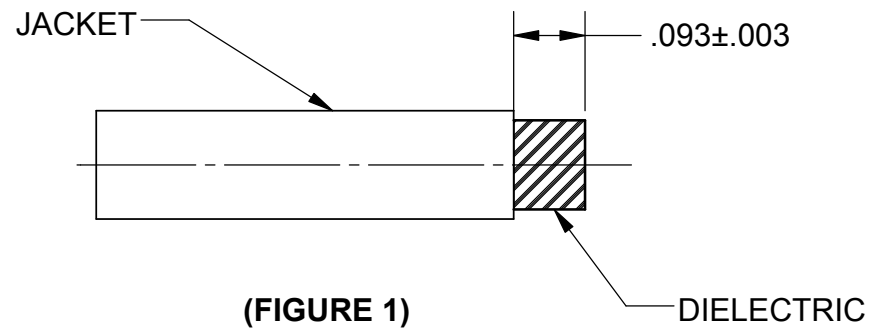


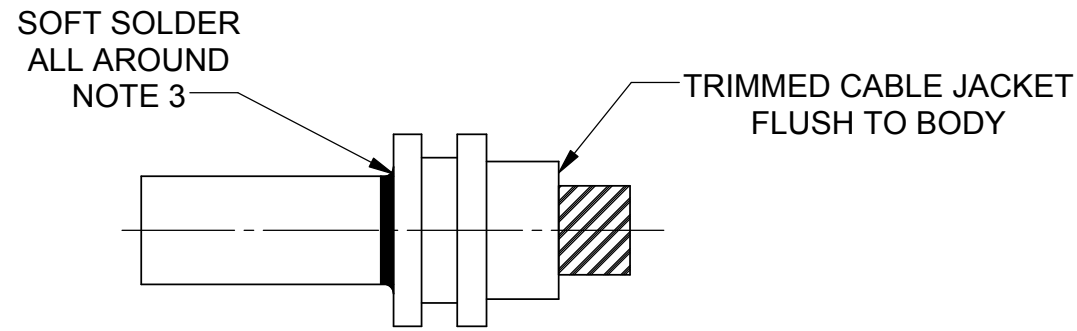
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
D	DCN 39867	06/13	STW



(FIGURE 1)

STEP 1, PER FIGURE 1

SET UP CABLE TRIM MACHINE, SINGLE EDGED RAZOR BLADE & CUT RESISTANT GLOVE.
TRIM JACKET ONLY TO DIMENSION SHOWN.



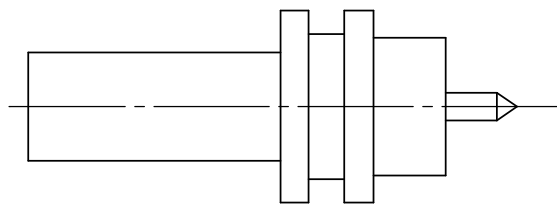
(FIGURE 2)

STEP 2, PER FIGURE 2

SET UP SOLDER TWEEZER, SOFT SOLDER, SOLDER FIXTURE, IONOX SOLUTION, BRUSH AND Q-TIP OR KIMWIPE.
SLIDE CABLE INTO CONNECTOR BODY AS SHOWN, SOFT SOLDER ALL AROUND AS SHOWN. SOLDER APPLIED TO REAR SIDE OF BODY. SEE NOTE 3.

STEP 3, PER FIGURE 3

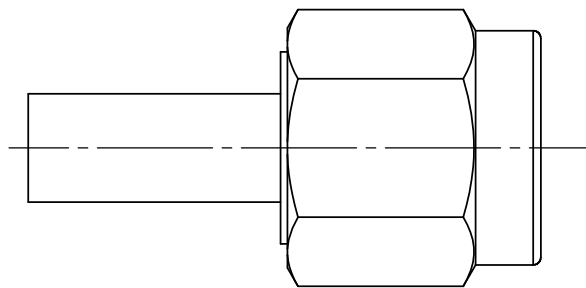
SET UP FACE TOOL AND POINTING FIXTURE
TRIM DIELECTRIC BACK FLUSH TO BODY BEING CAREFUL NOT TO NICK INNER CONDUCTOR
POINT INNER CONDUCTOR AS SHOWN.



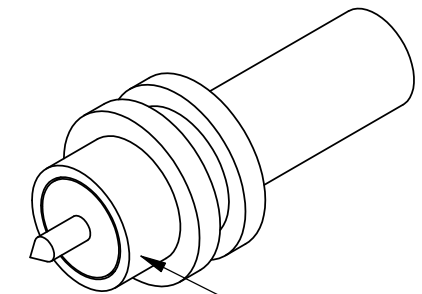
(FIGURE 3)

STEP 4, PER FIGURE 4

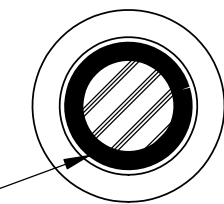
ASSEMBLE GASKET, LOCK RING AND COUPLING NUT TO BODY



(FIGURE 4)



VERIFY THERE IS NO SOLDER ON THIS SURFACE PRIOR TO FINAL ASSEMBLY WHEN SOLDERING FROM INTERFACE



(FIGURE 5)
INTERFACE VIEW

SOLDER TO JACKET 360°
SOLDER SHALL NOT EXTEND ONTO OUTSIDE OF BODY

- NOTES:
- CABLE ASSEMBLY INSTRUCTIONS FOR SEMI RIGID AND COMFORMABLE CABLE.
 - SOLDER TYPE PER CABLE ASSEMBLY BOM.
 - IF CABLE ASSEMBLY DRAWING REQUIRES TO SOLDER FROM THE INTERFACE SIDE, SEE FIGURE 5.

SF2902-6001
USED ON:

MATERIAL:	PER BOM
FINISH:	PER BOM
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 .005 T.I.R. 6) REMOVE ALL BURRS	
DRAWN:	BRT 05/21/97
CHECKED:	
APPROVED:	DGG 11/02/77
E.M. SIMULATION:	N/A

SV Microwave, Inc.	
2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409	
TITLE: CABLE ASSEMBLY INSTRUCTIONS	
SIZE B	CAGE CODE 95077
DWG. NO. 300-80-014	
SCALE: 4:1	SHEET 1 OF 1