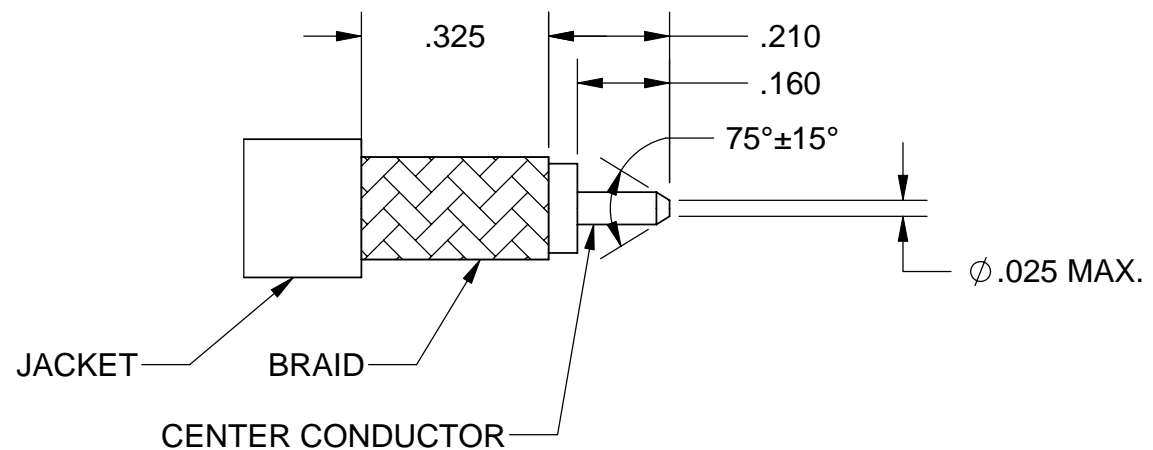


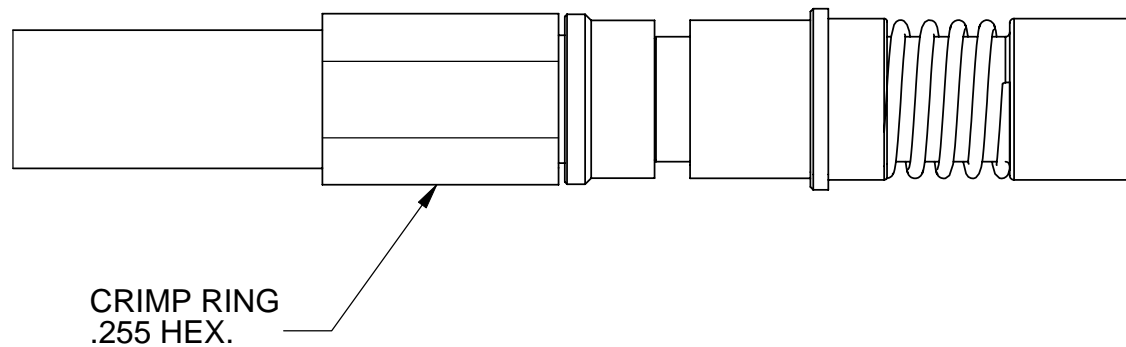
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	REL. NRN 35067	10/22/08	STW



STEP 1

TRIM CABLE PER DIMENSIONS SHOWN.

REMOVE ANY DIELECTRIC FROM THE CENTER CONDUCTOR AND DEBURR AND POINT CENTER CONDUCTOR, AS SHOWN.



STEP 2

INSERT CABLE INTO CONNECTOR UNTIL FULLY SEATED, WITH ALL BRAID WIRES ON THE OUTSIDE OF CONNECTOR BODY AND ALUMINUM TAPE INSIDE CONNECTOR BODY. CENTER CONDUCTOR WILL INSERT INTO SOCKET CONTACT WITHIN THE ASSEMBLY.

SLIDE CRIMP RING FORWARD AND CRIMP AS CLOSE AS POSSIBLE TO BODY USING M22520/10-03, .255 DIE.

IF APPLICABLE HEAT SHRINK TUBING OVER REAR OF CONNECTOR BODY AND DOWN ONTO CABLE JACKET USING HOT AIR GUN.

MATERIAL: PER BOM	DIMENSIONS ARE IN INCHES TOLERANCES:	UNLESS OTHERWISE SPECIFIED	SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409 TITLE: CABLE ASSEMBLY INSTRUCTIONS
FINISH: PER BOM	FRACTIONAL: ±1/64 ANGULAR: X° ±1°0' X'X' ±15'	1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1ST & LAST THREADS. 4) SURFACE ROUGHNESS 63 √ MIL-STD-10. 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .004 T.I.R. 6) REMOVE ALL BURRS	
SURFACE AREA: N/A	DECIMAL: X ±.030 .XX ±.010 .XXX ±.005	INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	DWG. NO. 300-89-012 SCALE: 1:8
PROPRIETARY THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SV MICROWAVE, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SV MICROWAVE, INC IS PROHIBITED.	THIRD ANGLE PROJECTION	DRAWN: JMC 10/22/08 CHECKED: STW 10/22/08 APPROVED: STW 10/22/08 E.M. SIMULATION: N/A	
SF9811-60003	USED ON:	SIZE B CAGE CODE 95077	SHEET 1 OF 1