

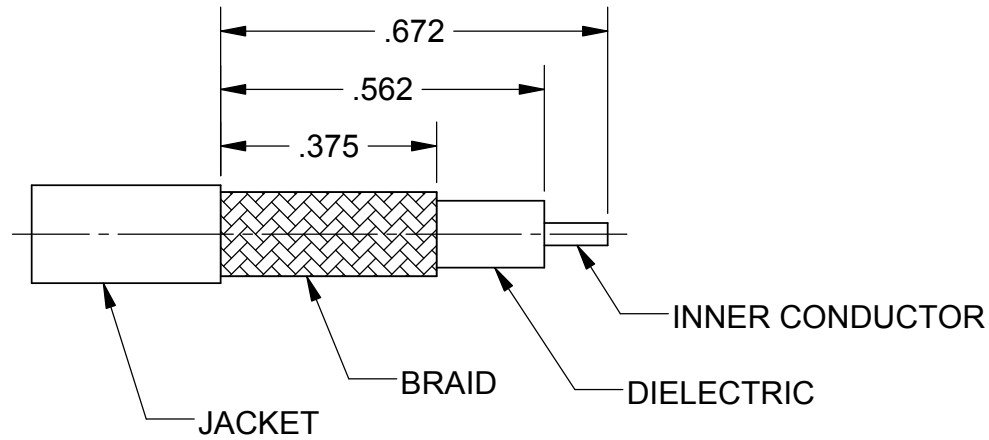
# 301-80-019 ASSEMBLY INSTRUCTIONS FOR M39012/26B0015

CONNECTOR TYPE.....TNC PLUG, CABLED, CRIMP ATTACHMENT

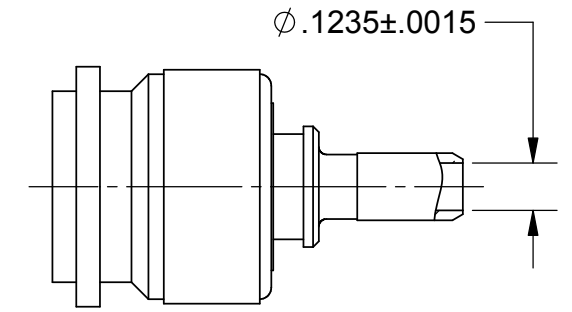
CABLE TYPE.....RG-58, 141, 303/U

SPECIAL TOOL.....CRIMP TOOL M22520/10-07 (.213 DIE)

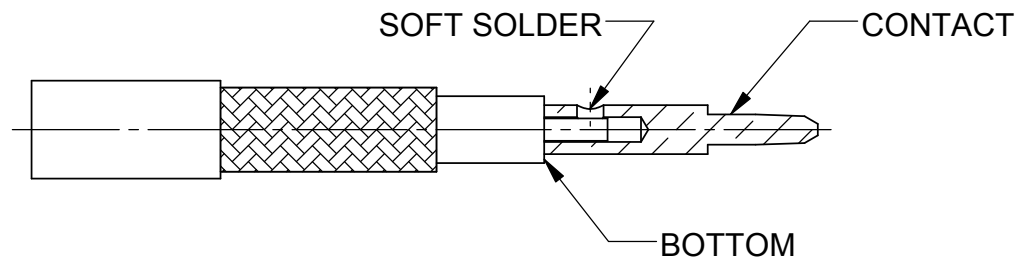
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	DCN 41040	01/15	STW



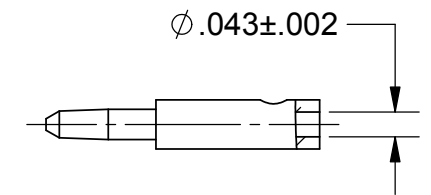
**STEP 1.**  
SLIDE SHRINK TUBING AND CRIMP RING ONTO CABLE. TRIM CABLE JACKET, BRAID, INSULATOR AND INNER CONDUCTOR TO DIMENSIONS SHOWN WITHOUT NICKING BRAID. FLARE BRAID AS SHOWN.



BODY ASSEMBLY

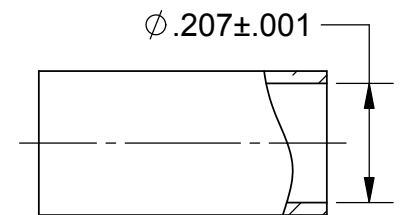


**STEP 2.**  
TIN CABLE INNER CONDUCTOR. SLIDE CONTACT ONTO INNER CONDUCTOR AND BOTTOM AGAINST DIELECTRIC. SOFT SOLDER CONTACT ONTO INNER CONDUCTOR. REMOVE EXCESS SOLDER.

