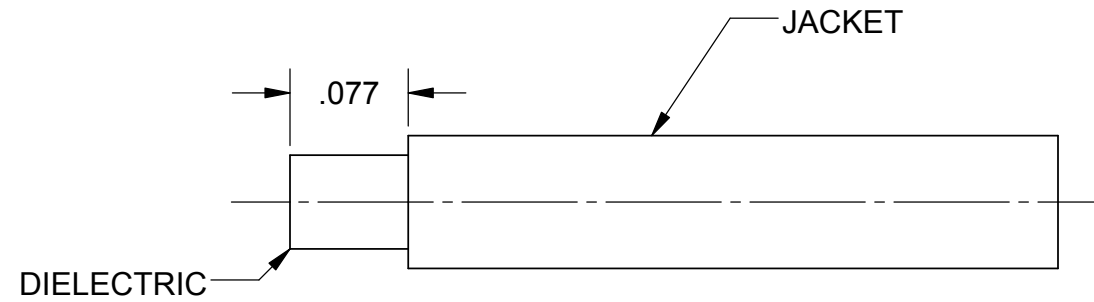
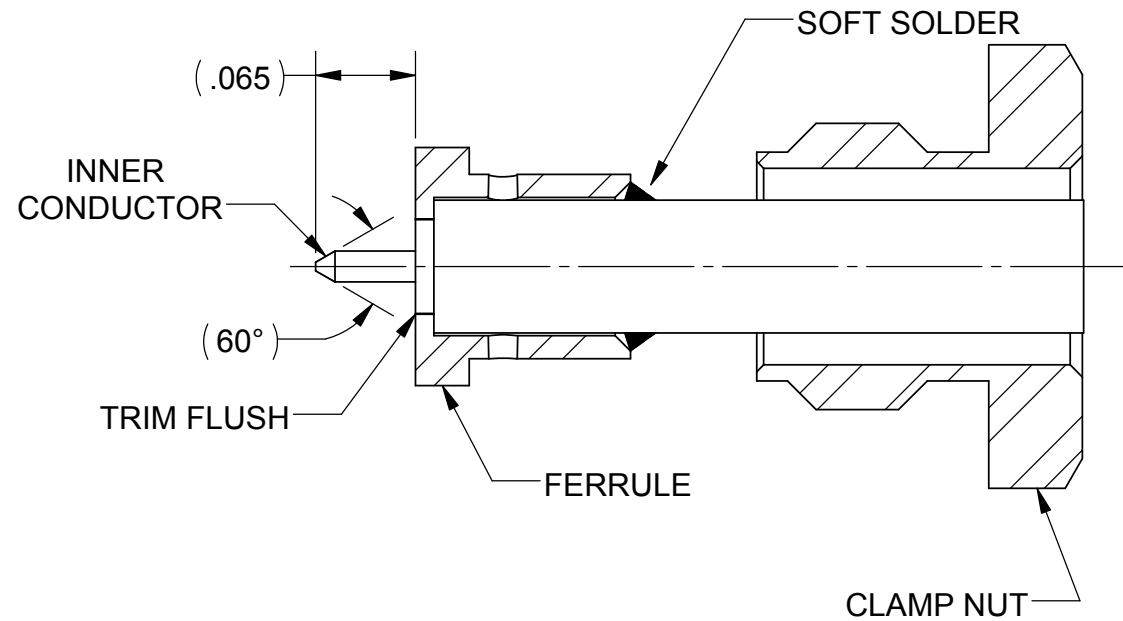


