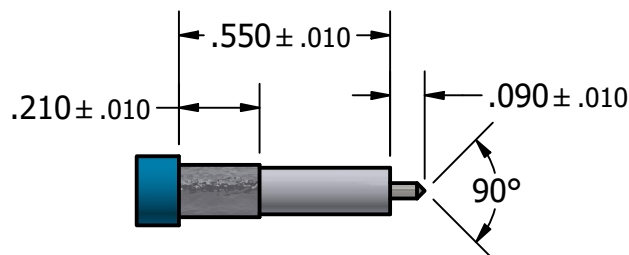


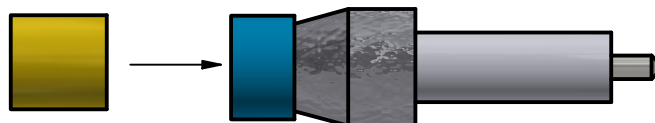
### STEP 1

Strip Cable to dimensions shown.  
Point Center Conductor.



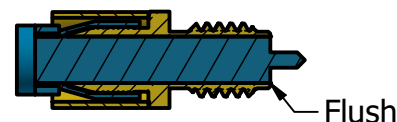
### STEP 2

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.



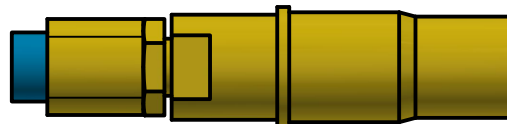
### STEP 3

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.



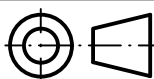
WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS  
EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF  
1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT  
TO SEVERE CRIMINAL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

The information and designs disclosed in this document are confidential and/or proprietary to  
The Phoenix Company of Chicago, Inc. and may not be used for manufacturing, reproduced,  
disclosed to others, or used for any other purpose without express written consent of The  
Phoenix Company of Chicago, Inc.

#### MATERIAL:

REV.	DESCRIPTION	BY	DATE	APPR.	DATE
E	PER ECN 14331	RA	10/25/2024	DW	11/27/2024
D	PER ECN 13483			JEM	9/4/2019
C	PER ECN 12958			JEM	5/24/2018
B	PER ECN 11642			JEM	4/17/2011
A	REL ECN 10901			JEM	3/22/2011

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY DIMENSIONS IN INCHES OR [METRIC]	APPROVALS	DATE
DO NOT SCALE PRINTS	DRAWN	MS
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$ ANGLES: $\pm 1/2^\circ$	CHECKED	
	QA	
	MFG	
	ENGINEER	
	APPROVED	JEM
		9/23/2010



#### The PHOENIX Company of Chicago, Inc.

22 GREAT HILL RD., NAUGATUCK, CT 06770  
WWW.PHOENIXOFCHICAGO.COM  
PHONE: (800) 323-9562 FAX: (630) 206-1801

#### CABLE ASSEMBLY PROCEDURE FOR 78-1080-2203

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-1080-2203	E	
SCALE	2 : 1	F.S.R. #	SHEET	1 OF 1