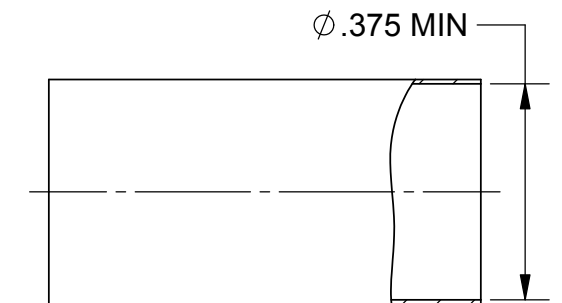
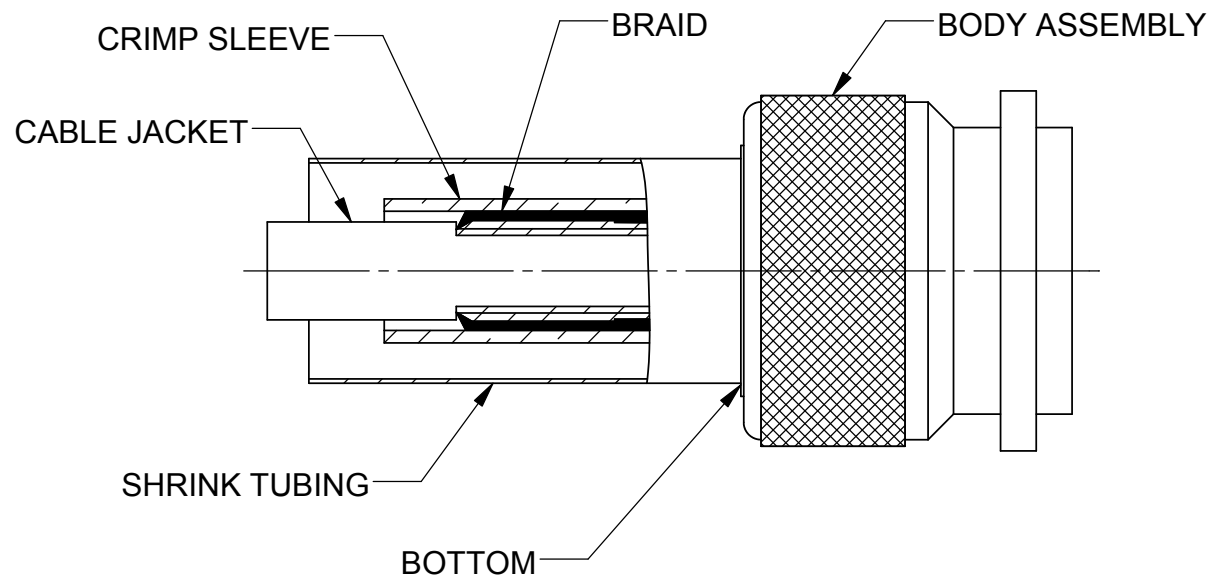


CONTACT

**STEP 3.**  
SLIDE BODY ASSEMBLY ONTO CABLE AND UNDER BRAID UNTIL CONTACT SNAPS INTO INSULATOR. SLIDE CRIMP SLEEVE OVER FLARED CABLE BRAID AS SHOWN. USING CRIMP TOOL M22520/10-07 WITH A .213 DIE OR EQUIVALENT CRIMP, CRIMP SLEEVE OVER CABLE BRAID. SLIDE SHRINK TUBING OVER JACKET AND CRIMP SLEEVE AND POSITION AS SHOWN. APPLY HEAT TO SHRINK TUBING TO COMPLETE ASSEMBLY.



CRIMP SLEEVE



SHRINK TUBING

MATERIAL: PER BOM	DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL: $\pm 1/64$ ANGULAR: X° $\pm 1'0$ X"X' $\pm 15'$	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	<b>SV Microwave, Inc.</b> 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409 TITLE: <b>CABLE ASSEMBLY INSTRUCTIONS</b>
FINISH: PER BOM	DECIMAL: X $\pm .030$ .XX $\pm .010$ .XXX $\pm .005$	DRAWN: BNK 01/07/15	
SURFACE AREA: N/A	INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	CHECKED: STW 01/07/15	SIZE: B CAGE CODE: 95077 DWG. NO.: 301-80-019
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	APPROVED: STW 01/07/15	SCALE: 3:1
M39012/26B0015	USED ON:	E.M. SIMULATION: N/A	SHEET 1 OF 1