	
	MFG	
	ENGINEER	
	APPROVED HN	7/22/2003

**The PHOENIX Company of Chicago, Inc.**

22 GREAT HILL RD., NAUGATUCK, CT 06770
WWW.PHOENIXOFCHICAGO.COM
PHONE: (800) 323-9562 FAX: (630) 206-1801

**CABLE ASSEMBLY PROCEDURE
FOR 78-1080-0670**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-1080-0670	G	
SCALE	3 : 1	F.S.R. #	SHEET	1 OF 1