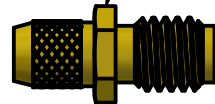


Cable



Ferrule



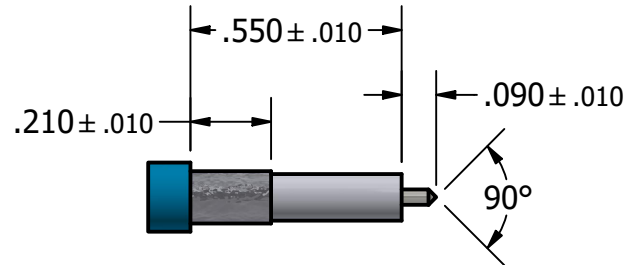
Crimp Nut



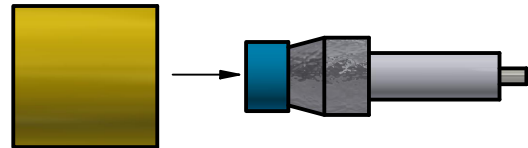
Body

STEP 1

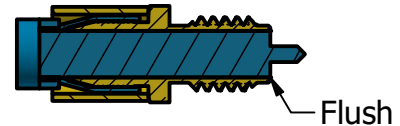
Strip Cable to dimensions shown.
Point Center Conductor.

**STEP 2**

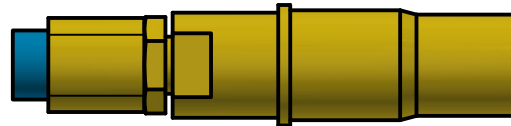
Slide Ferrule over Cable. Lift up
Outer Braid, do not brush up the
strands longitudinally. Cut the Tape,
bring Outer Braid back. Flair Inner
and Outer Braid by rotating Dielectric.

**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.



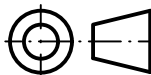
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MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
E	PER ECN 14331	RA	10/25/2024	DW	11/27/2024
D	PER ECN 13539			JEM	10/18/2019
C	PER ECN 11581			JEM	2/13/2013
B	PER ECN 9679			JEM	12/8/2008
A	REL ECN 5496			HN	6/8/2000

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]	APPROVALS	DATE
DO NOT SCALE PRINTS	DRAWN YT	6/8/2000
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ ANGLES: $\pm 1/2^\circ$	CHECKED	
	QA	
	MFG	
	ENGINEER	
	APPROVED HN	6/8/2000

**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 78-1080-2202**

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-1080-2202	E	
SCALE	2 : 1	F.S.R. #	SHEET	1 OF 1