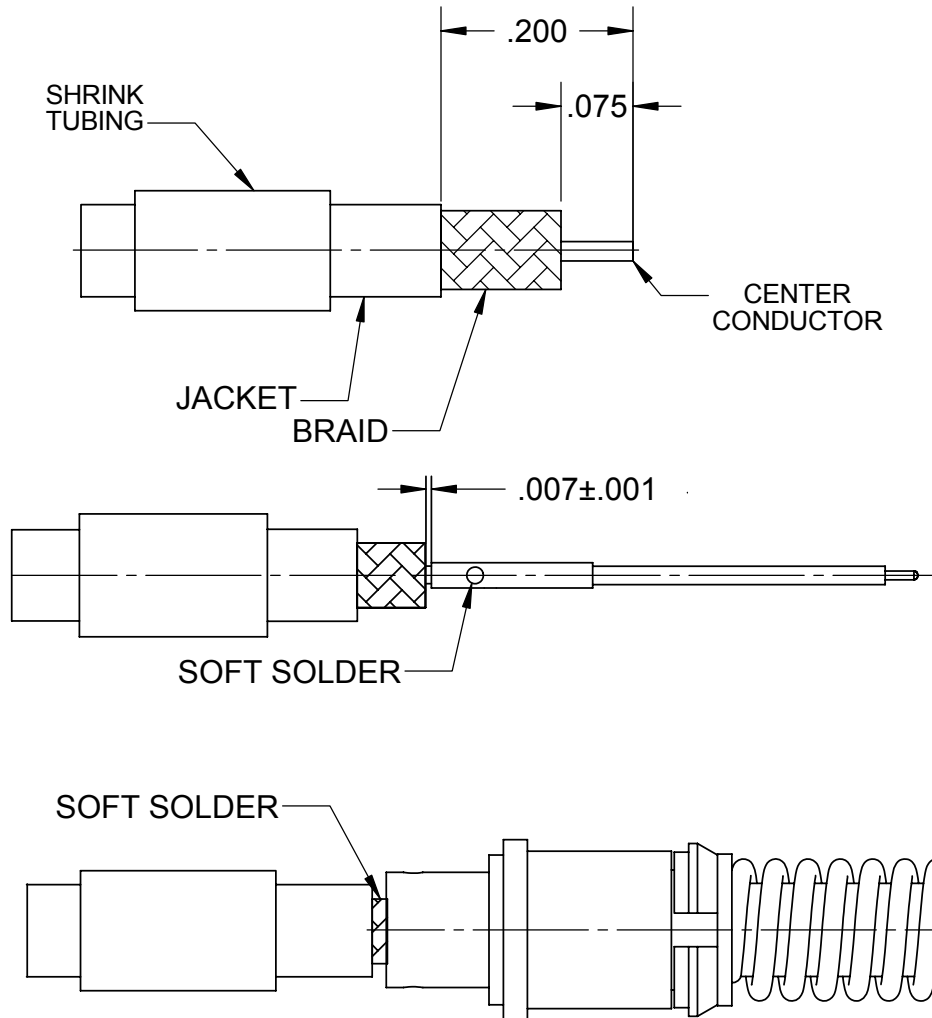


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	REL NRN 33834	11/20/06	STW



- STEP 1.**
PRIOR TO REMOVING JACKET FROM CABLE, DIP END INTO FLUX AND THEN DIP INTO A SOLDER POT TO A DEPTH OF .500" FOR 6 SECONDS MAX. TRIM JACKET TO .500", THEN TRIM BRAID, DIELECTRIC AND CENTER CONDUCTOR TO DIMENSIONS SHOWN. (DO NOT NICK BRAID OR CENTER CONDUCTOR).
- STEP 2.**
IF USED, SLIDE SHRINK TUBING ONTO CABLE.
- STEP 3.**
SOLDER CABLE TO CONTACT USING Sn63Pb37 SOLDER MAINTAIN .007 ± .001 GAP (USE SPACER).
- STEP 3.**
INSTALL PREPARED CABLE INTO CONNECTOR BODY UNTIL THE CABLE BOTTOMS IN CONNECTOR BODY AS SHOWN.
- STEP 4.**
SOFT SOLDER CABLE BRAID TO CONNECTOR BODY USING Sn63Pb37 SOLDER.
- STEP 5.**
IF USED, SLIDE SHRINK TUBING FORWARD OVER CONNECTOR BODY. APPLY HEAT AND SHRINK INTO PLACE.

MATERIAL:	N/A
FINISH:	N/A
SURFACE AREA:	N/A
PROPRIETARY	
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SV MICROWAVE, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SV MICROWAVE, INC IS PROHIBITED.	

DIMENSIONS ARE IN INCHES TOLERANCES:	
FRACTIONAL:	±1/64
ANGULAR:	X° ±1'0"
	X'X' ±15'
DECIMAL:	X ±.030
	.XX ±.010
	.XXX ±.005
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	
THIRD ANGLE PROJECTION	

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 N/A T.I.R.	
6) REMOVE ALL BURRS	
DRAWN:	JMC 11/20/06
CHECKED:	STW 11/20/06
APPROVED:	STW 11/20/06
E.M. SIMULATION:	N/A

SV Microwave, Inc.		
2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409		
TITLE: CABLE ASSEMBLY INSTRUCTION		
SIZE	CAGE CODE	DWG. NO.
A	95077	300-32-011
SCALE: 1:0.111111		SHEET 1 OF 1

SF3211-6001
USED ON: