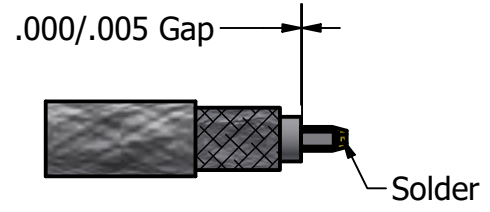


**STEP 1**

Trim cable to dimensions shown.

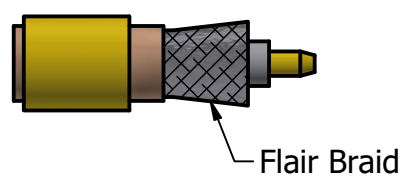
**STEP 2**

Tin cable center conductor.  
Solder bullet onto center contact.  
Clean solder joint.



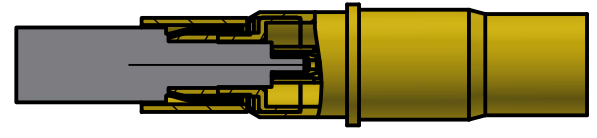
**STEP 3**

Slide solder ferrule over cable and flair braid by rotating the cable dielectric.



**STEP 4**

Slide cable into back of connector until cable bottoms. Slide ferrule into position and crimp using a .213 hex die (M22520/5-05).



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UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR [METRIC]				APPROVALS	DATE
DO NOT SCALE PRINTS				DRAWN	12/12/2001
TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003				CHECKED	
ANGLES: ± 1/2°				QA	
F	PER ECN 14463	11/26/2024	DW	MFG	
E	PER ECN 13536	10/17/19		ENGINEER	
D	PER ECN 9680	12/08/08	BGW	APPROVED	
C	PER ECN 6604	5/06/02	JEM	HN	12/12/2001
B	PER ECN 6516	2/25/02	HN		
REV.	DESCRIPTION	DATE	APPR.	SCALE	2:1
				F.S.R. #	1
				SHEET	1 OF 1