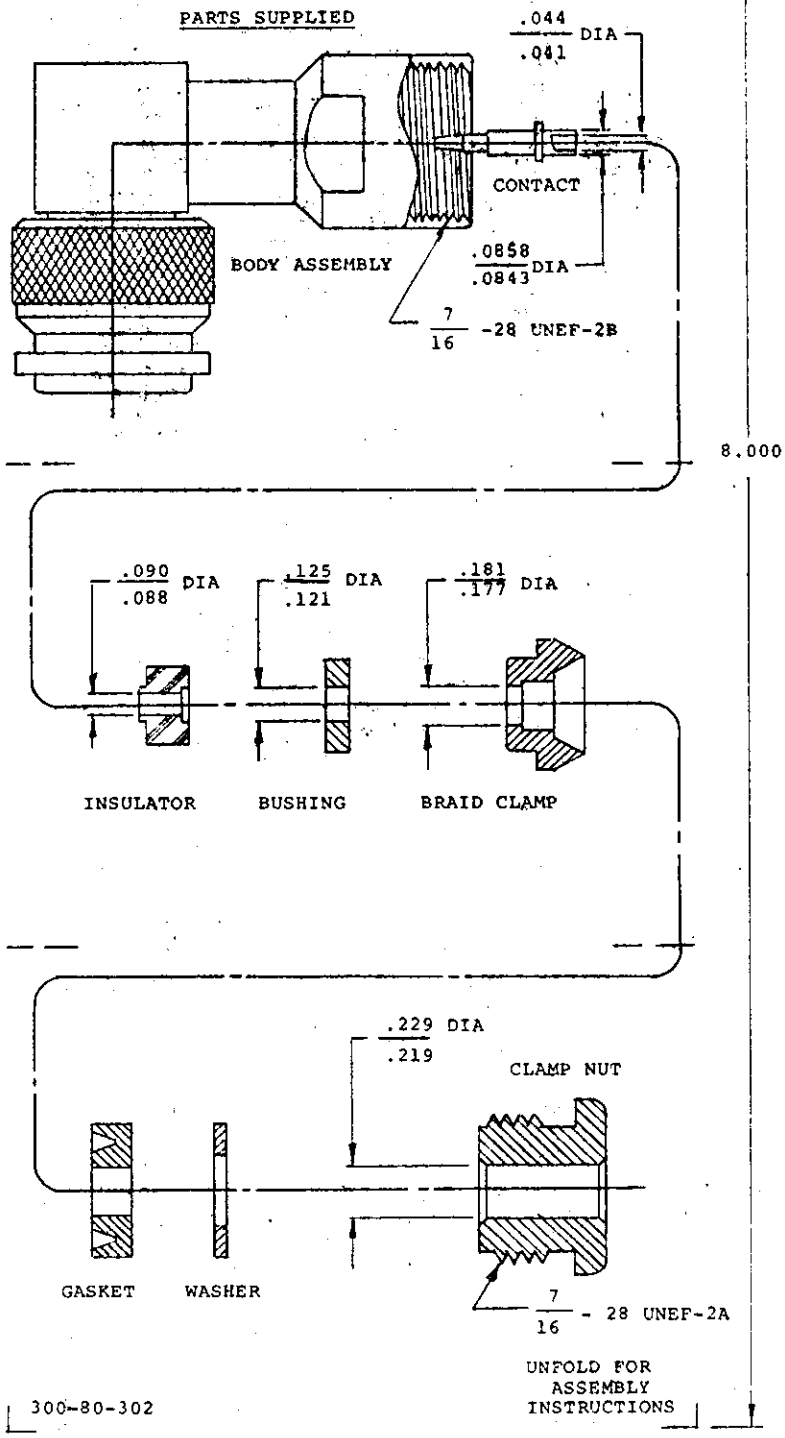
MARK LABLE PER PARTS LIST

Connector Type.....TNC Plug, Right Angle, Cabled, UG Clamp Attachment.
Cable Type.....RG-58, 142, 223, 400.
Special Tools.....None

PARTS SUPPLIED



300-80-302

SYM	DESCRIPTION	DATE	APPR.
1	REL. F 9086	9-82	

UNLESS OTHERWISE SPECIFIED
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES: THREE PLACE DECIMALS ±.005, TWO PLACE DECIMALS ±.010, ANGULAR ±1°
3. REMOVE ALL BURRS & SHARP EDGES .005 MAX.
4. CHECKER LIST & LAST THREADS 45°
5. ALL DIAMETERS TO BE CONCENTRIC WITHIN: T.I.R.
6. SURFACE ROUGHNESS (MIL-STD-10)

