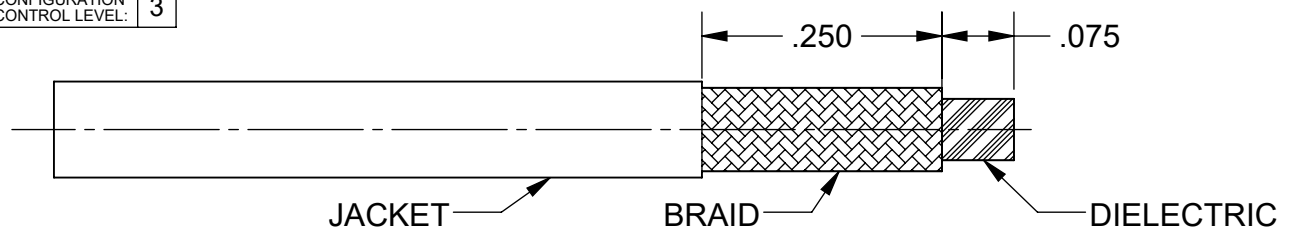
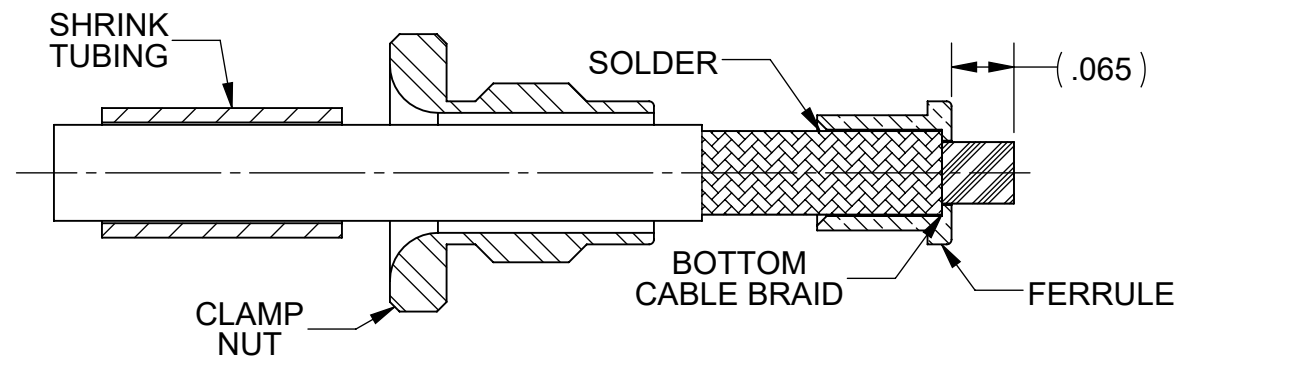


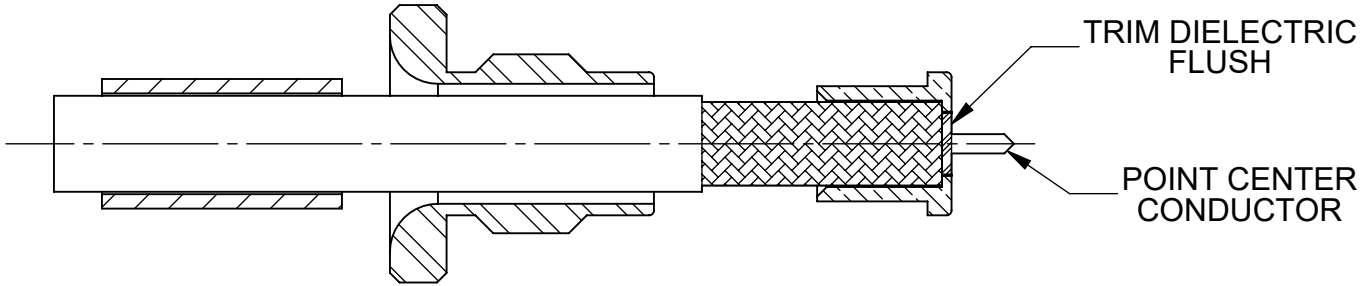
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	DCN 49553	01/20	SEE PDM
A	DCN 51686	06/22	



