

# Soliton/Vector

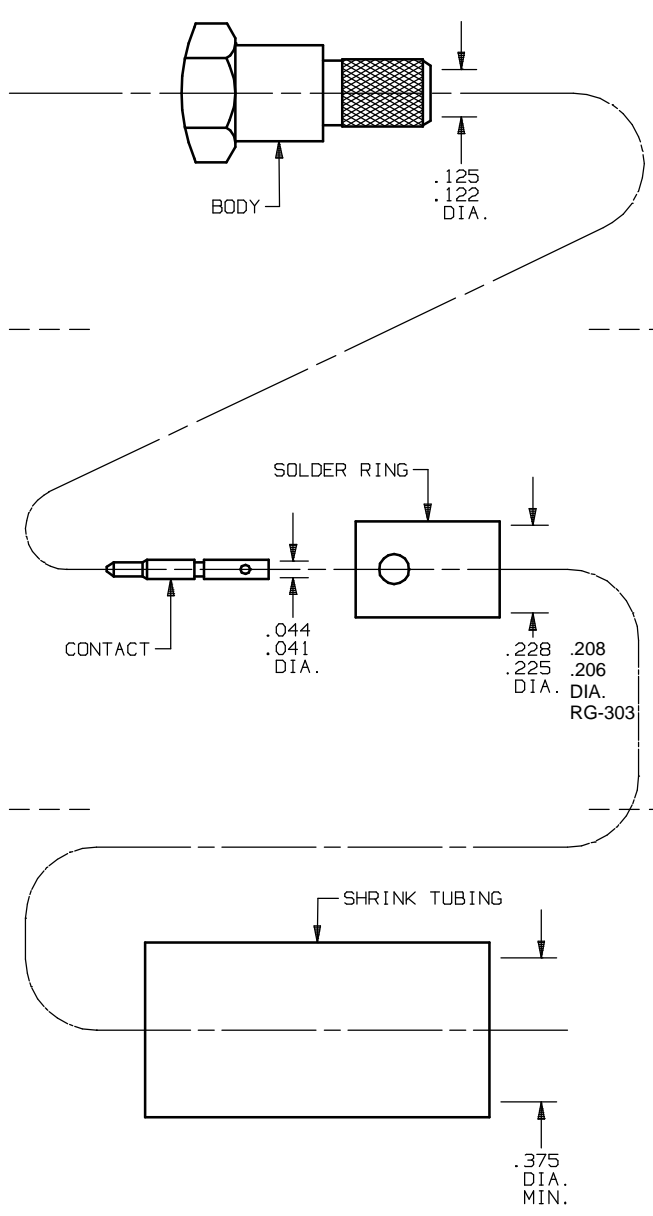
MARK LABEL PER PARTS LIST

CONNECTOR TYPE....SMA PLUG  
SOLDER ATTACHMENT

CABLE TYPE.....RG-142, RG-400 & RG-223 ,RG-303

SPECIAL TOOL.....NO SPECIAL TOOLS REQUIRED

## PARTS SUPPLIED



UNFOLD FOR ASSEMBLY INSTRUCTIONS  
CABLE ASSEMBLY PART NUMBER 300-80-370.

SYM.	DESCRIPTION	DATE	APPR.
-	REL. DCN F8357	06/81	DGG
A	REV. DCN 25695	11/99	STM

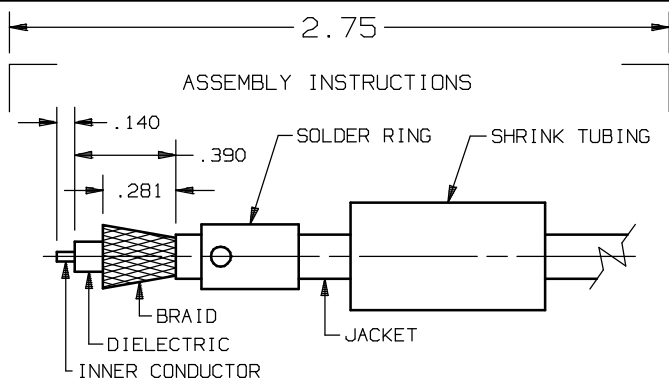
UNLESS OTHERWISE SPECIFIED:  
 1) ALL DIMENSIONS ARE AFTER PLATING.  
 2) BREAK CORNERS & EDGES .005 R. MAX.  
 3) CHAM. 1st & LAST THDS.  
 4) SURFACE ROUGHNESS 63 / MIL-STD-10.  
 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.  
 6) REMOVE ALL BURRS.

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

**SOLITRON/VECTOR MICROWAVE**  
 3301 ELECTRONICS WAY  
 WEST PALM BEACH FL., 33407

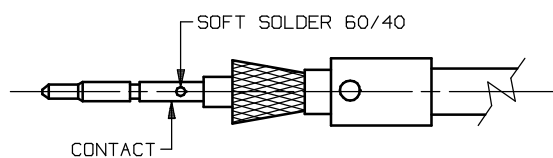
TITLE:  
**CABLE ASSEMBLY INSTRUCTIONS**

DMG. NO. 300-80-370  
 SHT. 1 OF 2

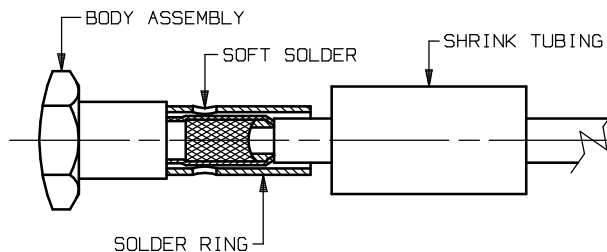


ASSEMBLY INSTRUCTIONS

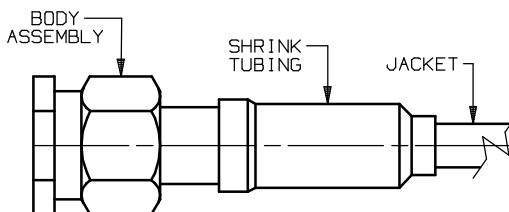
- 1.0 PREPARE CABLE END
  - 1.1 SLIDE SHRINK TUBING AND SOLDER RING ONTO CABLE.
  - 1.2 TRIM CABLE JACKET, BRAID, DIELECTRIC & INNER CONDUCTOR TO DIMENSIONS SHOWN. WITHOUT NICKING BRAID.
  - 1.3 FLARE BRAID AS SHOWN.



- 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

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REDRAWN: BRT 11/16/99  
 CHECKED:  
 APPROVED: DGG 6/25/81

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

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 WEST PALM BEACH, FL., 33407

TITLE:  
**CABLE ASSEMBLY INSTRUCTIONS**

DMG. NO. 300-80-370  
 SHT. 2 OF 2