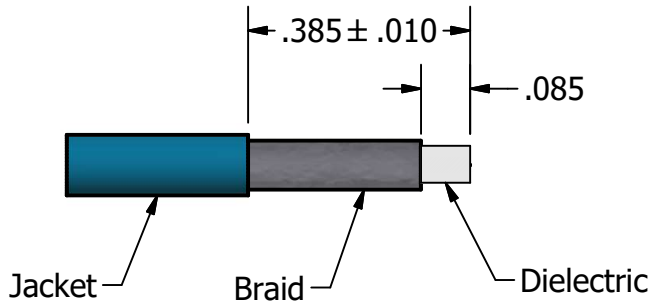
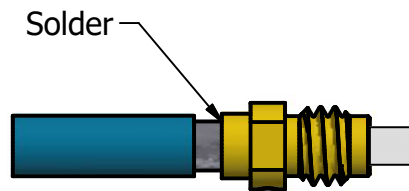


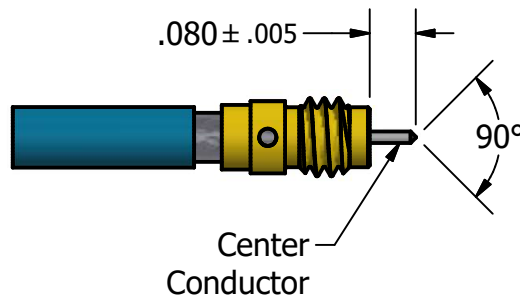
Step 1 (for Flex style cable only)
 Dip end of cable into flux.
 Tin Dip fluxed end of cable into solder pot to a depth of $.385 \pm .010$, for a maximum of 3 seconds.



Step 2
 Trim cable to dimensions shown, ($.385 \pm .010$ dimension for jacketed cables only).

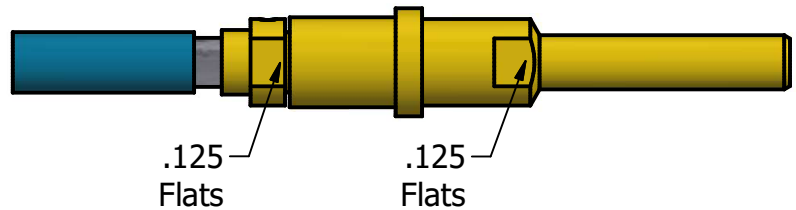


Step 3
 Install cable into solder nut until cable bottoms out. Solder the cable as shown. Clean solder joint.



Step 4
 Trim Dielectric to the face of the solder nut ($.003$ MAX. extrusion) and point the center conductor maintaining the dimension shown.

Step 5
 Install solder nut onto the body. Torque to 3.0 in-lbs. using two $\frac{1}{8}$ torque wrenches.



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MATERIAL:

<small>UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC).</small> <small>DO NOT SCALE PRINTS</small> <small>TOLERANCES ARE: FRACTIONS: ± 1/64 DECIMALS: .XX ± .01 .XXX ± .003 ANGLES: ± 1/2</small>				APPROVALS		DATE		<i>The PHOENIX Company of Chicago, Inc.</i> 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM											
				DRAWN		4/3/2024													
				CHECKED		4/3/2024		TITLE CABLE ASSEMBLY PROCEDURE FOR 168L-0030-0860											
				QA															
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				ENGINEER		SPS		4/3/2024		A		58167		168L-0030-0860		A			
				APPROVED		SPS		4/3/2024		SCALE		F.S.R. #		SHEET 1		OF 1			