

A SIZE COPY

SIZE B

DRAWING NO. 300-80-279

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

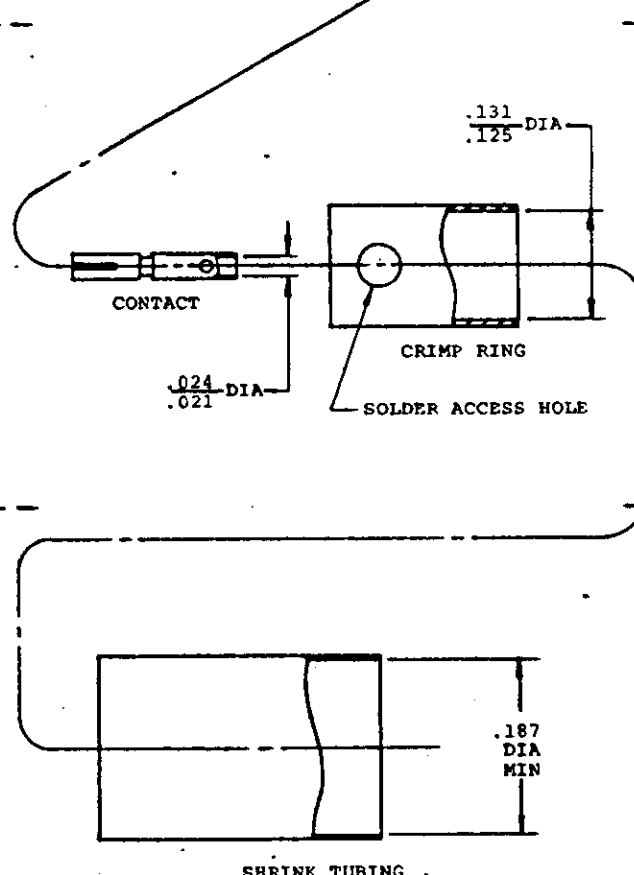
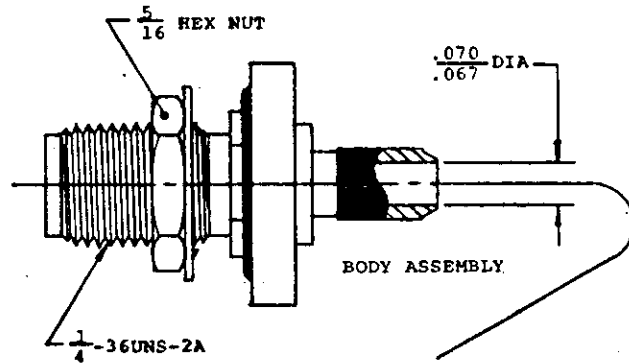
MARK LABEL PER PARTS LIST

CONNECTOR TYPE....SMA JACK, JAM NUT MTD.,
CABLED, SOLDER OR CRIMP
ATTACHMENT.

CABLE TYPE.....RG-174/U, 316/U

SPECIAL TOOL.....CRIMP TOOL M22520/10-05
(.128 DIE)

PARTS SUPPLIED



8.000

300-80-279

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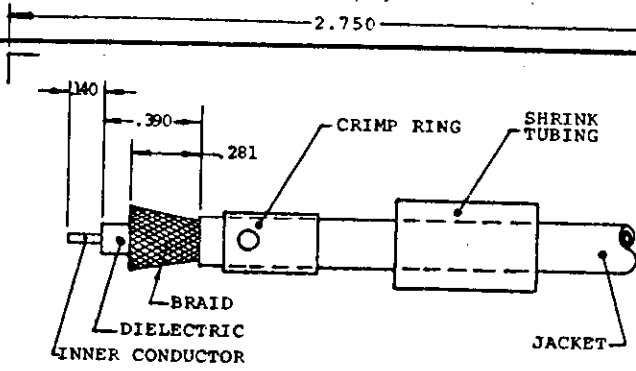
UNFOLD FOR
ASSEMBLY
INSTRUCTIONS

