

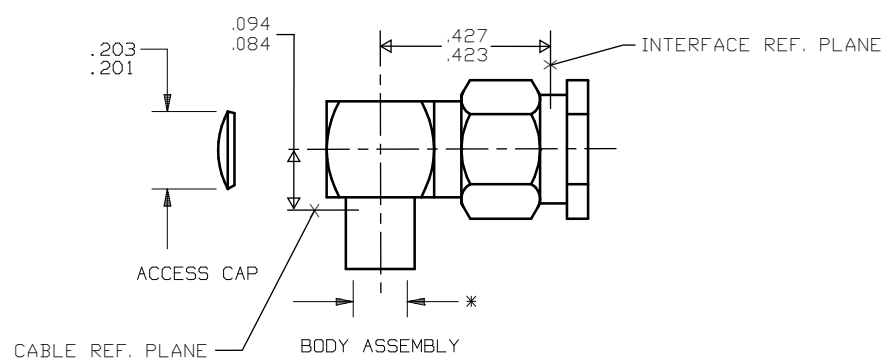
SV Microwave, Inc.

MARK LABEL PER PARTS LIST

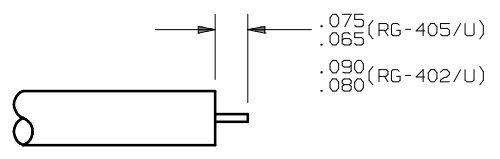
CONNECTOR TYPE....SMA R/A PLUG
CABLED, SOLDER ATTACHMENT.

CABLE TYPE..... .085(RG-405/U) SEMI-RIGID
.141(RG-402/U) SEMI-RIGID

NOTE:
TO MINIMIZE CABLE DIELECTRIC GROWTH DURING
SOLDERING OPERATION, NORMALIZE CABLE
(THERMAL SHOCK MIL-STD 202, METHOD 107 &
COND. B) PRIOR TO FINAL TRIM PARA. 1.0.



- * RG-402/U..... .147
.145 DIA.
- * RG-405/U..... .091
.089 DIA.



1.0 CABLE END PREPARATION

1.1 TRIM JACKET AND INSULATOR TO DIMENSION
SHOWN USING CARE NOT TO NICK INNER
CONDUCTOR.

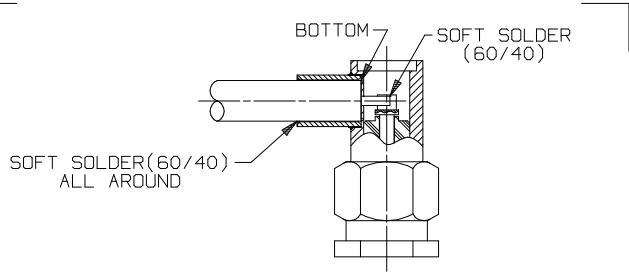
UNFOLD FOR ASSEMBLY INSTRUCTIONS
CABLE ASSEMBLY PART NUMBER 300-80-576.

SYM.	DESCRIPTION	DATE	APPR.	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.	DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS .X ±.030 .XX ±.015 .XXX ±.005 FRACTIONAL ±1/64 ANGULAR X° ±1.0' X°X' ±15'
A	REV. DCN 20226	11/91	RDF		
B	REV. DCN 24652	09/98	STM		
C	REV. DCN 27589	10/01	STM		
D	REV. DCN 27639	11/01	STM		
E	DCN 38048	03/11	STW		
REDRAWN: BRT 8/18/98 CHECKED: APPROVED: NID 2/26/86				FINISH: N/A AREA: N/A SIZE: A CODE IDENT: 95077 SCALE: N/A	
TITLE: SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409				DMG. NO. SHT. 1 OF 2 300-80-576	

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2400 Centrepark West Drive, Suite 100
West Palm Beach, FL 33409

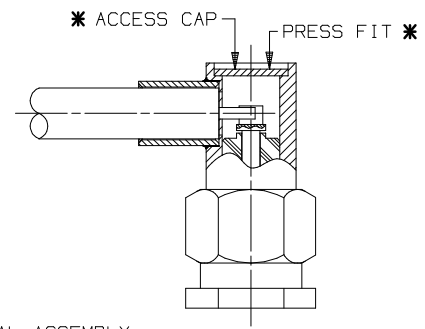
CABLE ASSEMBLY
INSTRUCTIONS

300-80-576



2.0 CONNECTOR AND CABLE ASSEMBLY

- 2.1 INSERT CABLE INTO CONNECTOR ASSEMBLY WHILE MAKING CERTAIN CENTER CONDUCTOR OF CABLE IS ALIGNED WITH SLOT OF CONTACT. BOTTOM CABLE INTO BODY.
- 2.2 SOFT SOLDER(60/40) CONNECTOR TO CABLE JACKET.
- 2.3 SOFT SOLDER(60/40) CONTACT TO CENTER CONDUCTOR OF CABLE.



3.0 FINAL ASSEMBLY

- 3.1 PRESS OR SOLDER ACCESS CAP INTO CONNECTOR RECESS.

* OPTIONAL METHOD IS SOLDERING CAP TO BODY USING SN60(60/40) SOLDER.

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