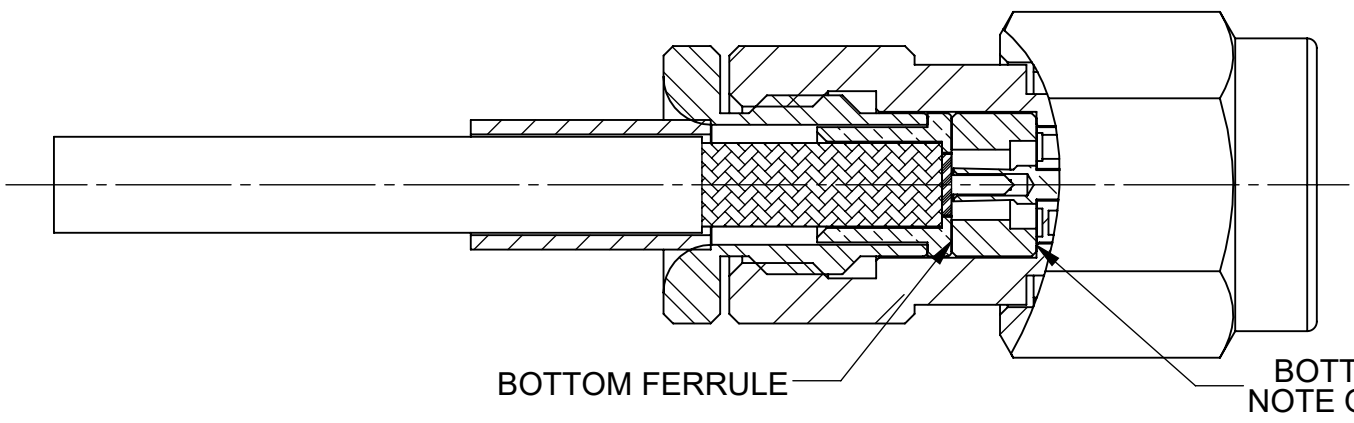
STEP 1:
 1.1) TRIM CABLE JACKET AND BRAID TO DIMENSIONS SHOWN
 1.2) TIN DIP CABLE UP TO CABLE JACKET



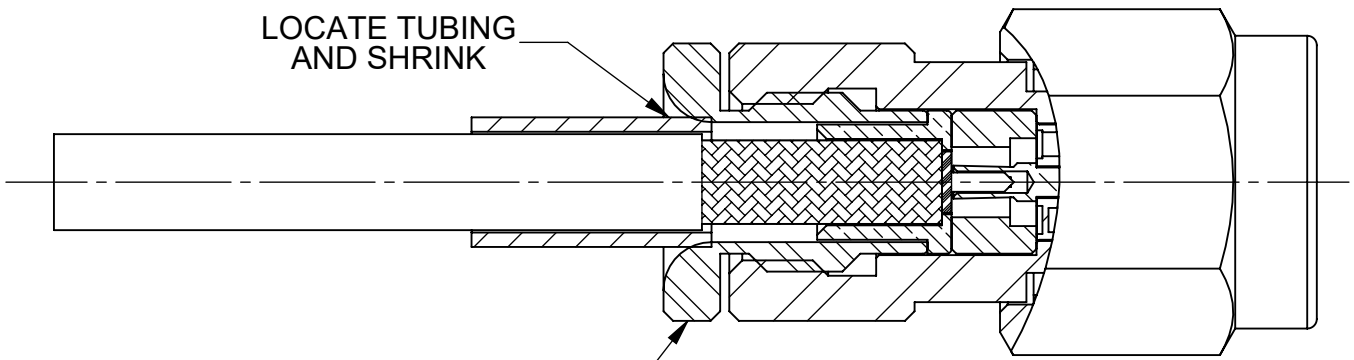
STEP 2:
 2.1) SLIDE SHRINK TUBING AND CLAMP NUT OVER CABLE.
 2.2) BOTTOM CABLE BRAID ON CABLE STOP INSIDE FERRULE.
 2.3) SOLDER CABLE BRAID TO FERRULE.



STEP 3:
 3.1) TRIM DIELECTRIC FLUSH WITH FACE OF FERRULE.
 3.2) POINT CENTER CONDUCTOR.



STEP 4:
 4.1) INSTALL INSERT INTO CONNECTOR BODY. FOR 2.92mm AND 2.4mm NOTE ORIENTATION OF INSERT. FOR 1.85mm NO ORIENTATION.
 4.2) BOTTOM FERRULE AND CABLE AGAINST INSERT.



STEP 5:
 5.1) TORQUE CLAMP NUT INTO BODY.(7-10 IN-LBS RECOMMENDED)
 5.2) LOCATE SHRINK TUBING AGAINST CLAMP NUT AND SHRINK OVER CABLE.

NOTES:
 1. FOR CONNECTORS WITH DATE CODE EARLIER THAN 08/20 PLEASE CONTACT SALES AT SV MICROWAVE (sales@svmicrowave.com).

0.085 mmWAVE
 USED ON:

MATERIAL:	N/A
FINISH:	N/A
SURFACE AREA:	N/A
PROPRIETARY	
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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 .005 T.I.R.	
6) REMOVE ALL BURRS	
DRAWN:	DEF 01/23/20
CHECKED:	SEE PDM
APPROVED:	SEE PDM
E.M. SIMULATION:	N/A

Amphenol
 www.svmicrowave.com

TITLE:
 CABLE ASSEMBLY INSTRUCTIONS

SIZE	DWG. NO.	300-33-010
B		

SCALE: 5:1 SHEET 1 OF 1