

# SV Microwave Inc.

MARK LABEL PER PARTS LIST

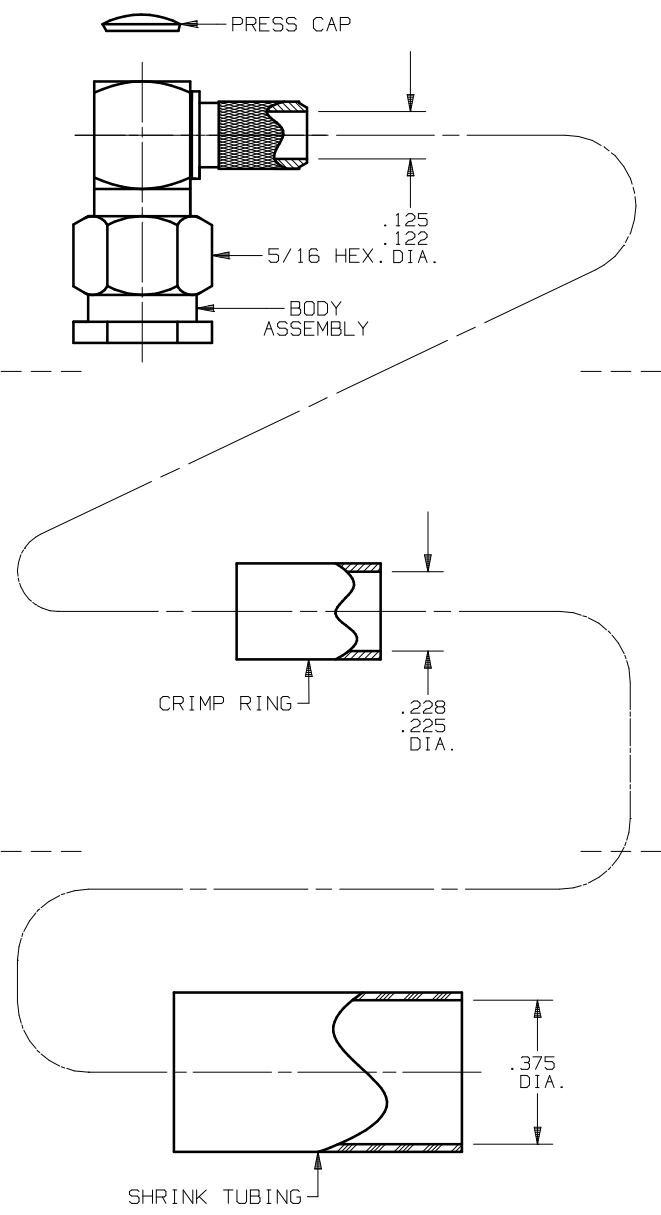
CONNECTOR TYPE.....SMA R/A PLUG  
CRIMP ATTACHMENT

CABLE TYPE.....RG-55,142,223 & 400

SPECIAL TOOL.....PREFERRED DIE M22520/5-19  
CLOSURE B, ALTERNATE DIE  
M22520/5-05 CLOSURE A OR  
-11, -57, CLOSURE A

INSTRUCTIONS FOR:..M39012/56-3028, M39012/56-3128,  
M39012/56B3015, M39012/56B3115

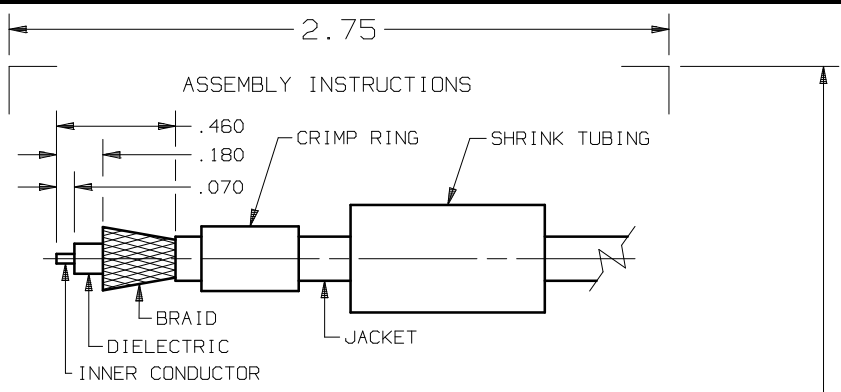
## PARTS SUPPLIED



UNFOLD FOR ASSEMBLY INSTRUCTIONS  
CABLE ASSEMBLY PART NUMBER 300-80-580.

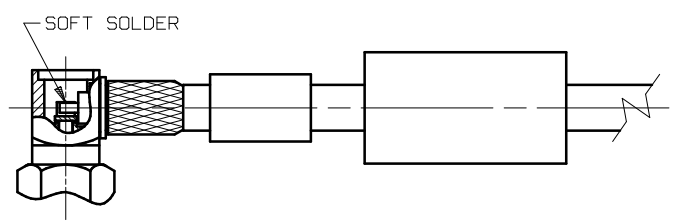
SYM.	DESCRIPTION	DATE	APPR.	UNLESS OTHERWISE SPECIFIED:			
C	REV. DCN F11855	07/90	RG	1) ALL DIMENSIONS ARE AFTER PLATING.			
D	REV. DCN 24893	11/98	STM	2) BREAK CORNERS & EDGES .005 R. MAX.			
E	REV. DCN 30782	12/03	BRT	3) CHAM. 1st & LAST THDS.			
				4) SURFACE ROUGHNESS 63 J MIL-STD-10.			
				5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.			
				6) REMOVE ALL BURRS.			
				REDRAWN: BRT 11/18/98			
				CHECKED:			
				APPROVED: NID 3/01/86			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES:			
				DECIMALS	FRACTIONAL	ANGULAR	
				X ±.030	±1/64	X° ±1.0'	
				.XX ±.015		X°X' ±15'	
				.XXX ±.005			
				MATERIAL: N/A			
				FINISH: N/A			
				AREA: N/A			
				SIZE	CODE IDENT.	SCALE	
				A	95077	N/A	
				DMG. NO. 300-80-580			
				SHT. 1 OF 2			
				CABLE ASSEMBLY INSTRUCTIONS			
				SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409			

8.00

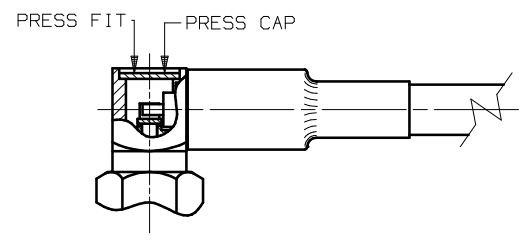


ASSEMBLY INSTRUCTIONS

- 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 M22550/5-19, CLOSURE B (.213 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

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REDRAWN: BRT 11/18/98  
 CHECKED:  
 APPROVED: ND 3/01/86

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

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

TITLE:  
**CABLE ASSEMBLY INSTRUCTIONS**

DMG. NO. SH. 2 OF 2  
**300-80-580**