

CABLE ASSEMBLY PROCEDURE

P/N 78-1080-1082

PAGE 1 OF 1

DATE: 04/05/10

DRAWN: MS

APPROVED: JEM

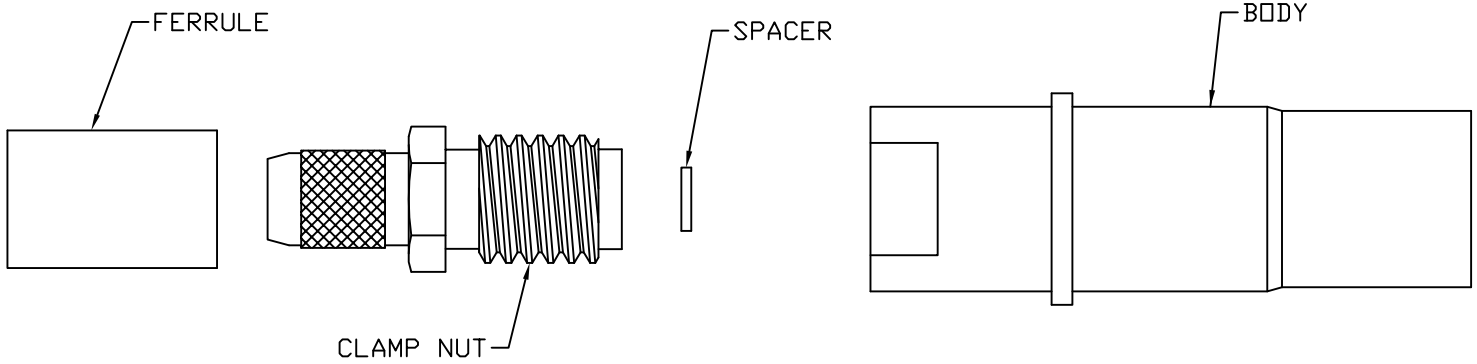
FOR SUHNER S_02162_B CABLE

The *PHOENIX* Company of Chicago™

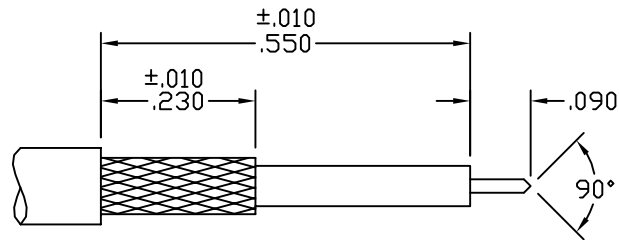
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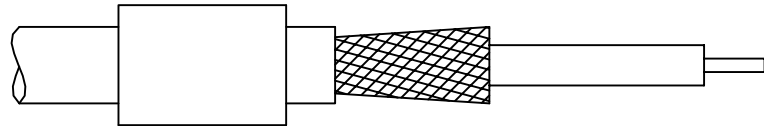
REV	DESCRIPTION	DATE	APPR
B	PER ECN 10406	06/04/10	JEM
C	PER ECN 10596	09/08/10	MS
D	PER ECN 13531	10/15/19	JEM



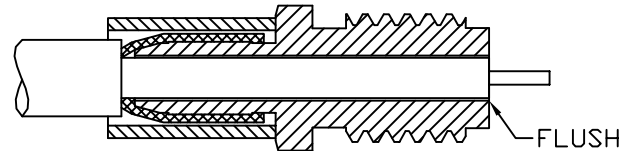
STEP 1
TRIM CABLE TO DIMENSIONS SHOWN.
POINT CENTER CONDUCTOR AS SHOWN.



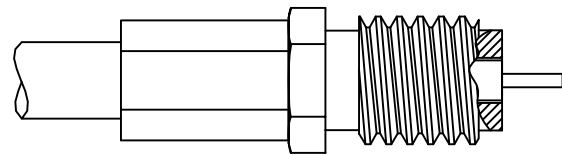
STEP 2
SLIDE FERRULE OVER CABLE
AND FLAIR BRAID BY ROTATING
DIELECTRIC.



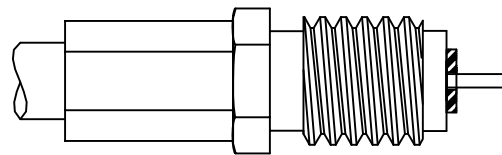
STEP 3
INSERT THE BARREL OF THE CRIMP NUT BETWEEN
THE BRAID AND DIELECTRIC, POSITIONED SO THAT
THE END OF THE CABLE DIELECTRIC IS FLUSH
WITH THE END OF THE CRIMP NUT.



STEP 4
SLIDE THE FERRULE AGAINST THE SHOULDER
OF THE CRIMP NUT AND CRIMP USING .178 HEX
DIE (M22520/5-05).



STEP 5
PLACE THE SPACER AGAINST THE CRIMP
NUT.



STEP 6
THREAD CONNECTOR BODY ONTO
THE CRIMP NUT ASSEMBLY,
TIGHTEN TO 7-10 IN-LBS.

