



INSULATOR SPACER BOTTOM ONTO OUTER BRAID-

CONTACT BOTTOM ONTO INSULATOR SPACER-

REVISION HISTORY APPROVED DESCRIPTION 02/13 STW NRN 37970

STEP 1

TRIM CENTER CONDUCTOR AND OUTER BRAID TO DIMENSIONS SHOWN, DO NOT NICK CENTER CONDUCTOR.

STEP 2

ASSEMBLE INSULATOR SPACER ONTO CABLE, BOTTOM AGAINST OUTER **BRAID AS SHOWN.**

ASSEMBLE CONTACT ONTO CABLE, BOTTOM AGAINST INSULATOR SPACER AS SHOWN.

SOFT SOLDER CONTACT TO CENTER CONDUCTOR AND REMOVE EXCESS SOLDER.

STEP 3

INSTALL CABLE INTO CONNECTOR AND BOTTOM CONTACT TO CONTACT AS SHOWN.

SOFT SOLDER CABLE TO CONNECTOR.

MATERIAL: N/A	DIMENSIONS ARE IN INCHE
FINISH: DED DOM	FRACTIONAL: ±1/64 AN
FINISH: PER BOM	DECIMAL: .X ±.030 .XX ±.010
SURFACE AREA: N/A	.XXX ±.005
IN//A	INTERPRET DIMENSIONS A
PROPRIETARY	PER ASME Y14.5M - 1994
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2921-61262

USED ON:

DIMENSIONS ARE IN INCHES TOLERANCES:	UNLESS OTI	HERWISE SPECIFIED
FRACTIONAL: ±1/64 ANGULAR: X° ±1°0' X°X' +15'	1) ALL DIMENSIONS ARE 2) BREAK CORNERS & E	DGES .005 R. MAX.
DECIMAL: .X ±.030	3) CHAM. 1ST & LAST THREADS. 4) SURFACE ROUGHNESS 63 VMIL-STD-10. 5) DIA:'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN 1005 T.I.R. 6) REMOVE ALL BURRS	
INTERPRET DIMENSIONS AND TOLERANCES		
PER ASME Y14.5M - 1994	DRAWN:	FSG 02/07/13
THIRD ANGLE PROJECTION	CHECKED:	STW 02/07/13

1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1ST & LAST THREADS. 4) SUFFACE ROUGHNESS 63 VML-STD-10. 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .005 T.I.R. 6) REMOVE ALL BURRS	
DRAWN:	FSG 02/07/13
CHECKED:	STW 02/07/13

STW 02/07/13

APPROVED:

E.M. SIMULATION: N/A

SV Microwave, Inc.

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CABLE ASSEMBLY **INSTRUCTIONS**

SIZE CAGE CODE DWG. NO. B 95077 300-29-123 SCALE: 4:1 SHEET 1 OF 1