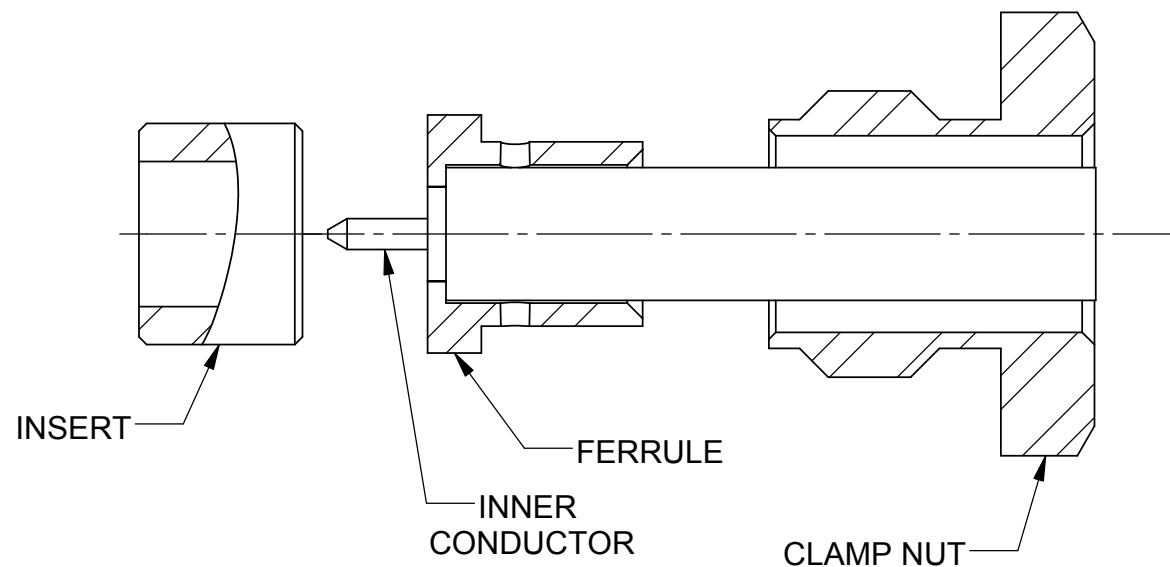
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	NRN 41794	09/17	STW



STEP 1.  
1.1) TRIM CABLE DIELECTRIC TO DIMENSION SHOWN.



STEP 2.  
2.1) ASSEMBLE CLAMP NUT ONTO CABLE, SLIDE FERRULE ONTO CABLE UNTIL IT BOTTOMS.  
2.2) SOFT SOLDER FERRULE TO CABLE JACKET BY USING Sn96 SOLDER.  
2.3) TRIM DIELECTRIC FLUSH WITH FERRULE FACE.  
MAKE SURE NOT TO NICK THE CENTER CONDUCTOR.  
2.4) POINT CENTER CONDUCTOR. DEBURR AS REQUIRED.



STEP 3.  
3.1) INSTALL INSERT INTO CONNECTOR ASSEMBLY.  
3.2) INSTALL CABLE ASSEMBLY INTO CONNECTOR. MAKE SURE THE CENTER CONDUCTOR MATES WITH THE SOCKET CONTACT WITHIN THE CONNECTOR ASSEMBLY.  
3.3) SLIDE CLAMP NUT FORWARD AND TIGHTEN WITH 20 IN-LBS OF TORQUE.

MATERIAL:	N/A	DIMENSIONS ARE IN INCHES TOLERANCES:	UNLESS OTHERWISE SPECIFIED	<b>SV Microwave, Inc.</b> 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409 TITLE: CABLE ASSEMBLY INSTRUCTIONS
FINISH:	N/A	FRACTIONAL: $\pm 1/64$ ANGULAR: X° $\pm 1'0''$ X'X' $\pm 15'$	1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1ST & LAST THREADS. 4) SURFACE ROUGHNESS 63 $\sqrt{\text{MIL-STD-10}}$ . 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .005 T.I.R. 6) REMOVE ALL BURRS	
SURFACE AREA:	N/A	DECIMAL: X $\pm .030$ .XX $\pm .010$ .XXX $\pm .005$	INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	DRAWN: JDT 09/18/17 CHECKED: STW 09/18/17 APPROVED: STW 09/18/17 E.M. SIMULATION: 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.		THIRD ANGLE PROJECTION		SIZE B CAGE CODE 95077 DWG. NO. 300-33-007 SCALE: 8:1 SHEET 1 OF 1

SF3311-60009  
USED ON: