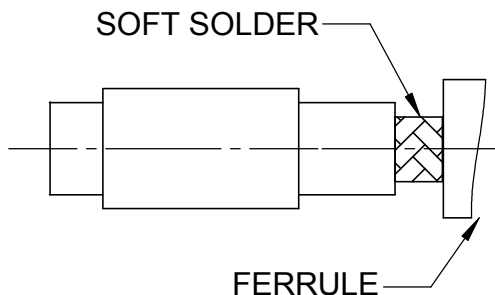
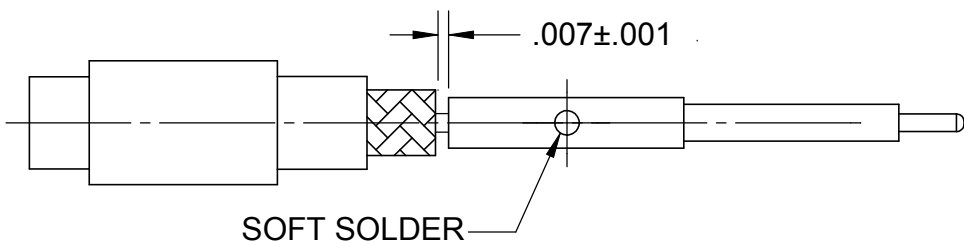
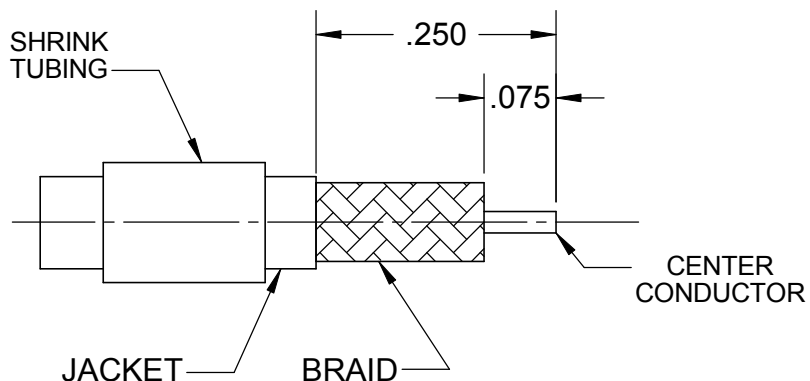


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	NRN 35822	02/10	STW
A	REV. DCN 37479	04/20/10	STW



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 4.
INSTALL PREPARED CABLE INTO CONNECTOR BODY UNTIL THE CABLE BOTTOMS IN CONNECTOR BODY AS SHOWN.

STEP 5.
SOFT SOLDER CABLE BRAID TO CONNECTOR BODY USING Sn63Pb37 SOLDER.

STEP 6.
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:	NHR 02/25/10
CHECKED:	STW 02/25/10
APPROVED:	STW 02/25/10
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.: 300-32-019
SCALE: 4:1		SHEET 1 OF 1

SF9351-60004
USED ON: