

# SV Microwave Inc.

MARK LABEL PER PARTS LIST

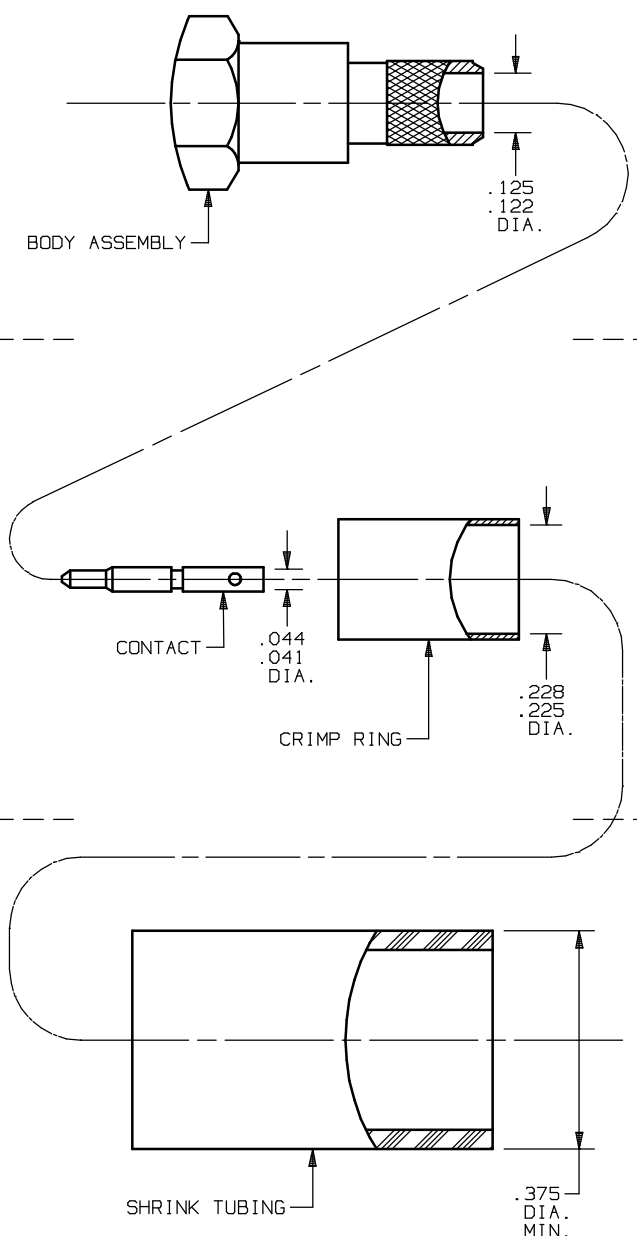
CONNECTOR TYPE.....SMA PLUG  
CRIMP ATTACHMENT

CABLE TYPE.....RG-142, RG-400, RG-223

SPECIAL TOOL.....PREFERRED DIE M22520/5-19  
CLOSURE B (.213 DIE) ALTERNATE  
DIE M22520/5-05 CLOSURE A, DR  
-11,57 CLOSURE A

INSTRUCTIONS FOR...M39012/55-3028, M39012/55-3128,  
M39012/55B3016, M39012/55B3116,  
M39012/55B3015, M39012/55B3115,  
M39012/55B3022, M39012/55B3122,  
M39012/55B3023, M39012/55B3123

## PARTS SUPPLIED

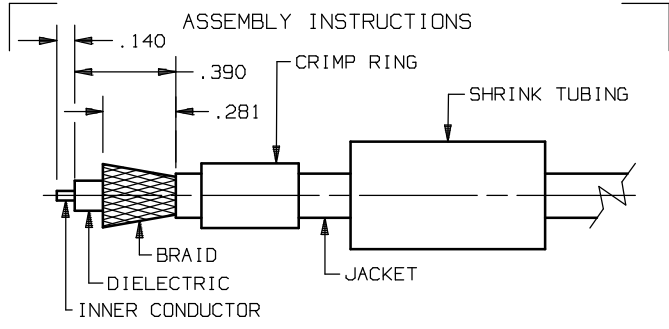


UNFOLD FOR ASSEMBLY INSTRUCTIONS  
CABLE ASSEMBLY PART NUMBER 300-80-274.

