

CABLE ASSEMBLY PROCEDURE

P/N 20-1965-0498

PAGE 1 OF 1 DATE: 9/10/11

DRAWN: JEM APPROVED: JEM

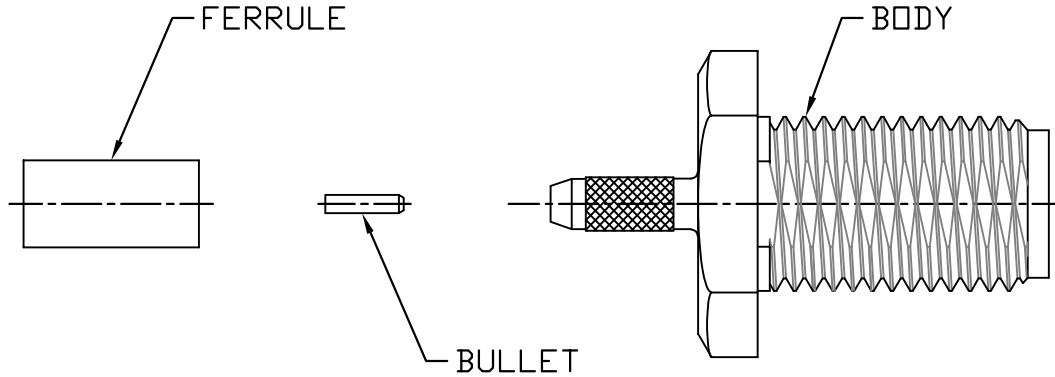
FOR USE WITH RG-178 CABLE

The *PHOENIX* Company of Chicago™

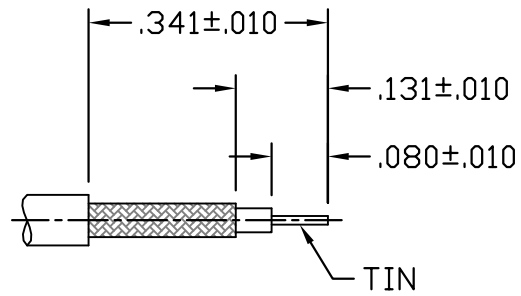
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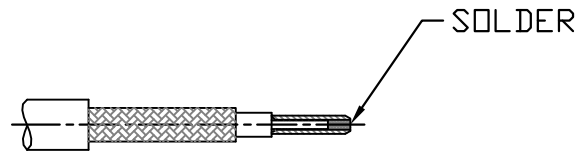
REV	DESCRIPTION	DATE	APPR
01	PRELIMINARY	9/10/12	JEM
A	PER ECN 11451	09/19/12	JEM
B	PER ECN 13661	1/29/20	JEM



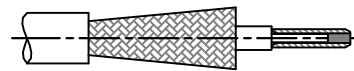
STEP 1
TRIM CABLE TO DIMENSIONS
SHOWN.. TIN CENTER CONDUCTOR.
CLEAN.



STEP 2.
SOLDER BULLET TO CENTER
CONDUCTOR AS SHOWN.



STEP 3
SLIDE FERRULE ONTO CABLE.
FLARE BRAID BY ROTATING
CABLE DIELECTRIC.



STEP 4
INSERT CABLE INTO BODY
UNTIL CABLE BOTTOMS.
SLIDE FERRULE UP UNTIL
IT BOTTOM ON SHOULDER.
CRIMP USING .105 HEX
DIE (M22520/5-03).

