

# SV Microwave Inc.

MARK LABEL PER PARTS LIST

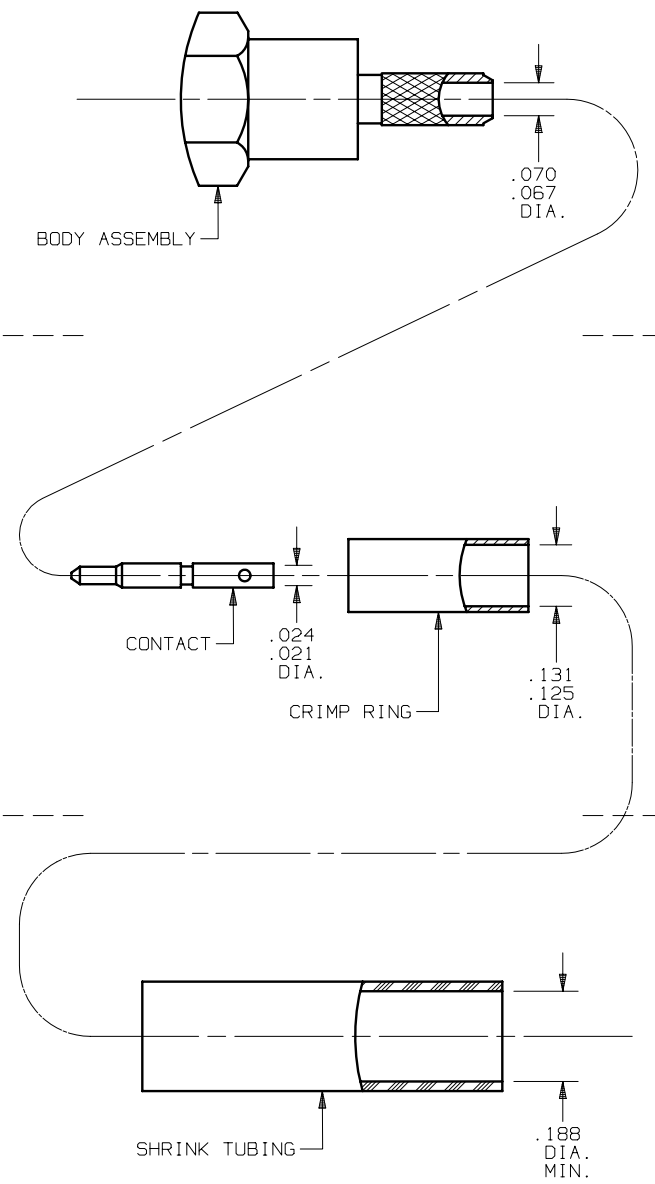
CONNECTOR TYPE.....SMA PLUG  
CRIMP ATTACHMENT

CABLE TYPE.....RG-316

SPECIAL TOOL.....PREFERRED DIE M22520/5-35  
CLOSURE B (.128 DIE) ALTERNATE  
DIE M22520/5-03 CLOSURE A

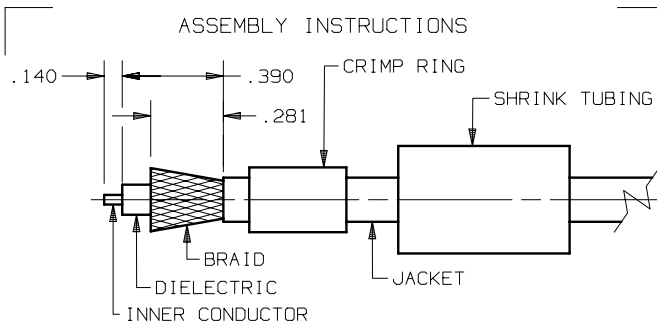
INSTRUCTIONS FOR....M39012/55-3026, M39012/55-3126,  
M39012/55B3012, M39012/55B3112,  
M39012/55B3019, M39012/55B3119

## PARTS SUPPLIED

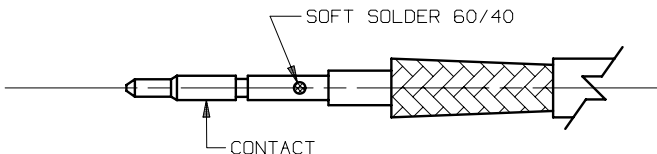


UNFOLD FOR ASSEMBLY INSTRUCTIONS  
CABLE ASSEMBLY PART NUMBER 300-80-269.

