

2.75

SV MICROWAVE INC.

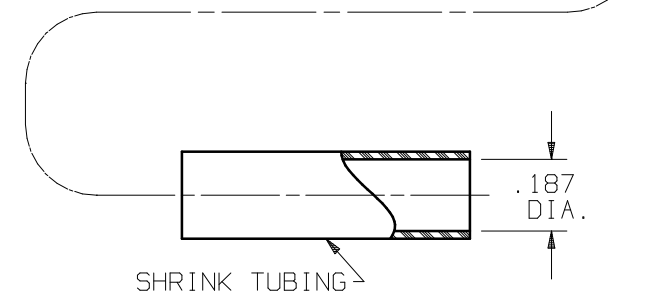
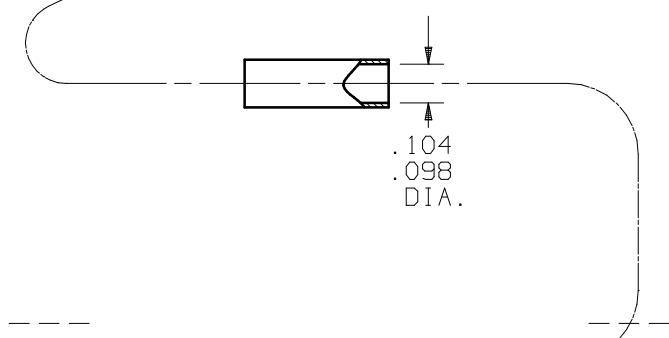
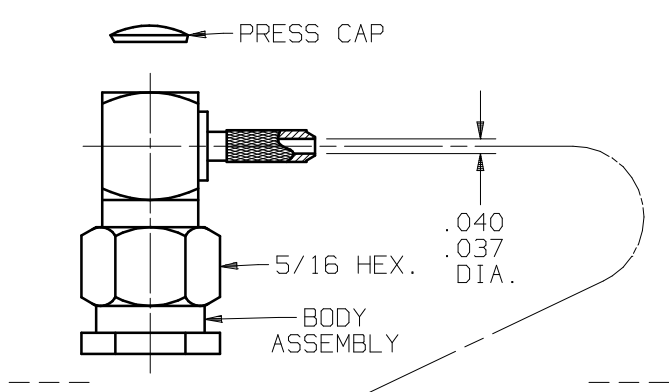
MARK LABEL PER PARTS LIST

CONNECTOR TYPE....SMA R/A PLUG
CRIMP ATTACHMENT

CABLE TYPE.....RG-178

SPECIAL TOOL.....CRIMP TOOL M22520/5-33
CLOSURE B(.105 DIE.)

PARTS SUPPLIED



8.00

UNFOLD FOR ASSEMBLY INSTRUCTIONS
CABLE ASSEMBLY PART NUMBER 300-80-474.

SYM.	DESCRIPTION	DATE	APPR.
B	REV. DCN F11855	07/90	RG
C	REV. DCN 24723	09/98	STM
D	REV. DCN 29623	03/03	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.

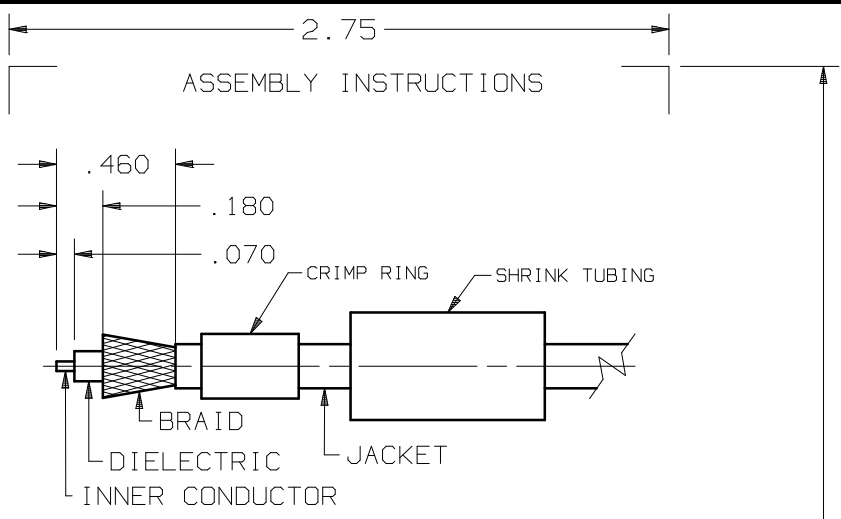
REDRAWN: BRT 9/14/98
 CHECKED: RG 1/25/83
 APPROVED: PMG 1/25/83

