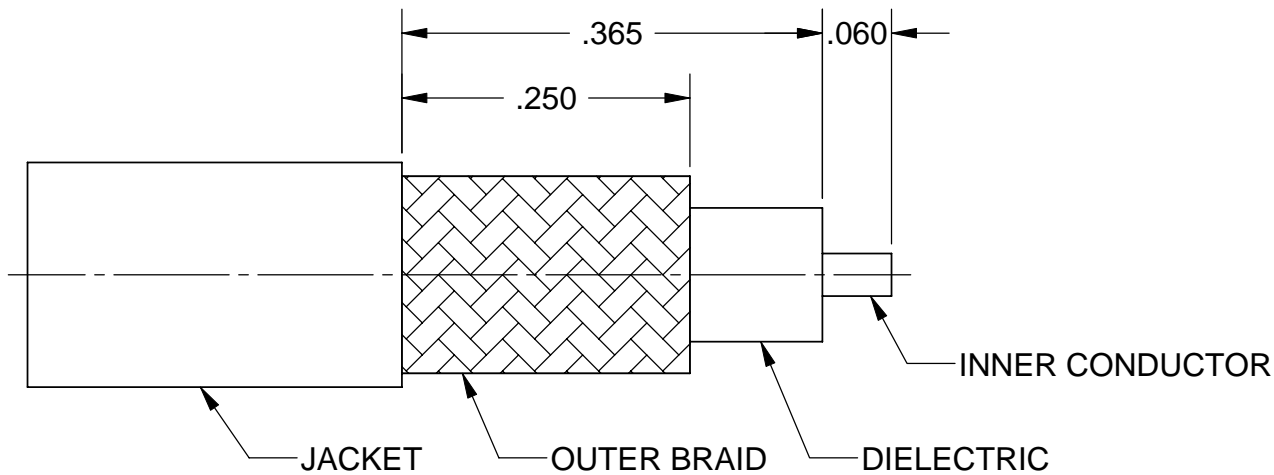
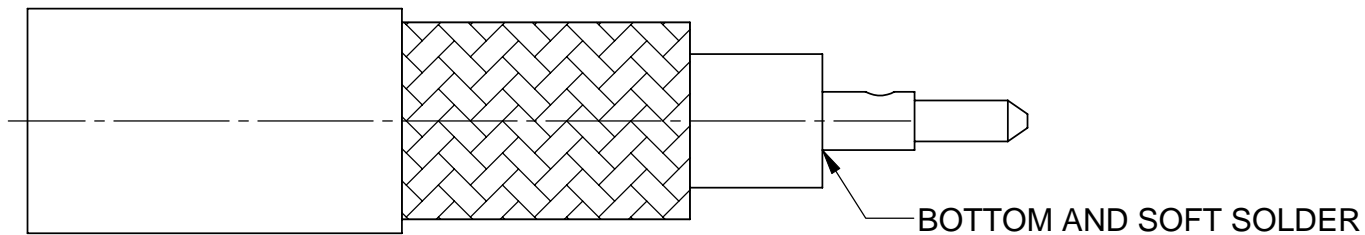


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	NRN 35420	06/09	STW



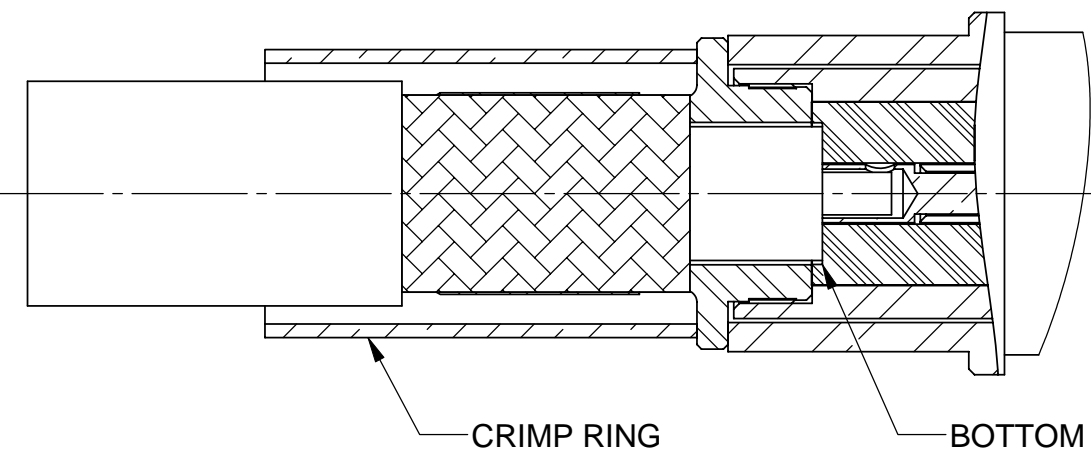
STEP 1:
 SLIDE SHRINK TUBING AND CRIMP RING ONTO CABLE. TRIM CABLE JACKET, BRAID, DIELECTRIC, AND INNER CONDUCTOR TO DIMENSIONS AS SHOWN. DO NOT NICK INNER CONDUCTOR OR BRAID.



STEP 2:
 TIN INNER CONDUCTOR AND SOFT SOLDER CONTACT ONTO INNER CONDUCTOR. REMOVE EXCESS SOLDER.

STEP 3:
 INSERT CONNECTOR ONTO CABLE UNDER BRAID UNTIL DIELECTRIC BOTTOMS. SLIDE CRIMP RING FORWARD OVER BRAID AS SHOWN AND CRIMP WITH A .213 HEX. DIE.

STEP 4:
 SLIDE SHRINK TUBING FORWARD OVER CRIMP RING AND CONNECTOR BODY AND SHRINK IN PLACE (NOT SHOWN).



MATERIAL:	N/A	DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL: $\pm 1/64$ ANGULAR: X° $\pm 1'0$ X'X' $\pm 15'$ DECIMAL: X $\pm .030$.XX $\pm .010$.XXX $\pm .005$	UNLESS OTHERWISE SPECIFIED 1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1ST & LAST THREADS. 4) SURFACE ROUGHNESS 63 $\sqrt{\text{MIL-STD-10}}$. 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .005 T.I.R. 6) REMOVE ALL BURRS	SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409
FINISH:	N/A			
SURFACE AREA:	N/A			
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.		INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	DRAWN: DAL 06/26/09 CHECKED: STW 06/26/09 APPROVED: STW 06/26/09 E.M. SIMULATION: N/A	TITLE: CABLE ASSEMBLY INSTRUCTIONS
SF9811-6002	USED ON:	THIRD ANGLE PROJECTION 	DWG. NO. 300-89-014	SIZE B CAGE CODE 95077
			SCALE: 6:1	SHEET 1 OF 1