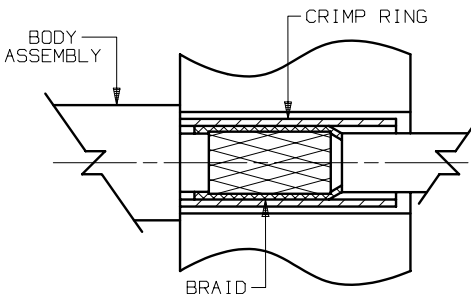
SYM.	DESCRIPTION	DATE	APPR.	UNLESS OTHERWISE SPECIFIED:	DIMENSIONS ARE IN INCHES	FINISH:	AREA:	DMG. NO.
A	REV. DCN 20483	10/92	RDF	1) ALL DIMENSIONS ARE AFTER PLATING. 2) BREAK CORNERS & EDGES .005 R. MAX. 3) CHAM. 1st & LAST THDS. 4) SURFACE ROUGHNESS 63 / MIL-STD-10. 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R. 6) REMOVE ALL BURRS.	DECIMALS X ±.030 .XX ±.015 .XXX ±.005	N/A	N/A	2400 Centrepark West Drive, Suite 100 West Palm Beach, FL, 33409
B	REV. DCN 29623	03/03	STM		FRACTIONAL ±1/64			SV Microwave, Inc. CABLE ASSEMBLY INSTRUCTIONS
C	REV. DCN 31722	07/04	BRT		ANGULAR X° ±1°0' X°X' ±15'			
				REDRAWN: MEB 03/17/03				
				CHECKED:				
				APPROVED: DGG 07/22/80				
					SIZE A	CODE IDENT. 95077	SCALE N/A	DMG. NO. 300-80-269



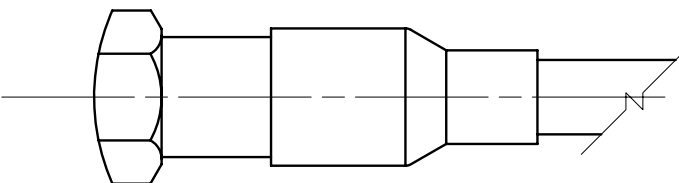
- 1.0 PREPARE CABLE END
  - 1.1 SLIDE SHRINK TUBING AND CRIMP RING ONTO CABLE.
  - 1.2 TRIM CABLE JACKET, BRAID, DIELECTRIC & INNER CONDUCTOR TO DIMENSIONS SHOWN. WITHOUT NICKING BRAID.
  - 1.3 FLARE BRAID AS SHOWN.



- 2.0 SOLDER INNER CONTACT
  - 2.1 TIN INNER CONDUCTOR.
  - 2.2 SLIDE CONTACT ONTO INNER CONDUCTOR AND BOTTOM ON DIELECTRIC AS SHOWN.
  - 2.3 SOFT SOLDER CONTACT ONTO INNER CONDUCTOR.
  - 2.4 REMOVE EXCESS SOLDER.



- 3.0 ATTACH CABLE BRAID TO BODY ASSY.
  - 3.1 SLIDE CABLE FORWARD INTO BODY ASSY. UNTIL CONTACT SNAPS INTO PLACE.
  - 3.2 SLIDE CRIMP RING FORWARD OVER FLARED BRAID AND POSITION AS SHOWN.
  - 3.3 "CRIMP" CRIMP RING USING CRIMP TOOL M22520/5-35 CLOSURE B (.128 DIE.).



- 4.0 ATTACH SHRINK TUBING
  - 4.1 SLIDE SHRINK TUBING OVER JACKET AND CRIMP RING AND POSITION AS SHOWN.
  - 4.2 APPLY HEAT(275° MIN) TO SHRINK TUBING TO COMPLETE ASSEMBLY.

SYM.	DESCRIPTION	DATE	APPR.
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A	REV. DCN 20483	10/92	RDF
B	REV. DCN 29623	03/03	STM
C	REV. DCN 31722	07/04	BRT

UNLESS OTHERWISE SPECIFIED:	
1) ALL DIMENSIONS ARE AFTER PLATING.	
2) BREAK CORNERS & EDGES .005 R. MAX.	
3) CHAM. 1st & LAST THDS.	
4) SURFACE ROUGHNESS 63 / MIL-STD-10.	
5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.	
6) REMOVE ALL BURRS.	

REDRAWN: MEB 03/17/03	
CHECKED:	
APPROVED: DGG 07/22/80	

FINISH:	N/A	AREA:	N/A
SIZE	CODE IDENT.	SCALE	
A	95077	N/A	

DECIMALS	FRACTIONAL	ANGULAR
X ±.030	±1/64	X° ±1'0"
.XX ±.015		X°X' ±15"
.XXX ±.005		

DIMENSIONS ARE IN INCHES	
TOLERANCES:	
TITLE:	
SV Microwave, Inc.	
2400 Centrepark West Drive, Suite 100	
West Palm Beach, FL, 33409	
CABLE ASSEMBLY INSTRUCTIONS	
DMG. NO.	300-80-269
SHT. 2 OF 2	