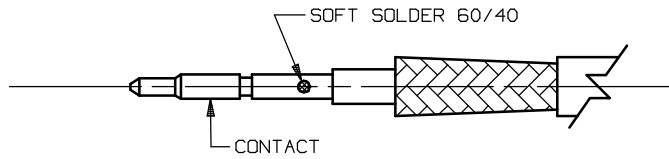
SYM.	DESCRIPTION	DATE	APPR.	UNLESS OTHERWISE SPECIFIED:			
A	REV. DCN 11602	08/89	RG	1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1st & LAST THDS. 4) SURFACE ROUGHNESS 63 / MIL-STD-10. 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R. 6) REMOVE ALL BURRS.			
B	REV. DCN 25934	03/00	STM	DIMENSIONS ARE IN INCHES			
				TOLERANCES:			
				DECIMALS			
				FRACTIONAL			
				ANGULAR			
				FINISH:			
				MATERIAL:			
				AREA:			
				TITLE:			
				DRAWN:			
				CHECKED:			
				APPROVED:			
				SIZE			
				CODE IDENT.			
				SCALE			
				DMG. NO.			
				SHT. 1			
				OF 2			

**SV Microwave, Inc.**  
3301 Electronics Way  
West Palm Beach, FL, 33407

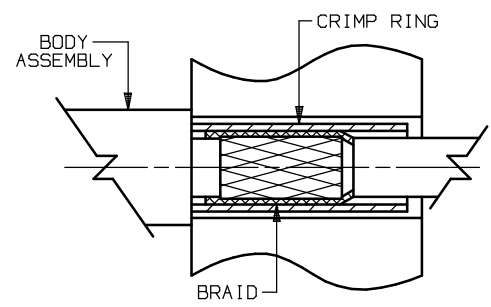
CABLE ASSEMBLY  
INSTRUCTIONS



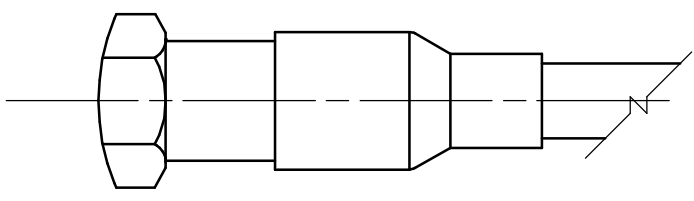
- 1.0 PREPARE CABLE END  
 1.1 SLIDE SHRINK TUBING AND CRIMP RING ONTO CABLE.  
 1.2 TRIM CABLE JACKET, BRAID, DIELECTRIC & INNER CONDUCTOR TO DIMENSIONS SHOWN. WITHOUT NICKING BRAID.  
 1.3 FLARE BRAID AS SHOWN.



- 2.0 SOLDER INNER CONTACT  
 2.1 TIN INNER CONDUCTOR.  
 2.2 SLIDE CONTACT ONTO INNER CONDUCTOR AND BOTTOM ON DIELECTRIC AS SHOWN.  
 2.3 SOFT SOLDER CONTACT ONTO INNER CONDUCTOR.  
 2.4 REMOVE EXCESS SOLDER.



- 3.0 ATTACH CABLE BRAID TO BODY ASSY.  
 3.1 SLIDE CABLE FORWARD INTO BODY ASSY. UNTIL CONTACT SNAPS INTO PLACE.  
 3.2 SLIDE CRIMP RING FORWARD OVER FLARED BRAID AND POSITION AS SHOWN.  
 3.3 "CRIMP" CRIMP RING USING CRIMP TOOL M22520/5-19(.213 DIE.).



- 4.0 ATTACH SHRINK TUBING  
 4.1 SLIDE SHRINK TUBING OVER JACKET AND CRIMP RING AND POSITION AS SHOWN.  
 4.2 APPLY HEAT(275° MIN) TO SHRINK TUBING TO COMPLETE ASSEMBLY.

SYM.	DESCRIPTION	DATE	APPR.
A	REV. DCN 11602	08/89	RG
B	REV. DCN 25934	03/00	STM

UNLESS OTHERWISE SPECIFIED:  
 1) ALL DIMENSIONS ARE AFTER PLATING.  
 2) BREAK CORNERS & EDGES .005 R. MAX.  
 3) CHAM. 1st & LAST THDS.  
 4) SURFACE ROUGHNESS 63 / MIL-STD-10.  
 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.  
 6) REMOVE ALL BURRS.

DIMENSIONS ARE IN INCHES

DECIMALS	TOLERANCES:	FRACTIONAL	ANGULAR
.X	±.030		X° ±1.0'
.XX	±.015	±1/64	X°X' ±15"
.XXX	±.005		

MATERIAL: N/A  
 FINISH: N/A  
 AREA: N/A

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 3301 Electronics Way  
 West Palm Beach, FL, 33407

TITLE:  
 CABLE ASSEMBLY INSTRUCTIONS

REDRAWN: BRT 02/29/00	CHECKED:	APPROVED: DGG 07/22/80
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SIZE: A	CODE: 95077	SCALE: N/A
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DMG. NO. 300-80-274	SHT. 2 OF 2
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