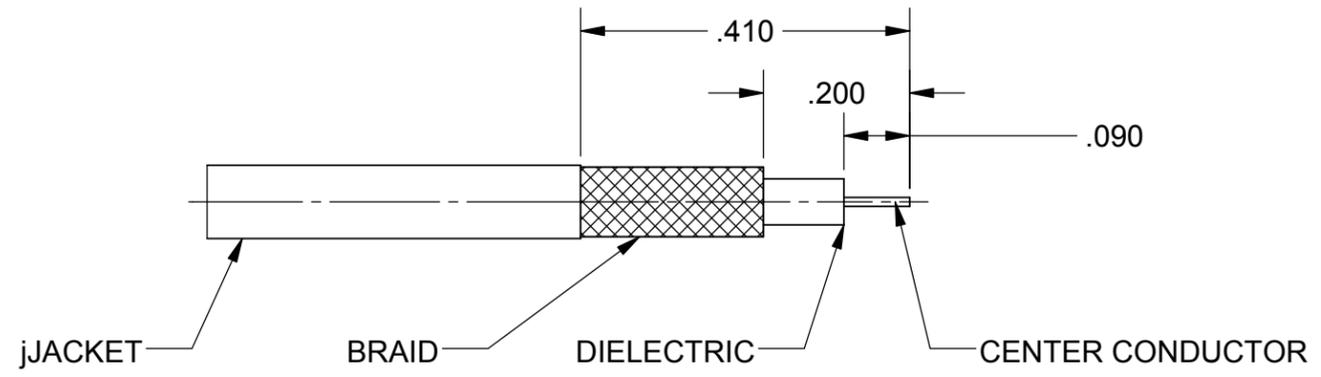
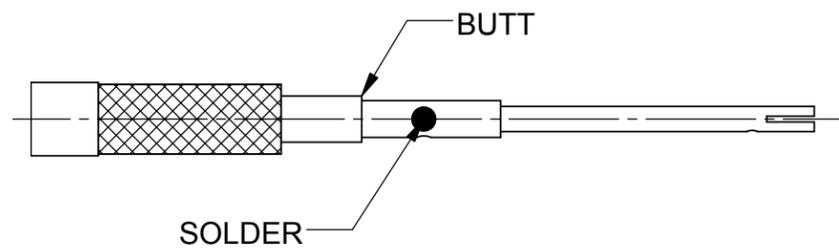


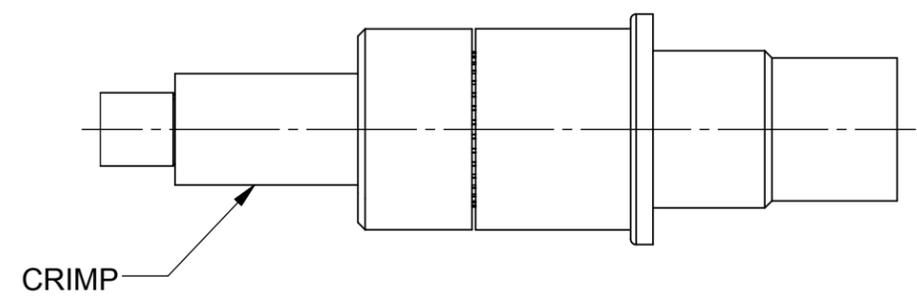
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	REL. NRN 40652	06/06/16	STW



STEP 1.
 TRIM CABLE TO DIMENSIONS SHOWN.
 BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR OR BRAID.



STEP 2.
 SLIDE CRIMP RING ON TO CABLE.
 INSTALL CONTACT ONTO CENTER CONDUCTOR, BUTT CONTACT TO DIELECTRIC.
 SOFT SOLDER CONTACT TO CABLE.



STEP 3.
 FLARE BRAID OUTWARD AWAY FROM DIELECTRIC.
 INSERT PREPARED CABLE INTO THE I.D. OF CONNECTOR ASSEMBLY,
 THE BRAID WILL REMAIN IN THE OUTSIDE.
 SLIDE CRIMP RING UP AND OVER BRAID, BUTT AGAINST SHOULDER.
 CRIMP USING M22520/10-01 CRIMP TOOL WITH M22520/10-05 (.128 HEX) CRIMP DIE.

MATERIAL:	N/A
FINISH:	N/A
SURFACE AREA:	N/A
PROPRIETARY	
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DIMENSIONS ARE IN INCHES TOLERANCES:	
FRACTIONAL:	±1/64 ANGULAR: X° ±1°0' X'X' ±15'
DECIMAL:	X ±.030 .XX ±.010 .XXX ±.005
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	
THIRD ANGLE PROJECTION	

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 √ MIL-STD-10. 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .004 T.I.R. 6) REMOVE ALL BURRS	
DRAWN:	JMC 06/06/16
CHECKED:	STW 06/06/16
APPROVED:	STW 06/06/16
E.M. SIMULATION:	N/A

 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409	
TITLE: CABLE ASSEMBLY INSTRUCTIONS	
SIZE: B	CAGE CODE: 95077
DWG. NO.:	300-93-018
SCALE: 4:1	SHEET 1 OF 1

SF9321-60007
 USED ON: