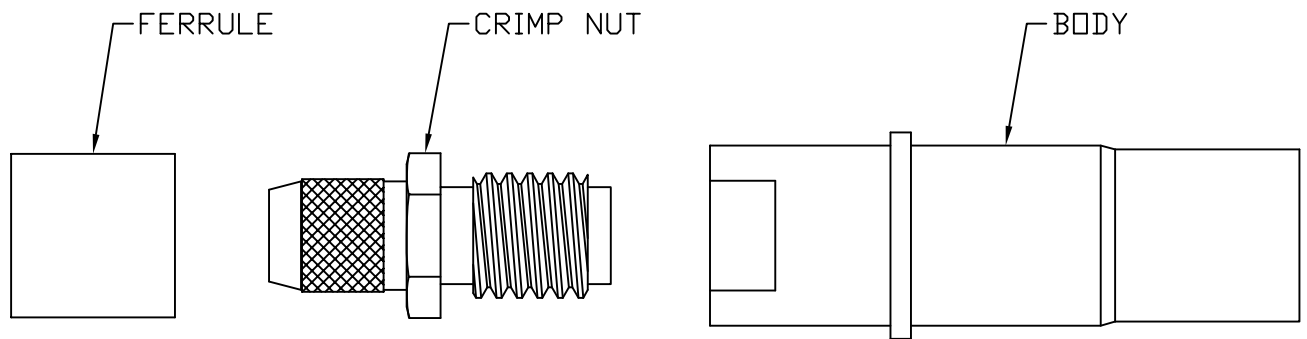


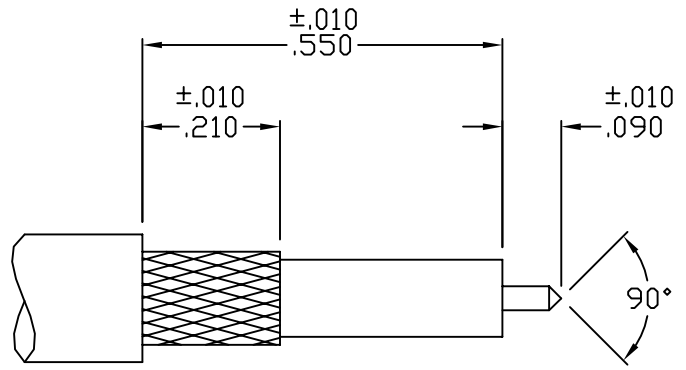
CABLE ASSEMBLY PROCEDURE	
P/N	78-1080-2202
PAGE 1 OF 1	DATE: 06/08/00
DRAWN: YT	APPROVED: HN
FOR USE WITH SF-142B CABLE	

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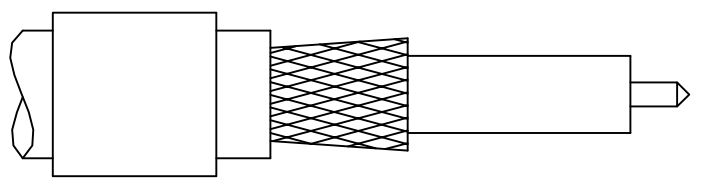
REV	DESCRIPTION	DATE	APPR
A	REL. ECN 5496	06/08/00	HN
B	PER ECN 9679	12/08/08	JEM
C	PER ECN 11581	02/13/13	JEM
D	PER ECN 13539	10/18/19	JEM



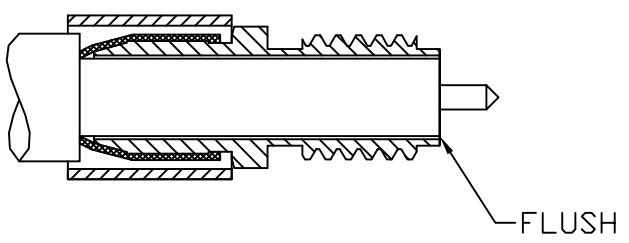
STEP 1
 STRIP CABLE TO DIMENSIONS SHOWN, POINT CENTER CONDUCTOR.



STEP 2
 SLIDE FERULE OVER CABLE. LIFT UP OUTER BRAID, DO NOT BRUSH UP THE STRANDS LONGITUDINALLY. CUT THE TAPE, BRING OUTER BRAID BACK. FLAIR INNER AND OUTER BRAID BY ROTATING 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 AND CRIMP USING .213 HEX DIE (M22520/5-05).



STEP 4
 INSERT PREPARED CABLE ASSEMBLY INTO BACK OF BODY AND TORQUE CRIMP NUT TO 7-10 INCH-LBS.

