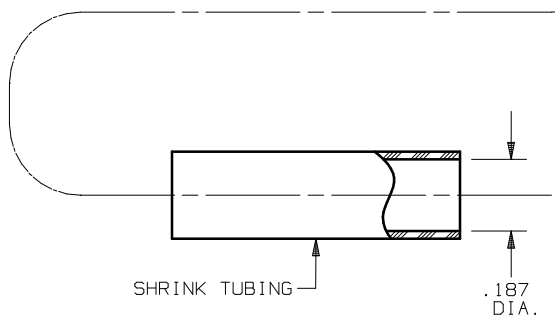
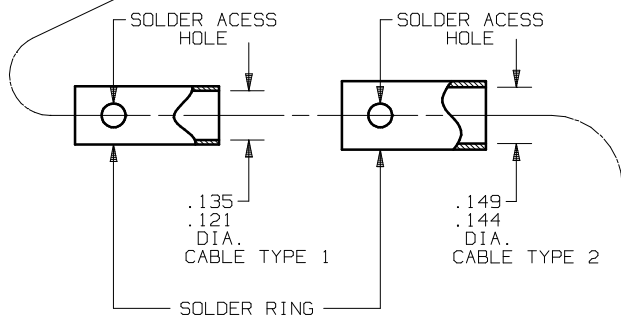
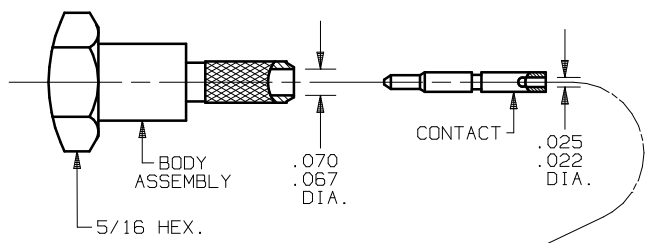


# SV Microwave Inc.

MARK LABEL PER PARTS LIST

CONNECTOR TYPE....SMA PLUG  
 SOLDER ATTACHMENT  
 CABLE TYPE.....TYPE 1: RG-174 & 316  
 TYPE 2: M177/152-00001  
 SPECIAL TOOL.....NO SPECIAL TOOLS REQUIRED

## PARTS SUPPLIED



UNFOLD FOR ASSEMBLY INSTRUCTIONS  
 CABLE ASSEMBLY PART NUMBER 300-80-369.

SYM.	DESCRIPTION	DATE	APPR.
-	REL. DCN F8357	06/81	DGG
A	REV. DCN 25530	08/99	STM
B	REV. DCN 26652	01/01	STM

UNLESS OTHERWISE SPECIFIED:  
 1) ALL DIMENSIONS ARE AFTER PLATING.  
 2) BREAK CORNERS & EDGES .005 R. MAX.  
 3) CHAM. 1<sup>ST</sup> & LAST THDS.  
 4) SURFACE ROUGHNESS 63 / MIL-STD-10.  
 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.  
 6) REMOVE ALL BURRS.

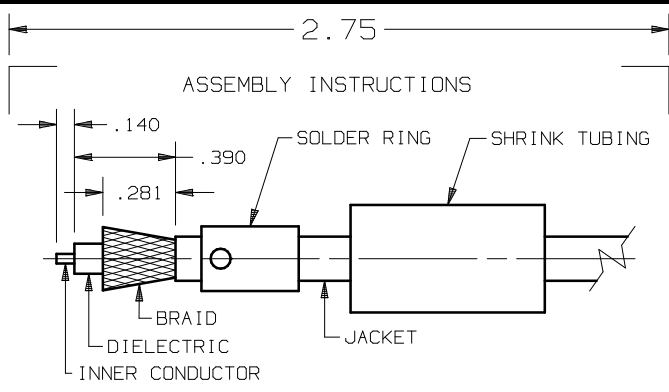
REDRAWN: BRT 8/13/99  
 CHECKED:  
 APPROVED: ND 6/25/81

DIMENSIONS ARE IN INCHES	
DECIMALS	TOLERANCES:
.X ±.030	FRACTIONAL
.XX ±.015	±1/64
.XXX ±.005	
ANGULAR	
X° ±1.0'	
X°X' ±15'	
FINISH:	AREA:
N/A	N/A
SIZE	CODE IDENT.
A	95077
SCALE	N/A

