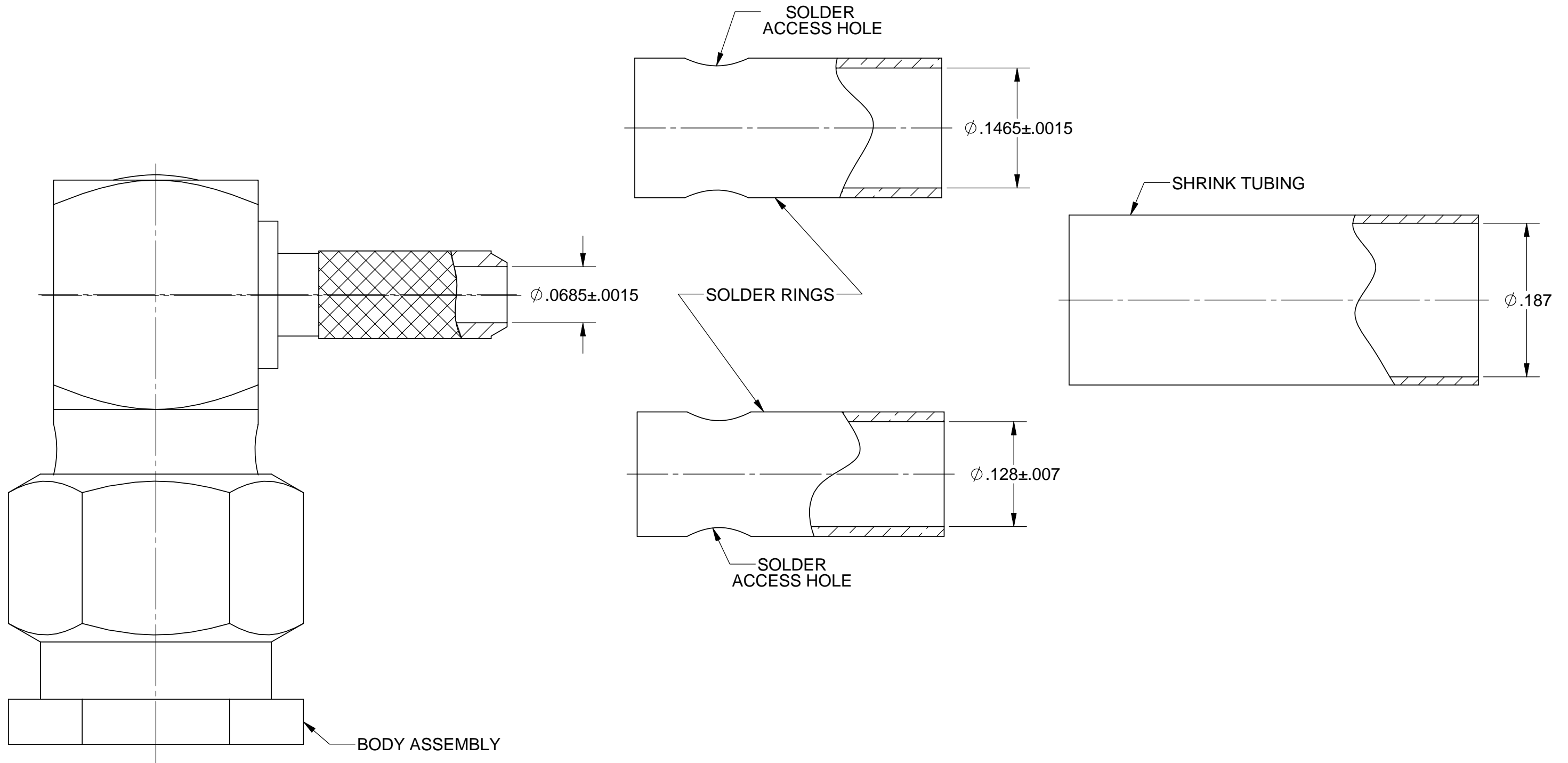


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
F	DCN 36094	10/08	DAL



M39012/56-3007  
USED ON:

