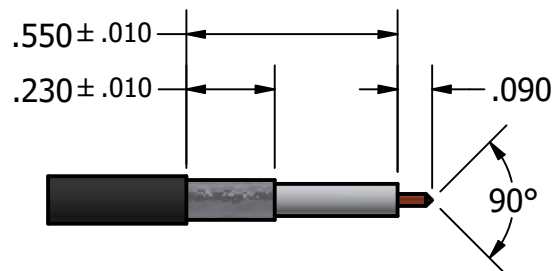
**STEP 1**

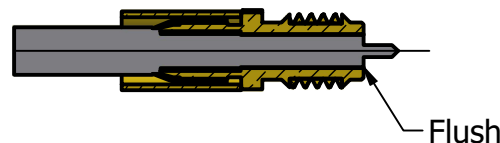
Trim cable to dimensions shown.
Point center conductor as shown

**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**

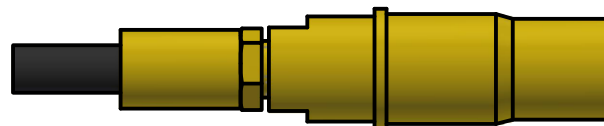
Slide the ferrule against the shoulder of the crimp nut and crimp using .178 hex die (M22520/5-05).

**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.



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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
E	PER ECN 14232	BAK	9/30/2024	DW	11/27/2024
D	PER ECN 13531			JEM	10/15/2019
C	PER ECN 10596			MS	9/8/2010
B	PER ECN 10406			JEM	6/4/2010

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	DATE
DRAWN	MS
CHECKED	
QA	
MFG	
ENGINEER	
APPROVED	JEM
	4/5/2010

The PHOENIX Company of Chicago, Inc.			
22 GREAT HILL RD., NAUGATUCK, CT 06770			
WWW.PHOENIXOFCHICAGO.COM			
PHONE: (800) 323-9562 FAX: (630) 206-1801			
TITLE			
CABLE ASSEMBLY PROCEDURE FOR 78-1080-1082			
SIZE	FSCM	DWG NO	REV
A	58167	78-1080-1082	E
SCALE	2:1	F.S.R. #	SHEET 1 OF 1