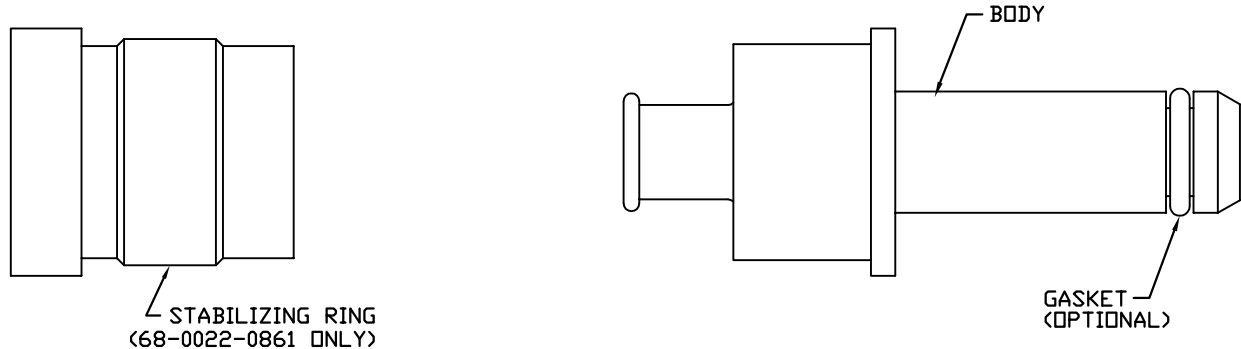


CABLE ASSEMBLY PROCEDURE		The <i>PHOENIX</i> Company of ChicagoTM 22 GREAT HILL RD., NAUGATUCK, CT 06770 WWW.PHOENIXOFCHICAGO.COM	REV	DESCRIPTION	DATE	APPR
P/N 68-0022-0861			H	PER ECN 11766	09/12/13	JEM
PAGE 2 OF 2	DATE: 10/06/97		I	PER ECN 12694	11/14/17	JEM
DRAWN: EK	APPROVED: JEM		J	PER ECN 13062	08/03/18	JEM
FOR USE WITH TFLEX 405 CABLE			K	PER ECN 13383	07/02/19	JEM

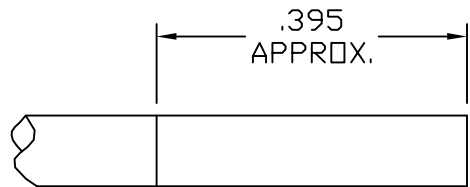
NOTES: 1) DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED [METRIC].

TFLEX 405 CABLE

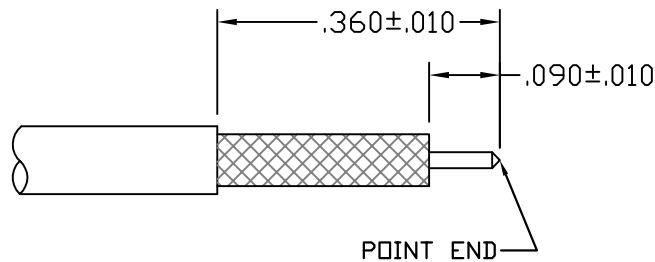
USE SHRINK TUBING.



STEP 1
DIP END OF CABLE INTO FLUX EF-6100 AND THEN TIN DIP CABLE TO DIMENSION SHOWN USING KESTER 60/40 SOLDER @ 500° F FOR SIX SECONDS MAX.



STEP 2
TRIM CABLE TO DIMENSIONS SHOWN. POINT TIP OF INNER CONDUCTOR AS SHOWN.



*NOTE: ON 68-0022-0861 SLIDE STABILIZING RING ON FIRST.

STEP 3
SLIDE PREPARED CABLE INTO CONNECTOR BODY AND SOLDER, CLEAN SOLDER JOINT.

