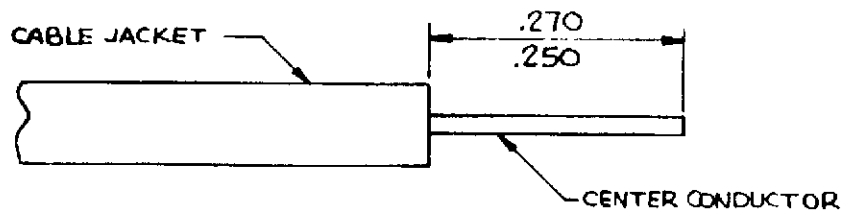


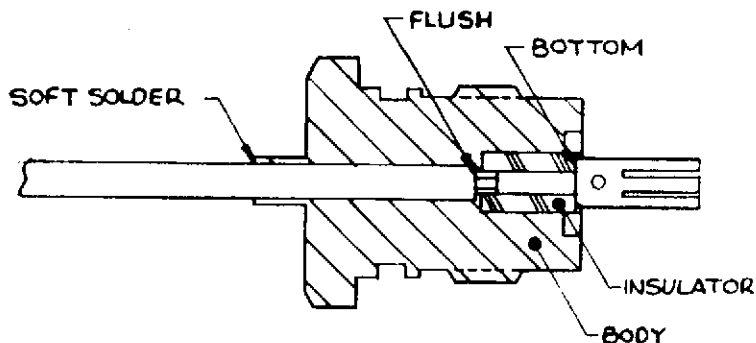
300-80-249

STEP 1



STEP 1
TRIM CABLE TO DIMENSION SHOWN LEAVING CENTER CONDUCTOR EXPOSED. DO NOT NICK CENTER CONDUCTOR.

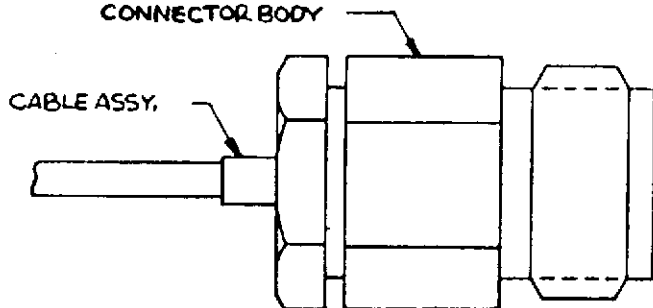
STEP 2



STEP 2
INSERT CABLE INTO BODY/INSULATOR ASSY. USING 60/40 SOLDER, SOLDER CABLE FLUSH WITH INSIDE SHOULDER AS SHOWN. PRE-TIN CENTER CONTACT CABLE HOLE. INSERT CONTACT THROUGH INSULATOR AND SOLDER IN PLACE BOTTOMING AGAINST INSULATOR.

STEP 3

PICTORIAL REPRESENTATION ONLY
CONNECTOR BODY



STEP 3
THREAD CABLE ASSEMBLY INTO CONNECTOR BODY AND TORQUE TO 45 INCH POUNDS.

FOR USE ON: SF6545-6013
6545-6017

SYM	DESCRIPTION	DATE	APPR	UNLESS OTHERWISE SPECIFIED 1. REMOVE ALL BURRS 2. BREAK ALL CORNERS & EDGES .005 R MAX. 3. CHAMFER 1ST & LAST THREADS 45° 4. SURFACE ROUGHNESS #3 ✓ MIL STD-10 5. DIAMETERS ON COMMON CENTERS TO BE CONCENTRIC WITHIN TIR 6. ALL DIMENSIONS ARE AFTER PLATING	SOLITRON/MICROWAVE		REF.
					PORT SALERNO, FLORIDA		MATERIAL
—	RELEASE F-7661	2-80	N	DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS FRACTIONAL ANGULAR .X ± .030 X' ± 1'0" XX ± .015 ± 1/64 X'X ± 15' XXX ± .005	FINISH	CABLE ASSEMBLY INSTRUCTIONS	
				DRAWN S.ZINAICH DATE 2-25-80	SCALE	CODE IDENT NO.	DRAWING NO.
				CHECKED N DATE 2-25-80	—	95077	300-80-249
				APPROVED DGG DATE 2/25/80		A	