

11 A" SIZE COPY

DATE 10 21 80

SIZE B
DRAWING NO. 300-80-319

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

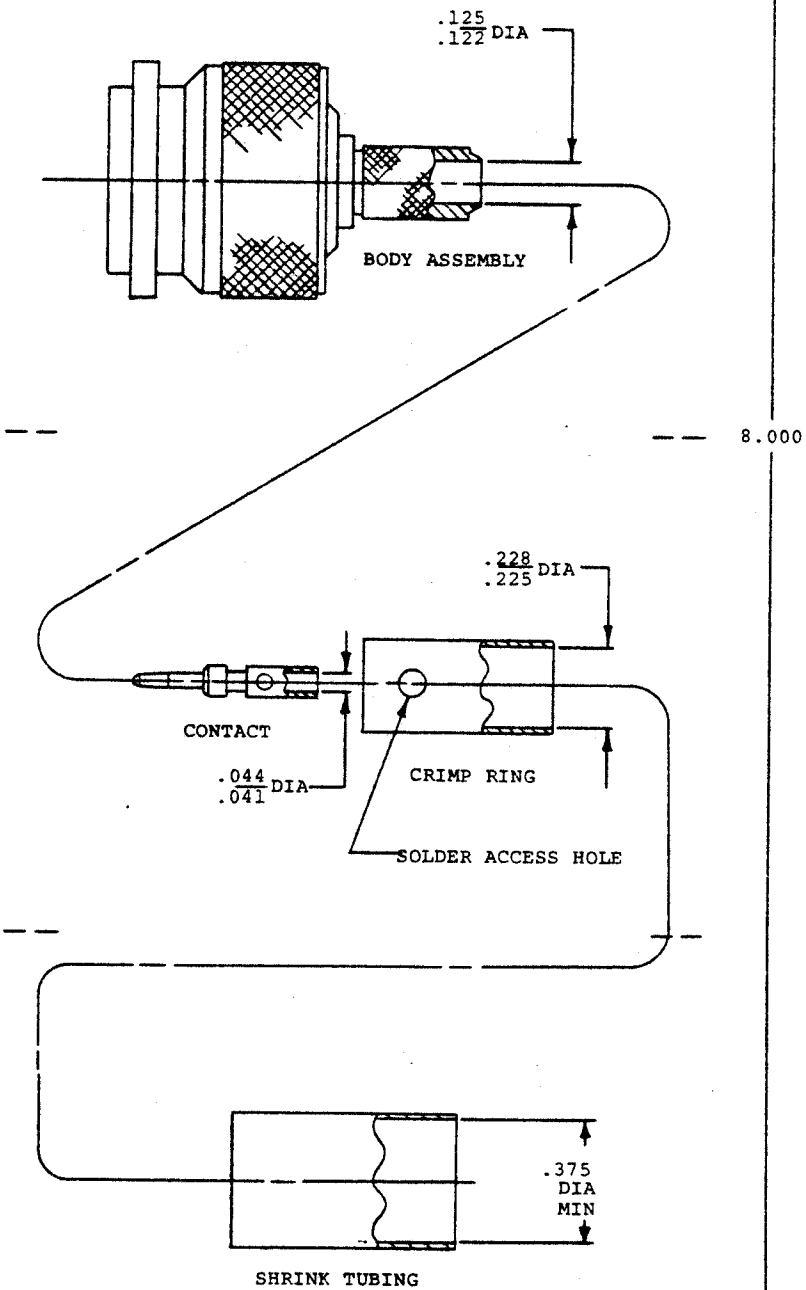
MARK LABEL PER PARTS LIST

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

CABLE TYPE.....RG-142, 223, 400/U

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

PARTS SUPPLIED



SYM	DESCRIPTION	DATE	APPN.
REL.	DCNF-7991	10/30/80	

UNLESS OTHERWISE SPECIFIED
1. ALL DIMENSIONS ARE IN INCHES
2. FRACTIONS ARE TO BE PLACED OVER PLACE DECIMALS
3. DIMENSIONS ARE TO BE CONCENTRIC
4. SURFACE ROUGHNESS

DRAWN: T. DATE: 10/23/80
CHECKED: [Signature] DATE: 10/28/80
APPROVED: DSG DATE: 10/28/80

NAME OF PART		ITEM NO.	PART NO.
SOLITRON/MICROWAVE PORT SALERNO, FLORIDA			
MATERIAL			
FINISH			
SCALE	CODE IDENT NO.	SIZE	
3X	95077	B	