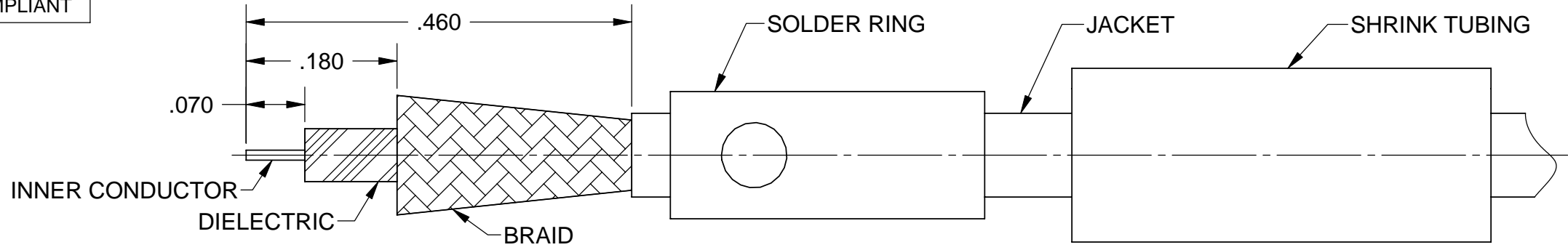
MATERIAL:	N/A
FINISH:	PER BOM
SURFACE AREA:	N/A
	<b>PROPRIETARY</b>
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DIMENSIONS ARE IN INCHES TOLERANCES:	
FRACTIONAL: $\pm 1/64$	ANGULAR: X° $\pm 1'0''$ X'X' $\pm 15'$
DECIMAL: X $\pm .030$ .XX $\pm .010$ .XXX $\pm .005$	
INTERPRET DIMENSIONS AND TOLERANCES 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 $\sqrt{\text{MIL-STD-10}}$ . 5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .005 T.I.R. 6) REMOVE ALL BURRS	
DRAWN:	HLP 10/15/08
CHECKED:	DAL 10/15/08
APPROVED:	ND 03/01/86
E.M. SIMULATION:	N/A

<b>SV Microwave, Inc.</b> 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409		
TITLE: <b>CABLE ASSEMBLY INSTRUCTIONS</b>		
SIZE	CAGE CODE	DWG. NO.
<b>B</b>	<b>95077</b>	<b>300-80-578</b>
SCALE: 8:1		SHEET 1 OF 2

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
F	DCN 36094	10/08	DAL

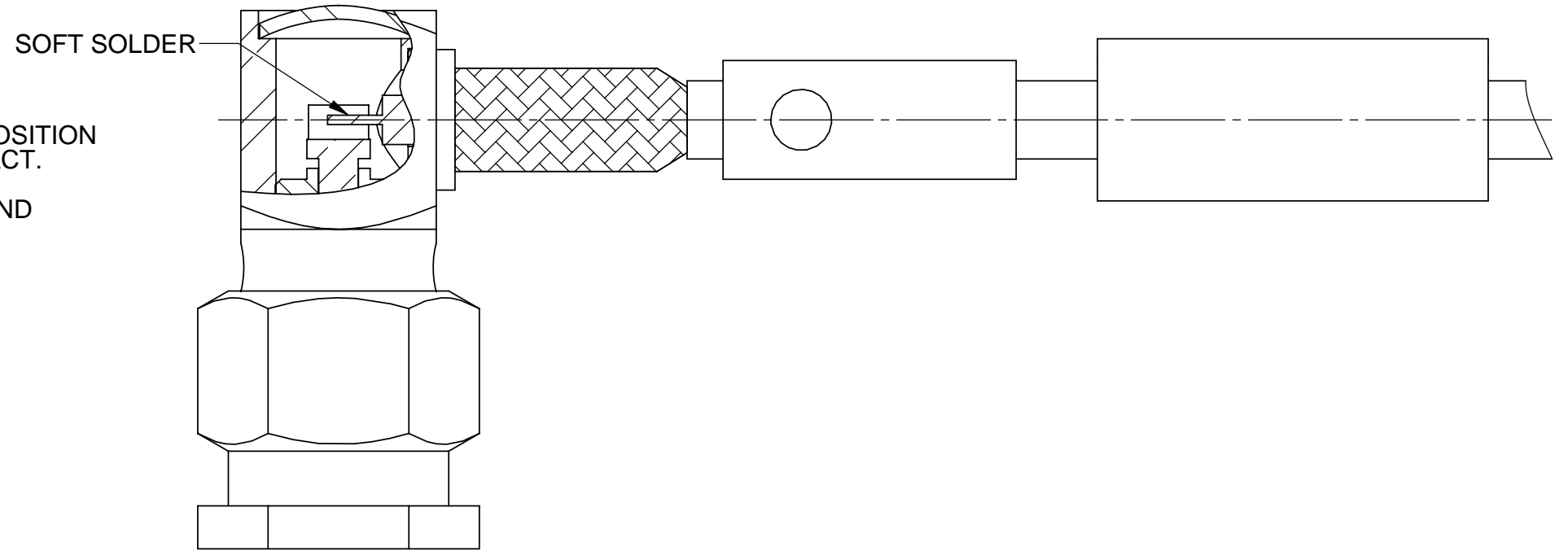


**STEP 1**

- SLIDE SHRINK TUBING AND SOLDER RING ONTO CABLE.
- TRIM CABLE JACKET, BRAID, DIELECTRIC AND INNER CONDUCTOR TO DIMENSIONS SHOWN WITHOUT NICKING BRAID.
- FLARE BRAID AS SHOWN.

