

CABLE ASSEMBLY PROCEDURE

P/N 78-1080-2670

PAGE 1 OF 1 DATE: 05/16/02

DRAWN: YT APPROVED: HN

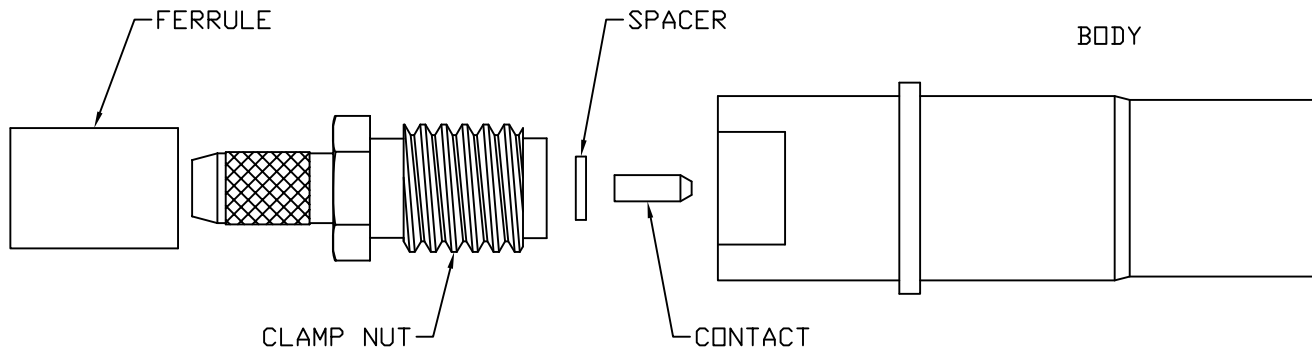
FOR USE WITH RD-316 CABLE

The **PHOENIX** Company of Chicago™

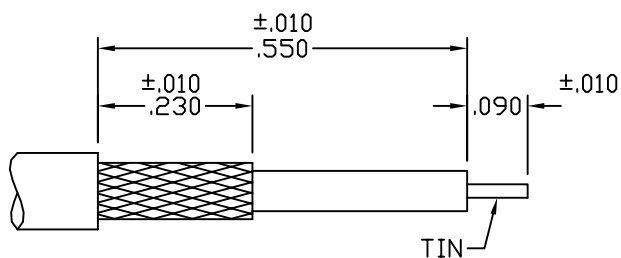
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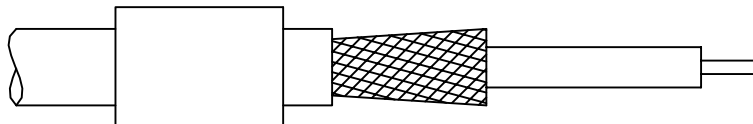
REV	DESCRIPTION	DATE	APPR
B	PER ECN 9678	12/08/08	JEM
C	PER ECN 10471	07/20/10	JEM
D	PER ECN 12958	05/24/18	JEM
E	PER ECN 13489	9/12/19	JEM



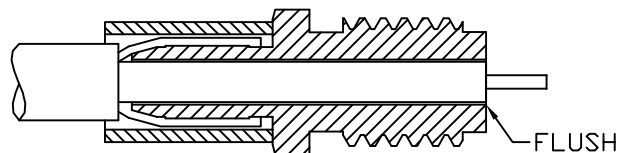
**STEP 1**  
TRIM CABLE TO DIMENSIONS SHOWN.  
TIN CENTER CONDUCTOR AND CLEAN  
SOLDER JOINT.



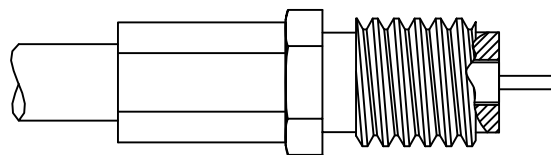
**STEP 2**  
SLIDE FERRULE OVER CABLE  
AND FLAIR BRAID BY ROTATING  
DIELECTRIC.



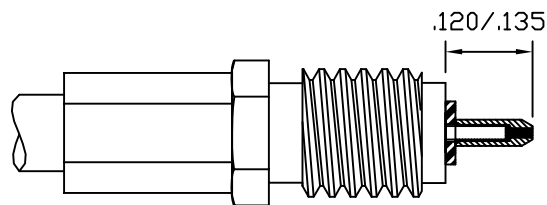
**STEP 3**  
INSERT THE BARREL OF THE CRIMP NUT BETWEEN  
THE BRAID AND DIELECTRIC, POSITIONED SO THAT  
THE END OF THE CABLE DIELECTRIC IS FLUSH  
WITH THE END OF THE CRIMP NUT.



**STEP 4**  
SLIDE THE FERRULE AGAINST THE SHOULDER  
OF THE CRIMP NUT AND CRIMP USING .151 HEX  
DIE (M22520/5-37).



**STEP 5**  
PLACE THE SPACER AGAINST THE CRIMP  
NUT. SLIDE THE BULLET OVER THE CENTER  
CONDUCTOR. USING RESISTANCE SOLDERING  
TWEETERS, APPLY HEAT TO THE BULLET  
TO REFLOW THE SOLDER, CLEAN SOLDER JOINT.



**STEP 6**  
THREAD CONNECTOR BODY ONTO  
THE CRIMP NUT ASSEMBLY,  
TIGHTEN TO 7-10 IN-LBS.