TITLE	REF.
CABLE ASSEMBLY INSTRUCTIONS	MIL-C-39012, CAT C
DRAWING NO.	
300-80-319	
SHEET OF	2

300-80-319

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

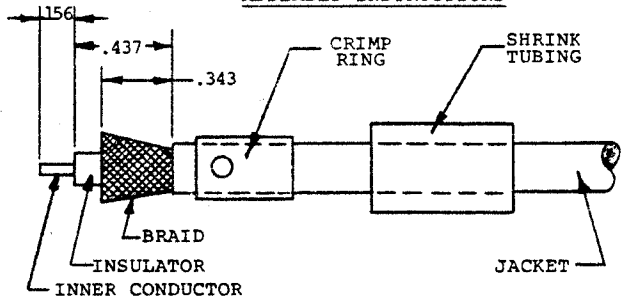
UNFOLD FOR
ASSEMBLY
INSTRUCTIONS

SIZE B DRAWING NO. 300-80-319

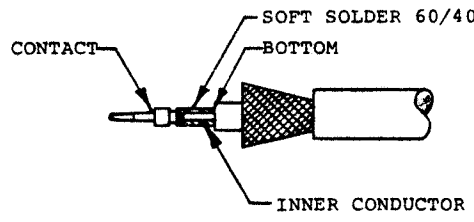
MADE IN THE U.S.A.

2.750

ASSEMBLY INSTRUCTIONS

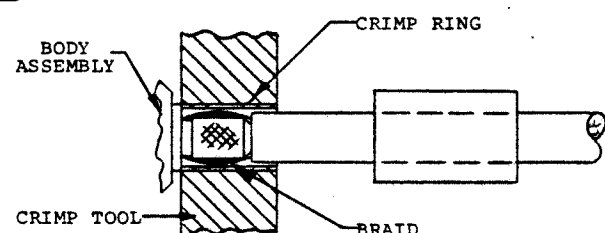


- 1.0 PREPARE CABLE END
 - 1.1 Slide shrink tubing & crimp ring onto cable.
 - 1.2 Trim cable jacket, braid, insulator & inner conductor to dimensions shown without nicking braid.
 - 1.3 Flare braid as shown.

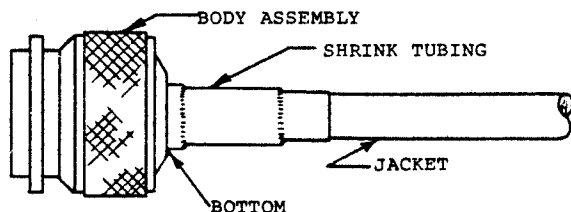


- 2.0 SOLDER INNER CONTACT
 - 2.1 Tin inner conductor.
 - 2.2 Slide contact onto inner conductor & bottom as shown.
 - 2.3 Soft solder contact onto inner conductor.
 - 2.4 Remove excess solder.

8.000



- 3.0 ATTACH CABLE BRAID TO BODY ASSEMBLY
 - 3.1 Slide body assy onto cable & under braid until contact snaps into insulator.
 - 3.2 Slide crimp ring over flared braid & position as shown.
 - 3.3 Attach body assy to cable braid by either of two methods:
 - (a) "Crimp" crimp ring using crimp tool M22520/10-07 (.213 die).
 - (b) Soft solder crimp ring to braid & connector ferrule through access holes.



- 4.0 ATTACH SHRINK TUBING
 - 4.1 Slide shrink tubing over jacket & crimp ring and position as shown.
 - 4.2 Apply heat (275°F min) to shrink tubing to complete assembly.

SYM	DESCRIPTION	DATE	APR.
REL.	DCNF-7991	10/18/80	

UNLESS OTHERWISE SPECIFIED	1. ALL DIMENSIONS ARE IN INCHES	1.000
TOLERANCES	2. TOLERANCES	1.000
FINISHES	3. FINISHES	1.000
PLACES	4. PLACES	1.000
DECIMALS	5. DECIMALS	1.000
ANGLES	6. ANGLES	1.000
ALL SQUARE	7. ALL SQUARE	1.000
SHARP EDGES	8. SHARP EDGES	1.000
AND	9. AND	1.000
CORNER RADIUS	10. CORNER RADIUS	1.000
MINIMUM	11. MINIMUM	1.000
CONCENTRIC	12. CONCENTRIC	1.000
AND	13. AND	1.000
SURFACE	14. SURFACE	1.000
ROUGHNESS	15. SURFACE ROUGHNESS	1.000

CHECKED	DATE	10/23/80
APPROVED	DATE	10/28/80
SCALE	CODE IDENT NO.	95077
SIZE		B

TITLE	CABLE ASSEMBLY INSTRUCTIONS
REF. PART NO.	MIL-C-39012, CAT. C
DRAWING NO.	300-80-319
SHEET NO.	2 OF 2

ITEM	NAME OF PART	PART NO.
	SOLITRON/MICROWAVE	
	PORT SAVERNO, FLORIDA	