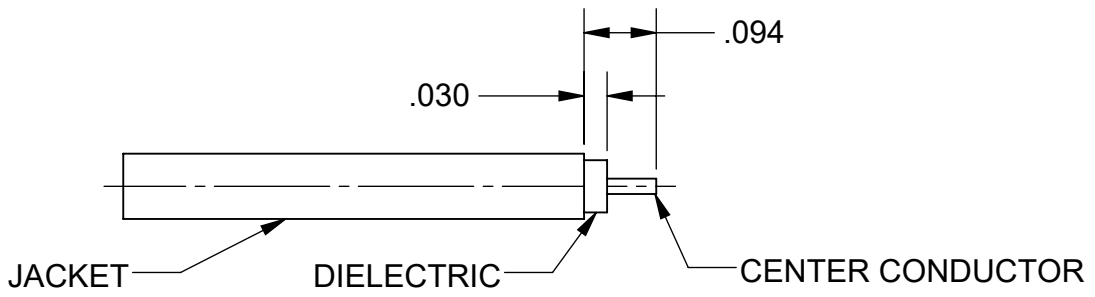


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	NRN 44880	07/20	SEE PDM
A	DCN 52221	12/22	
B	DCN 52475	04/23	

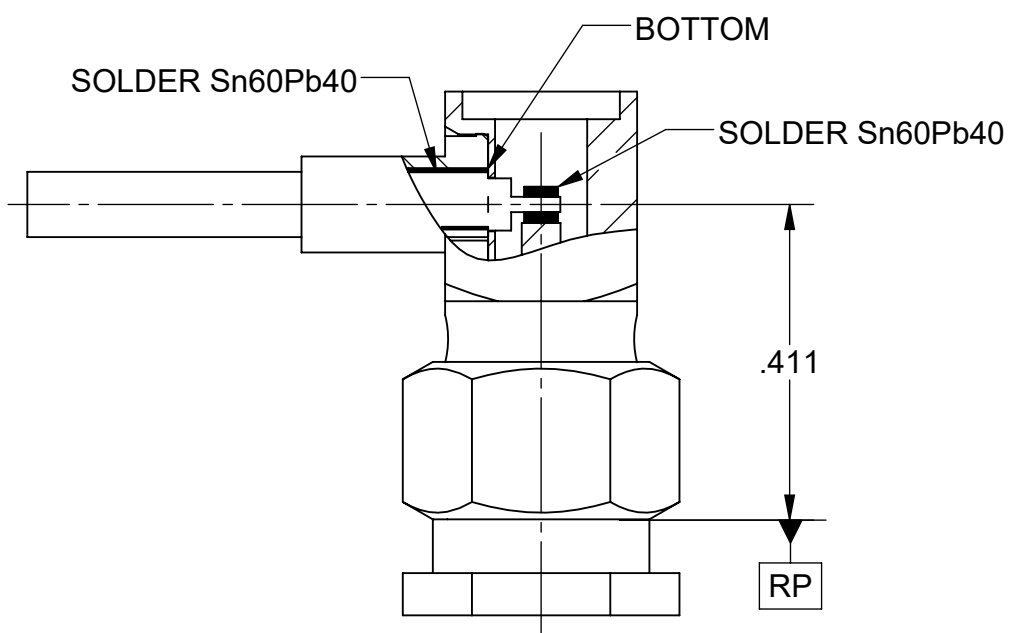


**STEP 1.**

TRIM INSULATOR AND JACKET TO DIMENSIONS SHOW. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR.

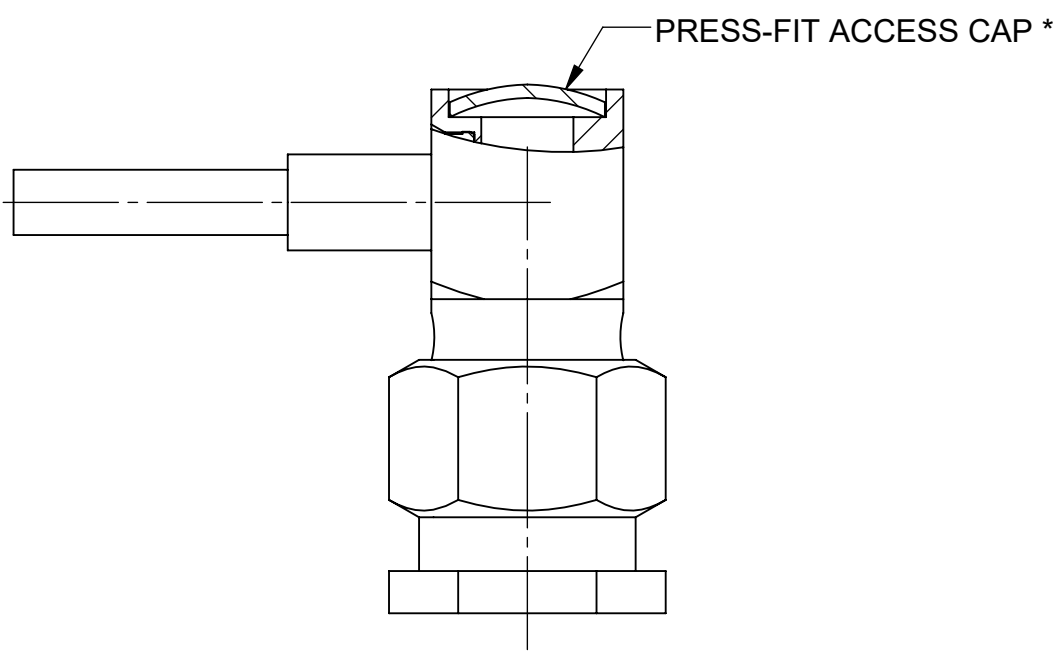
**NOTE:**

TO MINIMIZE CABLE DIELECTRIC GROWTH DURING SOLDERING OPERATION, NORMALIZE CABLE (THERMAL CYCLE PER MIL-DTL-17 PRIOR TO FINAL TRIM.



**STEP 2.**

ASSEMBLE CABLE INTO CONNECTOR ASSEMBLY, ENSURE CENTER CONDUCTOR IS POSITIONED INTO CONTACT SLOT AND ENSURE CABLE JACKET IS BOTTOMED IN BODY. SOLDER CABLE TO CONNECTOR USING Sn60Pb40 SOLDER. SOLDER CENTER CONDUCTOR TO CONTACT USING Sn60Pb40 SOLDER.



**STEP 3.**

ASSEMBLE ACCESS CAP AND PRESS IN PLACE

\* GOLD PLATED CAPS MAY BE SOLDERED USING Sn60Pb40 SOLDER.

MATERIAL: N/A	DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL: $\pm 1/64$ ANGULAR: X° $\pm 1'0''$ X°X' $\pm 15''$	UNLESS OTHERWISE SPECIFIED 1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1ST & LAST THREADS. 4) SURFACE ROUGHNESS 63 / MIL-STD-10. 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .005 T.I.R. 6) REMOVE ALL BURRS	 <b>TITLE:</b> CABLE ASSEMBLY INSTRUCTIONS
FINISH: PER BOM	DECIMAL: X $\pm .030$ .XX $\pm .010$ .XXX $\pm .005$	INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	
SURFACE AREA: N/A	THIRD ANGLE PROJECTION	DRAWN: JMC 08/05/20	SHEET 1 OF 1
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M39012/80-3007	USED ON:		