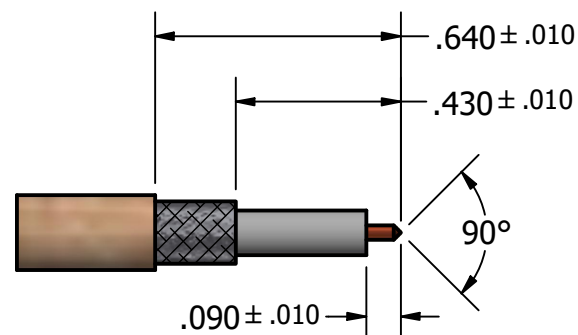
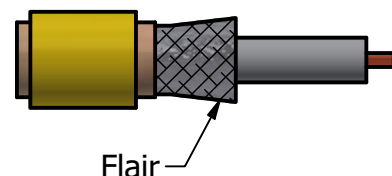
**STEP 1**

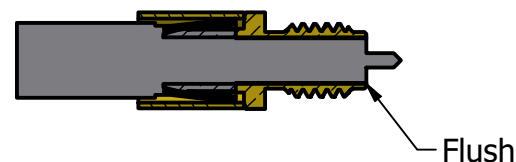
Trim cable to dimensions shown.
Point center conductor.

**STEP 2**

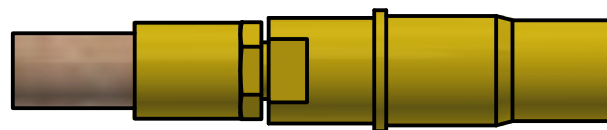
Slide ferrule over cable and flair braid by rotating cable dielectric.

**STEP 3**

Slide crimp nut over cable dielectric and under braid, be sure crimp nut is flush with cable dielectric.
Slide ferrule up against shoulder of crimp nut using .213 hex die (M22520/5-05).

**STEP 4**

Insert prepared cable assembly into back of body and torque crimp nut to 7-10 in-lbs.



WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

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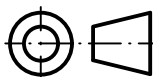
MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
E	PER ECN 14232	BAK	10/22/2024	DW	11/27/2024
D	PER ECN 13538			JEM	10/17/2019
C	PER ECN 11420			JEM	8/23/2012
B	PER ECN 9818			JEM	2/26/2009
A	PER ECN 4836			HN	12/18/1998

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY
DIMENSIONS IN INCHES OR [METRIC]

DO NOT SCALE PRINTS

TOLERANCES ARE:
FRACTIONS: $\pm 1/64$
DECIMALS: $.XX \pm .01$
ANGLES: $\pm 1/2^\circ$

**APPROVALS****DATE**

DRAWN

JEM

12/18/2019

CHECKED

QA

MFG

ENGINEER

APPROVED

HN

12/18/1998

The PHOENIX Company of Chicago, Inc.

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TITLE

**CABLE ASSEMBLY PROCEDURE
FOR 78-1080-2201**

SIZE

A

FSCM

58167

DWG NO

78-1080-2201

REV

E

PLATING OPT.

SCALE

2:1

F.S.R. #

SHEET

1

OF 1