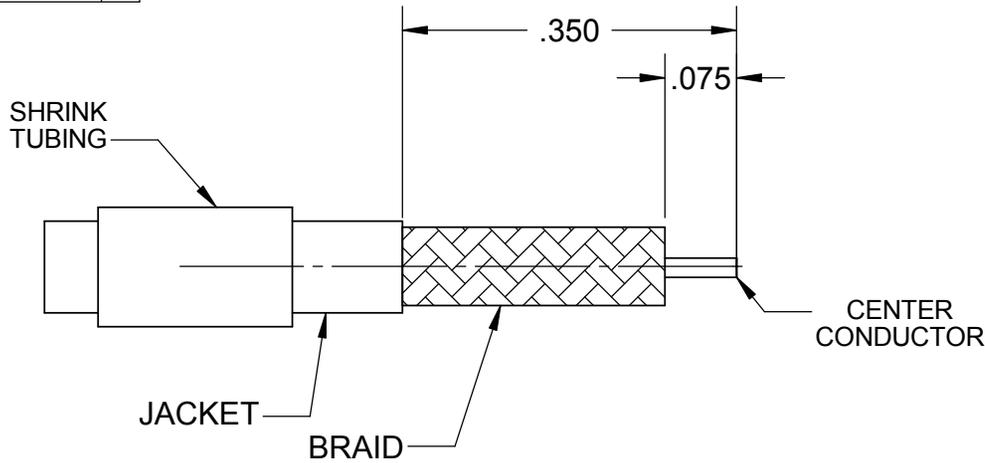


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	DCN 38226	05/11	STW



**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).

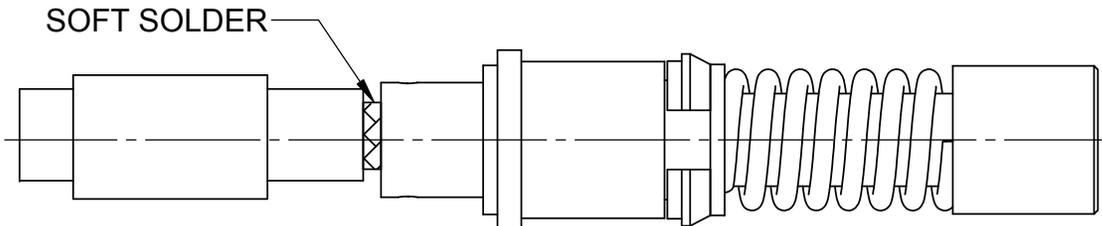
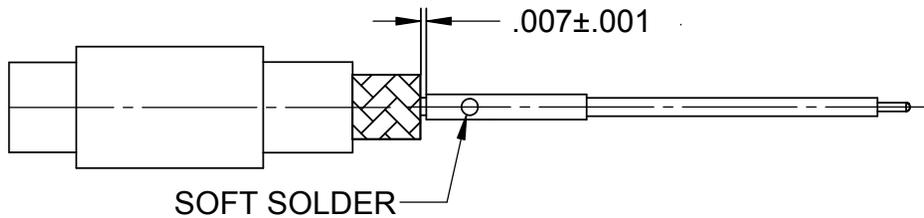
**STEP 2.**  
IF USED, SLIDE SHRINK TUBING ONTO CABLE.

**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.

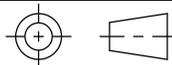
**STEP 5.**  
IF USED, SLIDE SHRINK TUBING FORWARD OVER CONNECTOR BODY. APPLY HEAT AND SHRINK INTO PLACE.



MATERIAL:	N/A
FINISH:	N/A
SURFACE AREA:	N/A
<b>PROPRIETARY</b>	
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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: FSG 05/13/11

CHECKED: STW 05/13/11

APPROVED: STW 05/13/11

E.M. SIMULATION: N/A

**SV Microwave, Inc.**

2400 Centrepark West Drive, Suite 100  
West Palm Beach, FL 33409

TITLE: **CABLE ASSEMBLY INSTRUCTION**

SIZE: **A** CAGE CODE: **95077** DWG. NO.: **300-32-023**

SCALE: 1:1

SHEET 1 OF 1

SF3211-6004

USED ON: