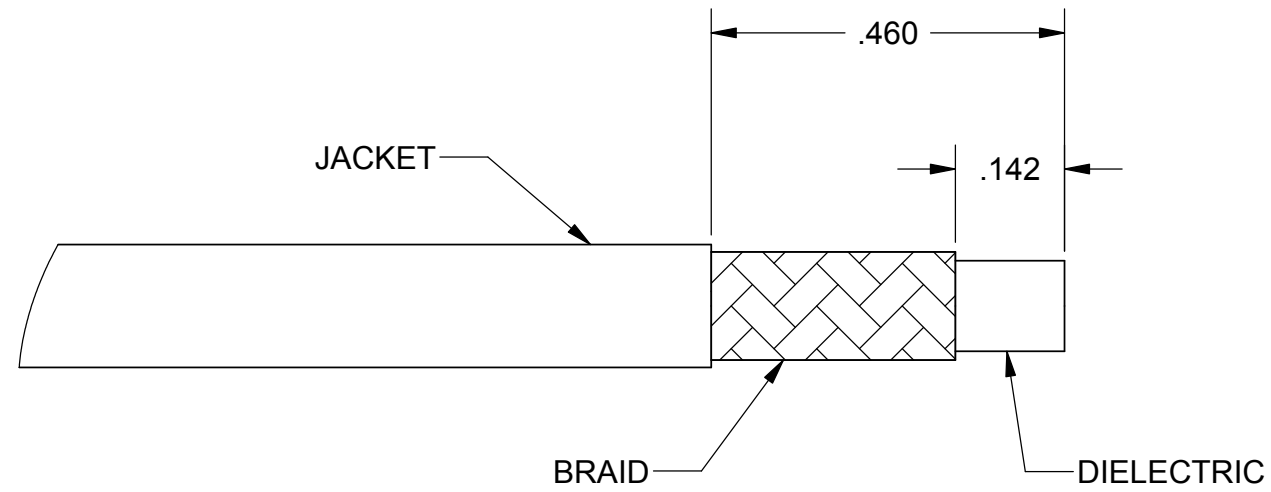
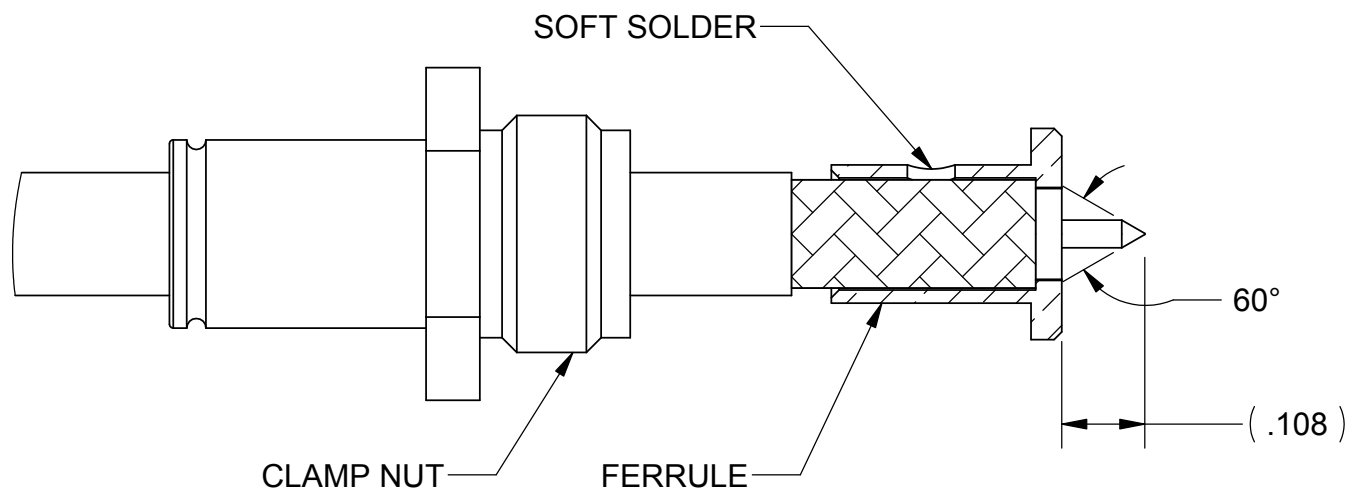


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	NRN 36014	05/10	STW
A	DCN 41948	12/15	STW



STEP 1.

- 1.1) TIN DIP CABLE SN63.
- 1.2) TRIM CABLE AS SHOWN.



STEP 2.

- 2.1) SLIDE SHRINK TUBING (IF SUPPLIED) AND CLAMP NUT ON CABLE
- 2.2) INSERT CABLE INTO REAR OF FERRULE AND BOTTOM AGAINST CABLE REFERENCE PLANE.
- 2.3) SOFT SOLDER CABLE TO FERRULE USING Sn63 SOLDER.
- 2.4) REMOVE EXCESS SOLDER AS NECESSARY.
- 2.5) TRIM DIELECTRIC FLUSH TO FLANGE OF THE FERRULE.
- 2.6) CHAMFER CENTER CONDUCTOR AS SHOWN.

NOTE 3.

- 3.1) INSTALL CABLE ASSEMBLY INTO BODY.
- 3.2) SLIDE CLAMP NUT FORWARD AND TIGHTEN 25-35 IN.-LBS.

MATERIAL:	N/A	DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL: ±1/64 ANGULAR: X° ±1'0" X'X' ±15' DECIMAL: X ±.030 .XX ±.010 .XXX ±.005	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	SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409 TITLE: CABLE ASSEMBLY INSTRUCTIONS
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.		INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	DRAWN: PJS 05/21/10	SIZE: B CAGE CODE: 95077 DWG. NO.: 300-45-021
4521-60024	USED ON:	THIRD ANGLE PROJECTION	CHECKED: STW 05/21/10	SCALE: 4:1
			APPROVED: STW 05/21/10	SHEET 1 OF 1
			E.M. SIMULATION: N/A	