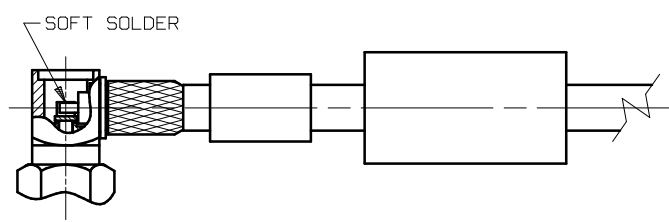
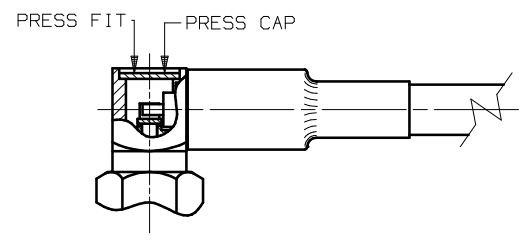


ASSEMBLY INSTRUCTIONS

- 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 ATTACH CABLE TO CONNECTOR
  - 2.1 INSERT PREPARED CABLE END INTO FERRULE END OF CONNECTOR. POSITION INNER CONDUCTOR INTO SLOT. SOFT SOLDER CONDUCTOR TO CONTACT.
  - 2.2 SLIDE CRIMP RING OVER BRAID AND FERRULE. CRIMP "CRIMP RING" USING CRIMP TOOL M22520/5-35, CLOSURE B (.128 DIE.). TRIM EXCESS BRAID IF NECESSARY.



- 3.0 ENCLOSING CONNECTOR OPENING
  - 3.1 PRESS CAP INTO RECESS OF CONNECTOR.
  - 3.2 SLIDE SHRINK TUBING OVER CRIMP RING.
  - 3.3 APPLY HEAT (275° MIN) TO SHRINK TUBING COMPLETING ASSEMBLY.

8.00

SYM.	DESCRIPTION	DATE	APPR.	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 TOLERANCES: DECIMALS .X ±.030 .XX ±.015 .XXX ±.005 FRACTIONAL ±1/64 ANGULAR X° ±1.0' X'X' ±15'	FINISH:	AREA:	SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL, 33409 TITLE: CABLE ASSEMBLY INSTRUCTIONS	
A	REV. DCN F11855	07/90	RG			SIZE	CODE IDENT.		SCALE
B	REV. DCN 24828	11/98	STM			A	95077		N/A
C	REV. DCN 30784	12/03	BRT			N/A	N/A		N/A
						REDRAWN:	BRT 10/21/98		
						CHECKED:			
				APPROVED:	ND 3/01/86				
							DMG. NO. 300-80-582 SHT. 2 OF 2		