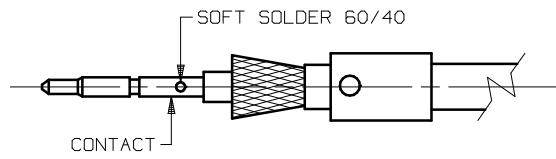
**SV Microwave, Inc.**  
 3301 Electronics Way  
 West Palm Beach, FL 33407

TITLE:  
 CABLE ASSEMBLY INSTRUCTIONS

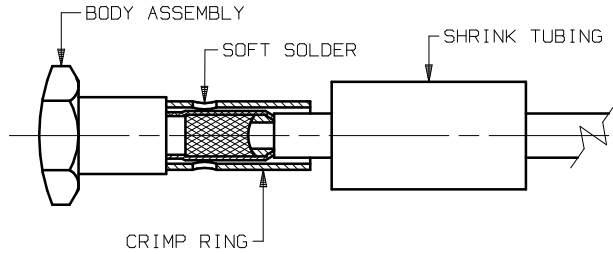
DMG. NO.  
 SHT. 1 OF 2  
 300-80-369



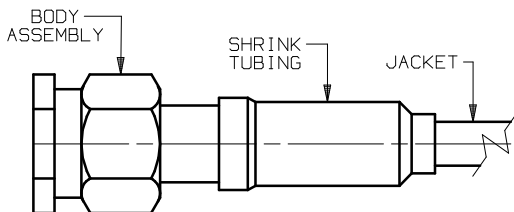
- 1.0 PREPARE CABLE END
- 1.1 SLIDE SHRINK TUBING AND SOLDER RING ONTO CABLE.
  - 1.2 TRIM CABLE JACKET, BRAID, DIELECTRIC & INNER CONDUCTOR TO DIMENSIONS SHOWN. WITHOUT NICKING BRAID.
  - 1.3 FLARE BRAID AS SHOWN.



- 2.0 ATTACH CONTACT TO CABLE
- 2.1 TIN INNER CONDUCTOR.
  - 2.2 SLIDE CONTACT ONTO INNER CONDUCTOR AND BOTTOM ON CABLE DIELECTRIC.
  - 2.3 SOFT SOLDER CONTACT ONTO INNER CONDUCTOR.
  - 2.4 REMOVE EXCESS SOLDER.



- 3.0 ATTACH CABLE BRAID TO BODY ASSEMBLY
- 3.1 SLIDE BODY ASSEMBLY ONTO CABLE DIELECTRIC AND BOTTOM.
  - 3.2 SLIDE CRIMP RING OVER FLARED BRAID AND POSITION AS SHOWN.
  - 3.3 SOFT SOLDER CRIMP RING TO BRAID AND CONNECTOR FERRULE THRU ACCESS HOLES.



- 4.0 ATTACH SHRINK TUBING
- 4.1 SLIDE SHRINK TUBING OVER JACKET AND CRIMP RING AND POSITION AS SHOWN.
  - 4.2 APPLY HEAT (275°F MIN.) TO SHRINK TUBING TO COMPLETE ASSEMBLY.

8.00

SYM.	DESCRIPTION	DATE	APPR.
-	REL. NRN F8357	06/81	DGG
A	REV. DCN 25530	08/99	STM
B	REV. DCN 26652	01/01	STM

UNLESS OTHERWISE SPECIFIED:  
 1) ALL DIMENSIONS ARE AFTER PLATING.  
 2) BREAK CORNERS & EDGES .005 R. MAX.  
 3) CHAM. 1st & LAST THDS.  
 4) SURFACE ROUGHNESS 63 / MIL-STD-10.  
 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.  
 6) REMOVE ALL BURRS.

REDRAWN: BRT 8/13/99  
 CHECKED:  
 APPROVED: ND 6/25/81

DIMENSIONS ARE IN INCHES	
DECIMALS .X ±.030 .XX ±.015 .XXX ±.005	TOLERANCES: FRACTIONAL ±1/64
ANGULAR X° ±1.0' X' ±15'	
FINISH: N/A	AREA: N/A
SIZE CODE IDENT. A 95077	SCALE N/A

**SV Microwave, Inc.**  
 3301 Electronics Way  
 West Palm Beach, FL, 33407

**CABLE ASSEMBLY INSTRUCTIONS**

DWG. NO. 300-80-369  
 SHT. 2 OF 2