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 DECIMALS .X ±.030
 .XX ±.015
 .XXX ±.005
 FRACTIONAL ±1/64
 ANGULAR X° ±1.0'
 X°X' ±15'

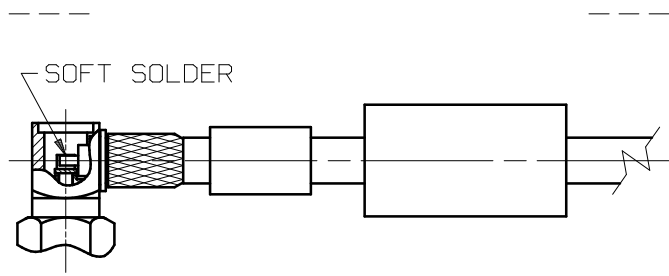
FINISH: N/A
 AREA: N/A
 SIZE CODE IDENT SCALE
 A 95077 N/A

SV Microwave, Inc.
 2400 Centrepark West Drive, Suite 100
 West Palm Beach, FL 33409

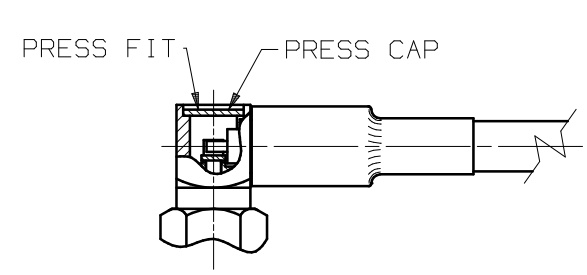
CABLE ASSEMBLY INSTRUCTIONS
 DMG. NO. 300-80-474
 SHT. 1 OF 2



- 1.0 PREPARE CABLE END
 - 1.1 SLIDE SHRINK TUBING AND CRIMP 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 CABLE TO CONNECTOR
 - 2.1 INSERT PREPARED CABLE END INTO FERRULE END OF CONNECTOR. POSITION INNER CONDUCTOR INTO SLOT. SOFT SOLDER CONDUCTOR TO CONTACT.
 - 2.2 SLIDE CRIMP RING OVER BRAID AND FERRULE. CRIMP "CRIMP RING" USING CRIMP TOOL M22550/10-05 (.105 DIE.). TRIM EXCESS BRAID IF NECESSARY.



- 3.0 ENCLOSING CONNECTOR OPENING
 - 3.1 PRESS CAP INTO RECESS OF CONNECTOR.
 - 3.2 SLIDE SHRINK TUBING OVER CRIMP RING.
 - 3.3 APPLY HEAT (275° MIN) TO SHRINK TUBING COMPLETING ASSEMBLY.

8.00

SYM.	DESCRIPTION	DATE	APPR.	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.	DIMENSIONS ARE IN INCHES DECIMALS X ±.030 .XX ±.015 .XXX ±.005 FRACTIONAL ±1/64 ANGULAR X° ±1.0' X°X' ±15'	FINISH:	AREA:	SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409 TITLE: CABLE ASSEMBLY INSTRUCTIONS
B	REV. DCN F11855	07/90	RG			REDRAWN:	BRT 9/14/98	
C	REV. DCN 24723	09/98	STM			CHECKED:	RG 1/25/83	
D	REV. DCN 29623	03/03	STM			APPROVED:	PMG 1/25/83	
						SIZE	A	
						CODE IDENT.	95077	
				SCALE	N/A			
				DWG. NO.	300-80-474			
				SHT. 2 OF 2				