

CABLE ASSEMBLY PROCEDURE

P/N 78-1080-2203

PAGE 1 OF 1

DATE: 09/23/10

DRAWN: MS

APPROVED: JEM

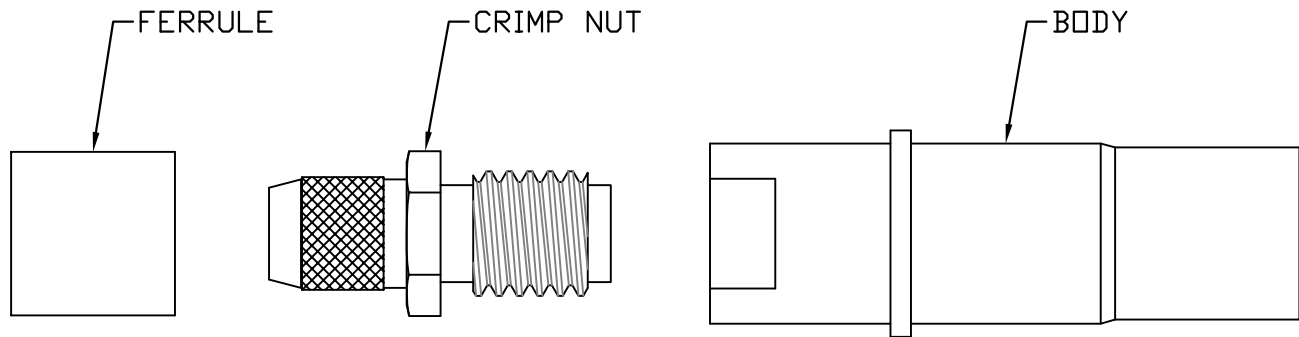
FOR USE WITH SFT-142B CABLE

The *PHOENIX* Company of Chicago™

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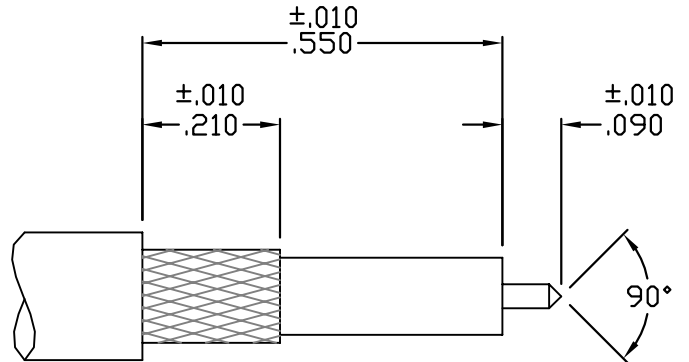
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REV	DESCRIPTION	DATE	APPR
A	PER ECN 10901	03/22/11	JEM
B	PER ECN 11642	04/17/11	JEM
C	PER ECN 12958	05/24/18	JEM
D	PER ECN 13483	9/4/19	JEM



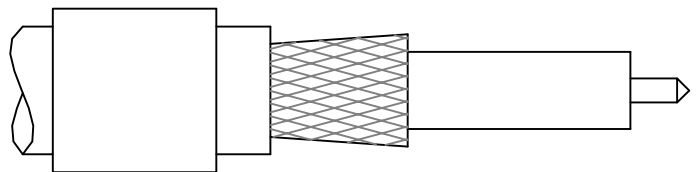
STEP 1

STRIP CABLE TO DIMENSIONS SHOWN, POINT CENTER CONDUCTOR.



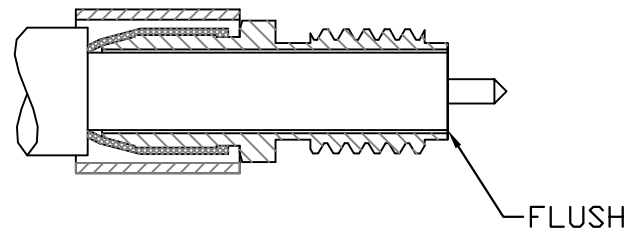
STEP 2

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 (M2520/5-05).



STEP 4

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

