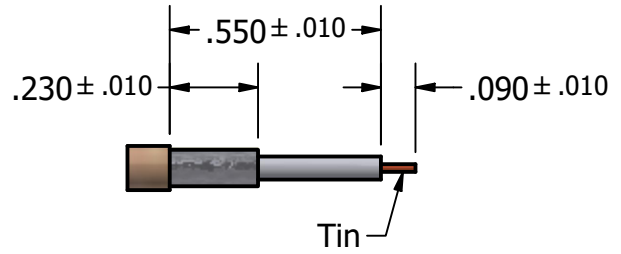


STEP 1

Trim cable to dimensions shown.
Tin center conductor and clean solder joint.



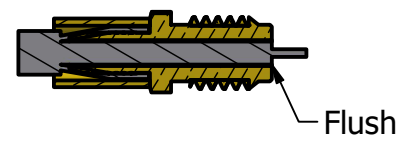
STEP 2

Slide ferrule over cable and flair braid by rotating dielectric.



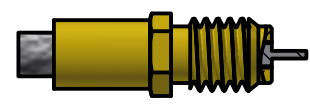
STEP 3

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.



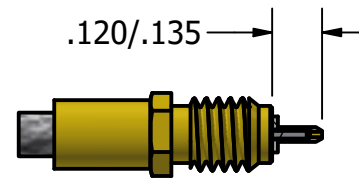
STEP 4

Slide the ferrule against the shoulder of the crimp nut and crimp using .151 hex die (M22520/5-37).



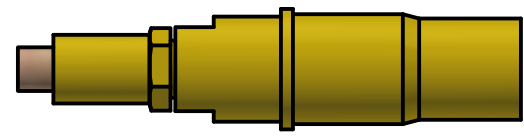
STEP 5

Place the spacer against the crimp nut. Slide the bullet over the center conductor. Using resistance soldering tweezers, apply heat to the bullet to re-flow the solder. Clean solder joint.



STEP 6

Thread connector body onto the crimp nut assembly, tighten to 7-10 in-lbs.



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MATERIAL:						UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR [METRIC].	APPROVALS		DATE
DO NOT SCALE PRINTS							DRAWN	YT	5/16/2002
TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2°						CHECKED			
F	PER ECN 14330	BAK	10/24/2024	DW	11/27/2024	QA			
E	PER ECN 13489			JEM	9/12/2019	MFG			
D	PER ECN 12958			JEM	5/24/2018				
C	PER ECN 10471			JEM	7/20/2010	ENGINEER			
B	PER ECN 9678			JEM	12/8/2008	APPROVED	HN	5/16/2002	
REV.	DESCRIPTION	BY	DATE	APPR.	DATE				

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TITLE
CABLE ASSEMBLY PROCEDURE FOR 78-1080-2670

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	78-1080-2670	F	
SCALE	2:1	F.S.R. #	SHEET 1 OF 1	