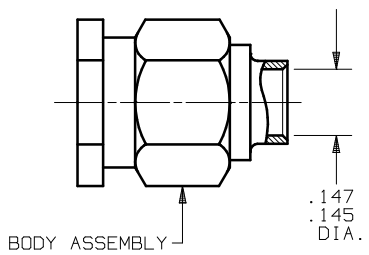


SV Microwave

MARK LABEL PER PARTS LIST

INSTRUCTIONS FOR: M39012/79B3102
 CONNECTOR TYPE....SMA PLUG, STRAIGHT, CABLED,
 SOLDER ATTACHMENT.
 CABLE TYPE.....141 SEMI-RIGID.(RG-402/U)
 NOTE: TO MINIMIZE CABLE DIELECTRIC GROWTH
 DURING SOLDER OPERATION, NORMALIZE
 CABLE (THERMAL SHOCK MIL-STD-202,
 METHOD 107, COND.B) PRIOR TO FINAL
 TRIM. PARA.1.0.

PARTS SUPPLIED



SEE REVERSE
 SIDE FOR
 ASSEMBLY
 INSTRUCTIONS

SV Microwave

300-80-982

SYM.	DESCRIPTION	DATE	APPR.
—	REL. NRN 27472	9/01	STM

UNLESS OTHERWISE SPECIFIED:
 1) ALL DIMENSIONS ARE AFTER PLATING.
 2) BREAK CONNERS & 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.

DRAWN: MEB 09/20/01
 CHECKED: STM 09/25/01
 APPROVED: STM 09/25/01

DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR	
DECIMALS	±.030	FRACTIONAL	±1/64	X° ±1°0'	X°X' ±15'
.XX ±.015					
.XXX ±.005					
MATERIAL:	N/A	FINISH:	N/A	AREA:	N/A
SIZE	CODE	IDENT.	SCALE		
A	95077		N/A		

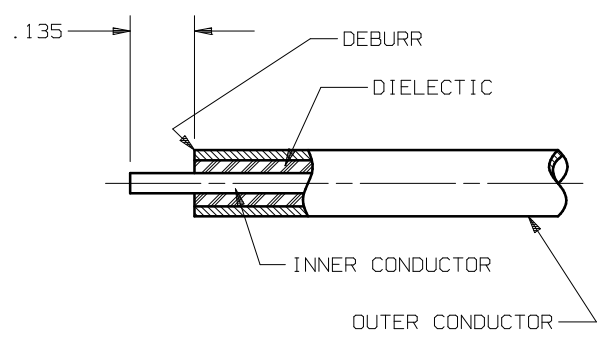
SV Microwave, Inc.
 3301 Electronics Way
 West Palm Beach, FL 33407

TITLE:
 CABLE ASSEMBLY
 INSTRUCTIONS

DWG. NO.
 SHT. 1
 OF 2

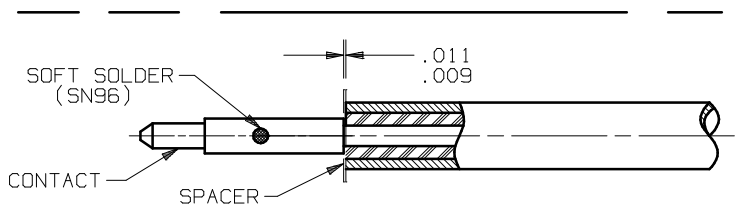
300-80-982

ASSEMBLY INSTRUCTIONS



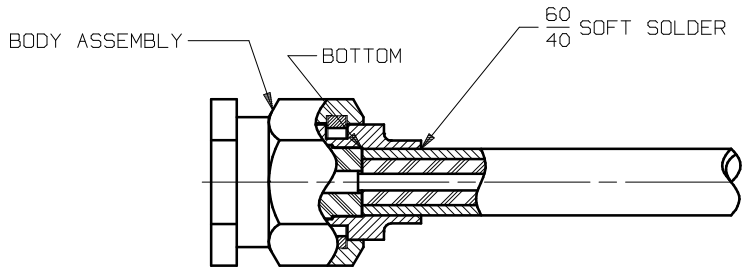
1.0 PREPARE CABLE END

- 1.1 TRIM CABLE OUTER CONDUCTOR/DIELECTRIC AND INNER CONDUCTOR TO DIMENSIONS SHOWN. DO NOT NICK INNER CONDUCTOR.



2.0 SOLDER CABLE CONTACT

- 2.1 PLACE CONNECTOR CONTACT OVER CABLE CENTER CONDUCTOR.
- 2.2 USE A SPACER TO MAINTAIN THE .010±.001 DIMENSION SHOWN.
- 2.3 SOFT SOLDER CONNECTOR CONTACT TO CABLE CENTER CONDUCTOR.
- 2.4 REMOVE SPACER.



3.0 SOLDER CABLE TO BODY

- 3.1 INSERT CABLE ASSEMBLY INTO BODY. BOTTOM CABLE AGAINST INSULATOR INSIDE BODY.
- 3.3 USING 60/40 SOLDER, SOLDER CABLE TO BODY ALL AROUND, WHILE APPLYING SUFFICIENT PRESSURE TO KEEP CABLE BOTTOMED IN BODY, DURING PROCESS.

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
FRACTIONAL

.X	±.030		ANGULAR
.XX	±.015	±1/64	X° ±1.0°
.XXX	±.005		X°X'±15'

MATERIAL: N/A

FINISH: N/A

AREA: N/A

DRAWN: MEB 09/20/01
CHECKED: STM 09/25/01
APPROVED: STM 09/25/01

SIZE	CODE	IDENT.	SCALE
A	95077		N/A

DMG. NO. 300-80-982
SHT. 2 OF 2

SV Microwave, Inc.
3301 Electronics Way
West Palm Beach, FL 33407

CABLE ASSEMBLY INSTRUCTIONS