DRAWN JBM DATE 9-23-82
CHECKED RG DATE 9-29-82
APPROVED DATE 9-29-82

SOLITRON/MICROWAVE
PORT SALER NO. FLORIDA

MATERIAL
FINISH
AREA
SCALE
CODE IDENT NO. 95077
SIZE B
REF.
TITLE CABLE ASSEMBLY INSTRUCTIONS
DRAWING NO. 300-80-479
SHEET 1 OF 2

SIZE B
DRAWING NO. 300-80-479

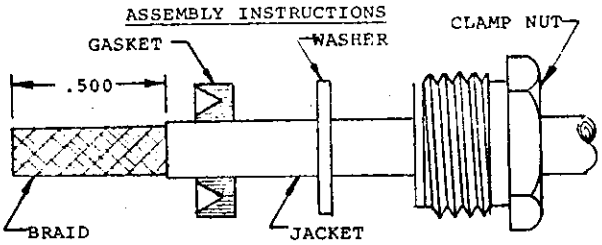
"A" SIZE COPY

"A" SIZE COPY

2.750

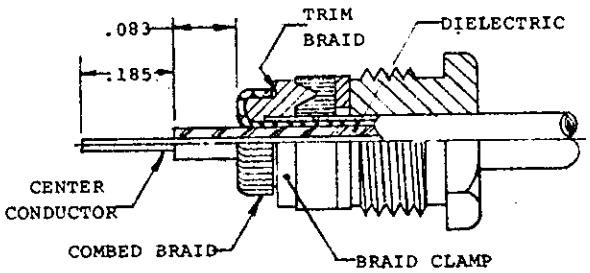
8.000

ASSEMBLY INSTRUCTIONS



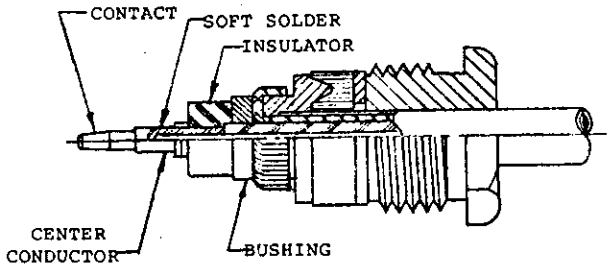
1.0 PREPARE CABLE END

1.1 Slide clamp nut, washer and gasket onto cable.
1.2 Trim cable jacket and braid to dimension shown, without nicking braid.



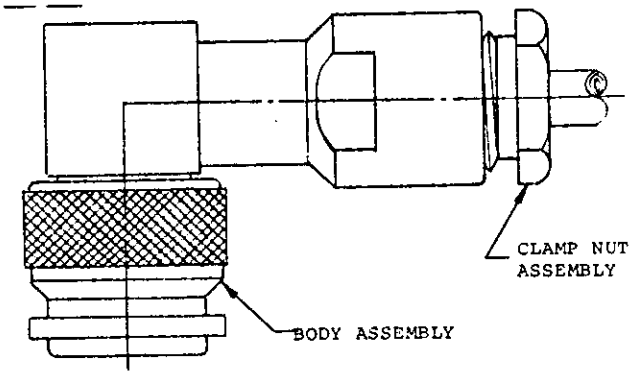
2.0 FORM CABLE BRAID OVER CLAMP

2.1 Comb out briad.
2.2 Install Clamp and fold braid back over clamp.
2.3 Trim excess Braid.
2.4 Trim cable dielectric and center conductor to dimensions shown.
2.5 Tin center conductor.



3.0 SOLDER CONTACT

3.1 Install bushing, insulator and contact bottoming each.
3.2 Soft solder contact to center conductor.
3.3 Remove excess solder.



4.0 INSTALL CLAMP NUT ASSY INTO BODY ASSY

4.1 Thread clamp nut assembly into body assembly and wrench tighten to recommended torque 25-30 inch pounds.

SYM	DESCRIPTION	DATE	APPR.
—	REL. F90BG	4-82	

UNLESS OTHERWISE SPECIFIED
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES: THREE PLACE DECIMALS ±.005; TWO PLACE DECIMALS ±.010; ANGULAR ±1°
3. REMOVE ALL BURRS & SHARP EDGES .005 MAX
4. CHAMFER 1ST & LAST THREADS 45°
5. ALL DIAMETERS TO BE CONCENTRIC WITHIN .002
6. SURFACE ROUGHNESS (MIL-STD-10)

DRAWN JBM DATE 4-23-82
CHECKED RG DATE 4-24-82
APPROVED DATE 4-28-82

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

MATERIAL
FINISH
AREA

SCALE
CODE IDENT NO. 95077
SIZE B

TITLE CABLE ASSEMBLY INSTRUCTIONS

DRAWING NO. 300-80-479
SHEET 2 OF 2

REF.

SIZE B
DRAWING NO. 300-80-479