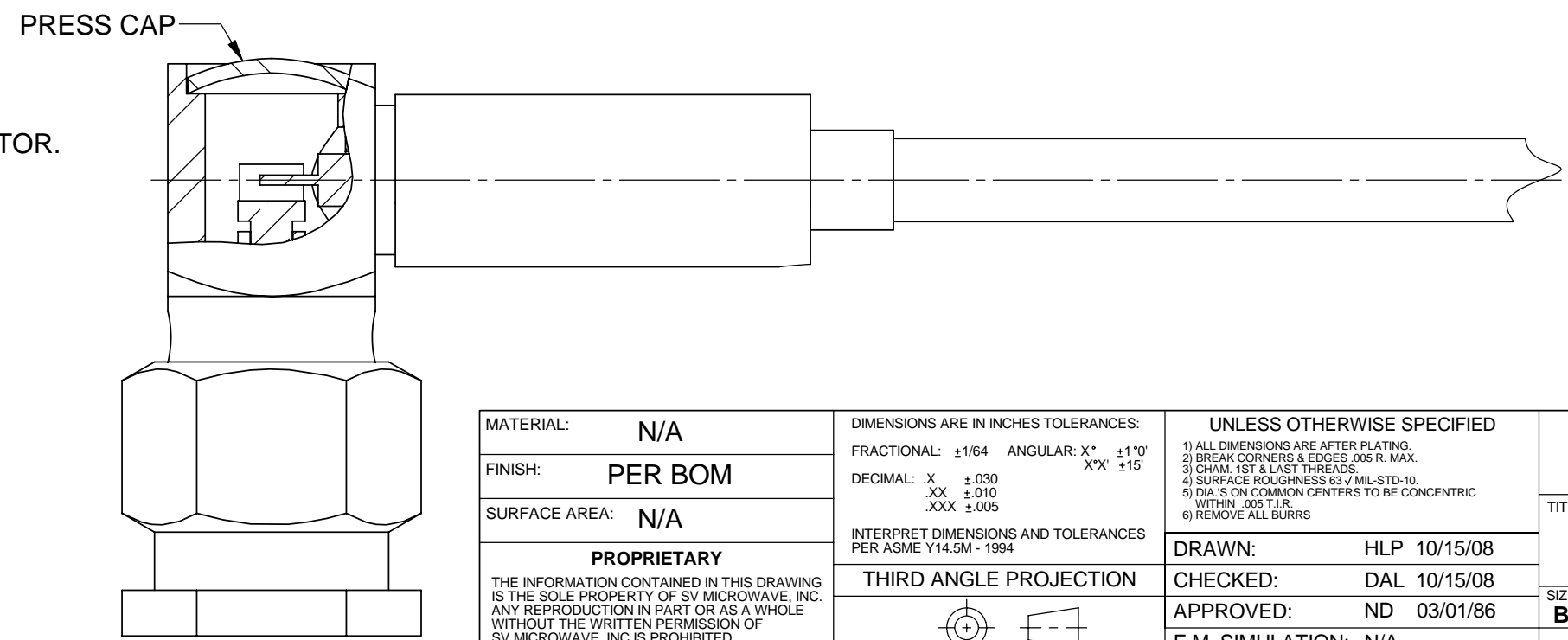
**STEP 2**

- INSERT PREPARED CABLE END INTO FERRULE END OF CONNECTOR. POSITION INNER CONDUCTOR INTO SLOT. SOFT SOLDER CONDUCTOR TO CONTACT.
- SLIDE SOLDER RING OVER BRAID AND FERRULE. SOFT SOLDER BRAID AND SOLDER RING TO FERRULE. TRIM EXCESS BRAID IF NECESSARY.



**STEP 3**

- SOLDER OR PRESS CAP INTO RECESS OF CONNECTOR.
- SLIDE SHRINK TUBING OVER SOLDER RING.
- APPLY HEAT(275° MIN.) TO SHRINK TUBING.



MATERIAL: N/A	DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL: ±1/64 ANGULAR: X° ±1'0" DECIMAL: .X ±.030 .XX ±.010 .XXX ±.005	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	<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	INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	DRAWN: HLP 10/15/08 CHECKED: DAL 10/15/08 APPROVED: ND 03/01/86 E.M. SIMULATION: N/A	
SURFACE AREA: N/A	THIRD ANGLE PROJECTION	DWG. NO. <b>300-80-578</b> SCALE: 2:1	SHEET 2 OF 2

PROPRIETARY  
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