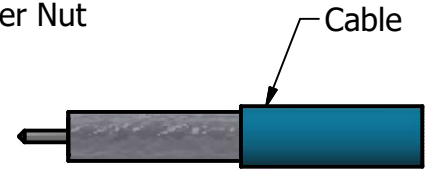
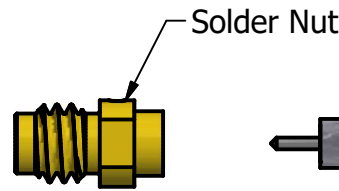
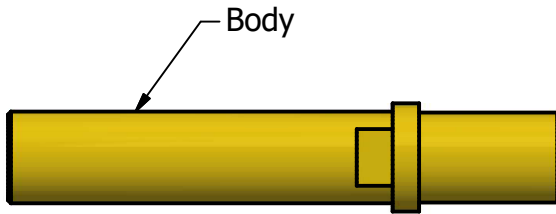
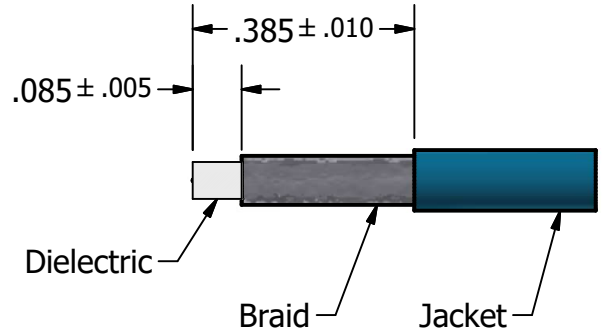


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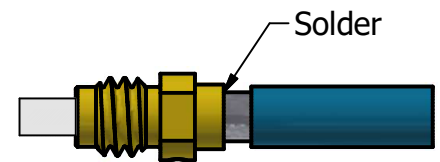
1



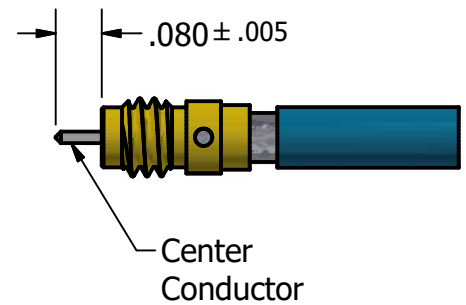
Step 1 (for Flex style cable only)
Dip end of cable into flux.
Tin Dip fluxed end of cable into solder pot to a depth of $.385 \pm .010$, for a maximum of 3 seconds.



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

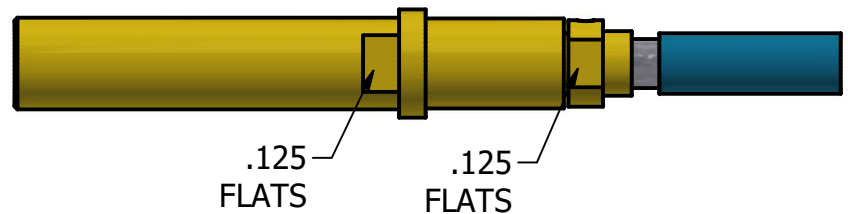


Step 3
Install cable into solder nut until cable bottoms out. Solder the cable as shown. Clean solder joint.



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:</small> <small>FRACTIONS: ± 1/64</small> <small>DECIMALS: .XX ± .01</small> <small>.XXX ± .003</small> <small>ANGLES: ± 1/2</small>	APPROVALS		DATE
	DRAWN RA		4/9/2024
	CHECKED SPS		4/9/2024
	QA		
	MFG		
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	APPROVED SPS	4/9/2024	
	REV.	DESCRIPTION	DATE
A	PER ECN 14383	4/9/2024	SPS

The **PHOENIX** Company of Chicago, Inc.
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TITLE
CABLE ASSEMBLY PROCEDURE FOR 168L-1030-0860

SIZE A	FSCM 58167	DWG NO 168L-1030-0860	REV A	PLATING OPT.
SCALE	F.S.R. #	SHEET 1 OF 1		

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