SYM	DESCRIPTION	DATE	APP.	UNLESS OTHERWISE SPECIFIED	FINISH
	RELEASE F-7909	8-20-80	[Signature]	1. ALL DIMENSIONS ARE IN INCHES 2. DIMENSIONS IN PARETHESIS ARE FOR INFORMATION ONLY 3. DIMENSIONS IN SQUARES ARE TYPICAL 4. DIMENSIONS IN TRIANGLES ARE TYPICAL 5. REMOVE ALL BURRS & SHARP EDGES AND ROUNDS 6. DIMENSIONS IN CIRCLES ARE FOR INFORMATION ONLY 7. DIMENSIONS IN PARETHESIS ARE FOR INFORMATION ONLY 8. ALL DIMENSIONS TO BE CONCENTRIC 9. SURFACE ROUGHNESS --- (MIL-STD-19) DRAWN EWS/mth DATE 8/6/80 CHECKED [Signature] DATE 8-6-80 APPROVED [Signature] DATE 8/6/80	

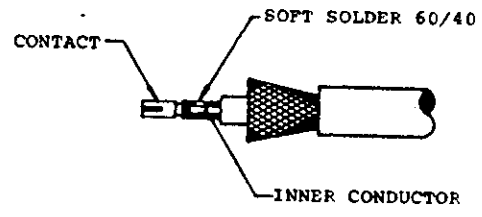
NAME OF PART	SIZE
SOLITRON/MICROWAVE PORT SALERNO, FLORIDA	B

TITLE	DRAWING NO.	SHEET NO.
CABLE ASSEMBLY INSTRUCTIONS	300-80-279	2

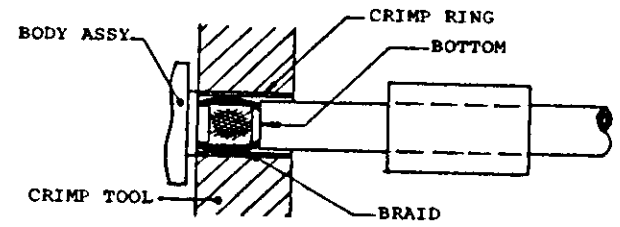
B
DRAWING NO.
300-80-279



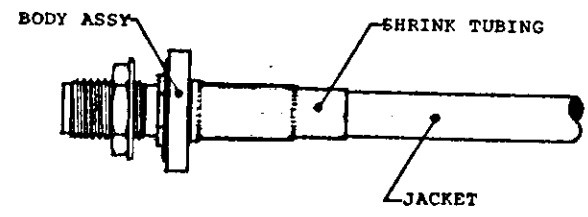
- 1.0 PREPARE CABLE END
 - 1.1 Slide shrink tubing and crimp ring onto cable.
 - 1.2 Trim cable jacket, braid, dielectric and inner conductor to dimensions shown without nicking braid.
 - 1.3 Flare braid as shown.



- 2.0 SOLDER INNER CONTACT
 - 2.1 Tin inner conductor.
 - 2.2 Slide contact onto inner conductor and bottom 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 body assy onto cable dielectric and bottom.
 - 3.2 Slide crimp ring over flared braid and position as shown.
 - 3.3 Attach body assy to cable braid by either of two methods:
 - a) "Crimp" crimp ring using crimp tool M22550/10-05 (.128 Die).
 - b) Soft solder crimp ring to braid and connector ferrule through access holes.



- 4.0 ATTACH SHRINK TUBING
 - 4.1 Slide shrink tubing over jacket and crimp ring and position as shown.
 - 4.2 Apply heat (275°F min.) to shrink tubing to complete assembly, while maintaining the desired maximum length from start of coupling nut to end of shrink tubing.

REV.	DESCRIPTION	DATE	APP.	REV.	DATE	APP.
—	RELEASE F-7809	8/80	D			

CHECKED	DATE 8/6/80	DRAWN	DATE 8/6/80
APPROVED	DATE 8/6/80	CHECKED	DATE 8/6/80

SOUTHRON/MICROWAVE		CABLE ASSEMBLY INSTRUCTIONS	
PORT SALERNO, FLORIDA	FINISH	SCALE	SIZE
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		95077	
			300-80-279