

USED ON: 1265-4000

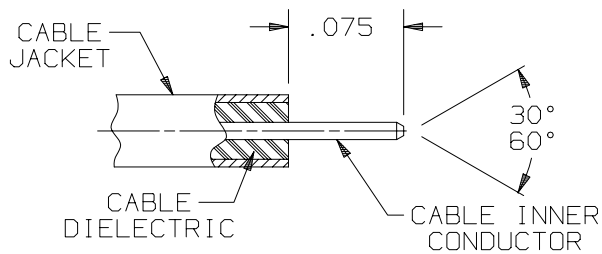
300-12-002

R & D
DEVELOPED
PRODUCT

HFSS & DCN
CONTROLLED
DOCUMENT

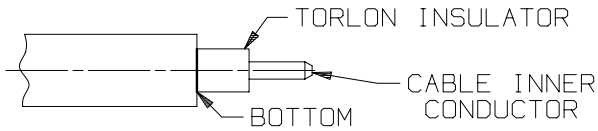
STEP 1

TRIM CABLE JACKET AND CABLE DIELECTRIC AS SHOWN, DO NOT NICK CABLE INNER CONDUCTOR. POINT CABLE INNER CONDUCTOR.



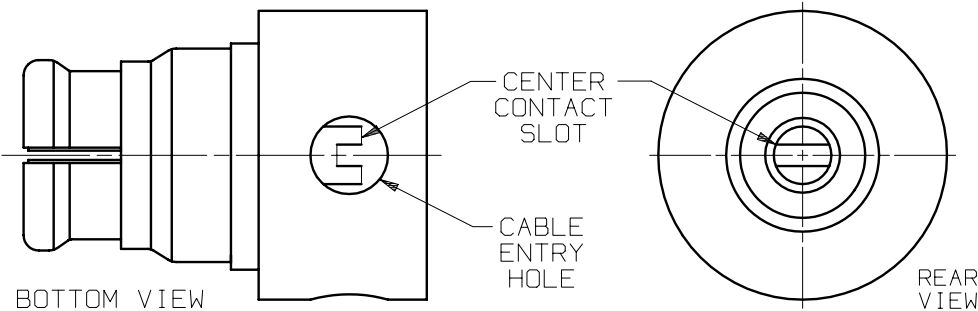
STEP 2

INSTALL TORLON INSULATOR ONTO CABLE INNER CONDUCTOR BOTTOMED ON CABLE AS SHOWN.



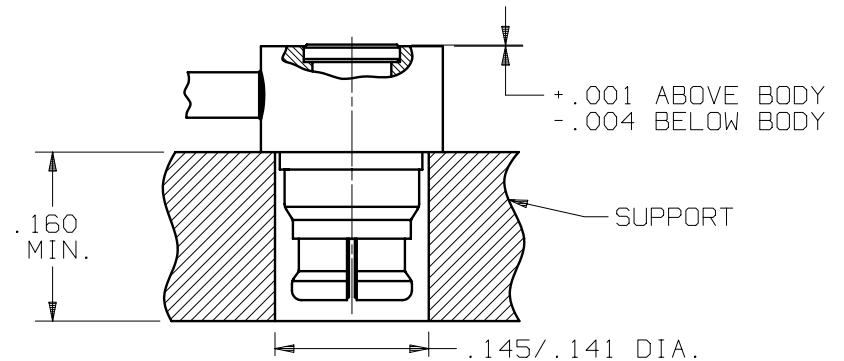
STEP 3

CHECK ORIENTATION OF CENTER CONTACT SLOT (ADJUST IF REQD) FROM THE BOTTOM & REAR OF CONNECTOR. IF ALIGNED INSERT THE CABLE BOTTOMED INSIDE. INNER CONDUCTOR TO REST INSIDE SLOT.



STEP 5

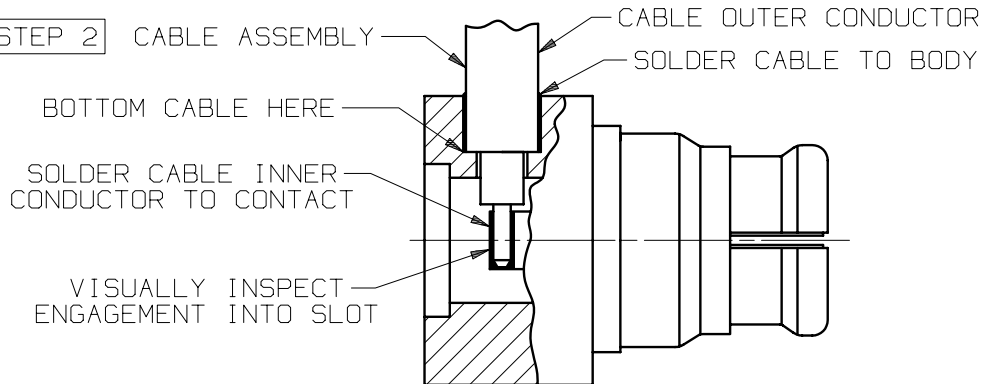
INSTALL PRESS CAP TOWARD CONNECTOR AND GENTLY PRESS UNTIL SEATED $+.001/- .004$.



STEP 4

INSERT **STEP 2** CABLE ASSEMBLY INTO THE BODY ENTRY HOLE UNTIL BOTTOMING INSIDE BODY. VISUALLY INSPECT CABLE INNER CONDUCTOR FOR ENGAGEMENT INTO CENTER CONTACT SLOT. SECURE CABLE OUTER CONDUCTOR TO PREVENT MOVEMENT DURING SOLDER OPERATION. SOLDER CONTACT USING 60/40 SOLDER, KEEP SOLDER IN SLOT AREA. SOLDER CABLE OUTER CONDUCTOR TO BODY USING 60/40 SOLDER, SOLDER RINGS ARE RECOMMENDED. UNCLAMP CABLE REMOVE ASSEMBLY, CLEAN & INSPECT.

STEP 2



SYM.	DESCRIPTION	DATE	APPR.
—	REL. NRN 29376	1/03	JM
A	REV. DCN 31523	7/04	STW

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 .005 T.I.R.
 6) REMOVE ALL BURRS.

DESIGNED: DWC 11/13/02
 HFSS CHK: SVG 11/13/02
 MECH CHK: DWC 11/14/02

DIMENSIONS ARE IN INCHES		
DECIMALS	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
SIZE A	CAGE NO. 95077	SCALE N/A

SV Microwave, Inc.
 2400 Centrepark West Drive, Suite 100
 West Palm Beach, FL 33409

TITLE:
CABLE ASSEMBLY INSTRUCTIONS

DWG. NO.
300-12-002