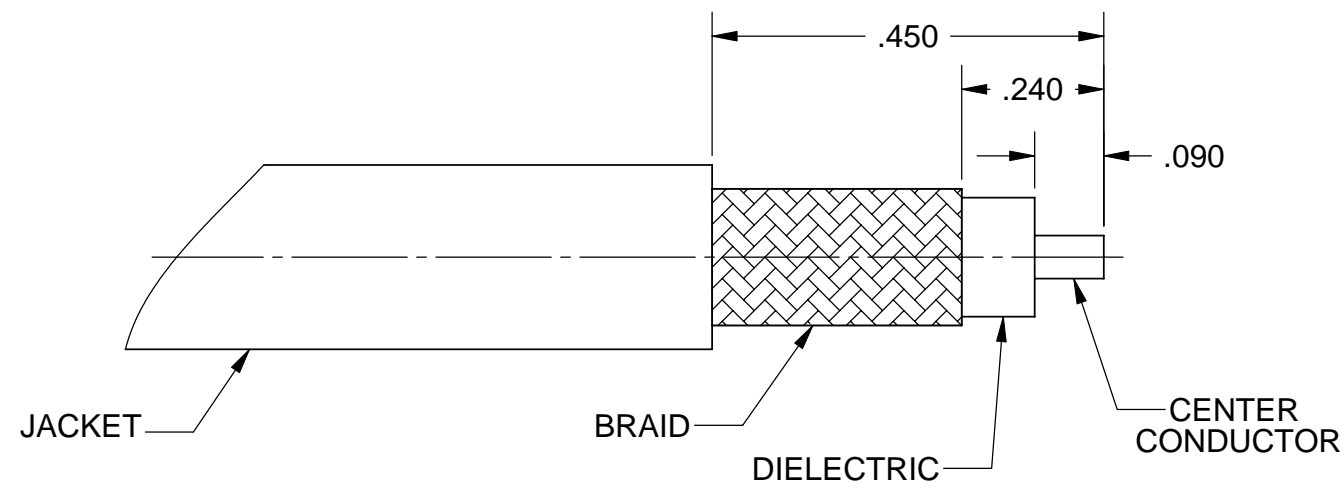
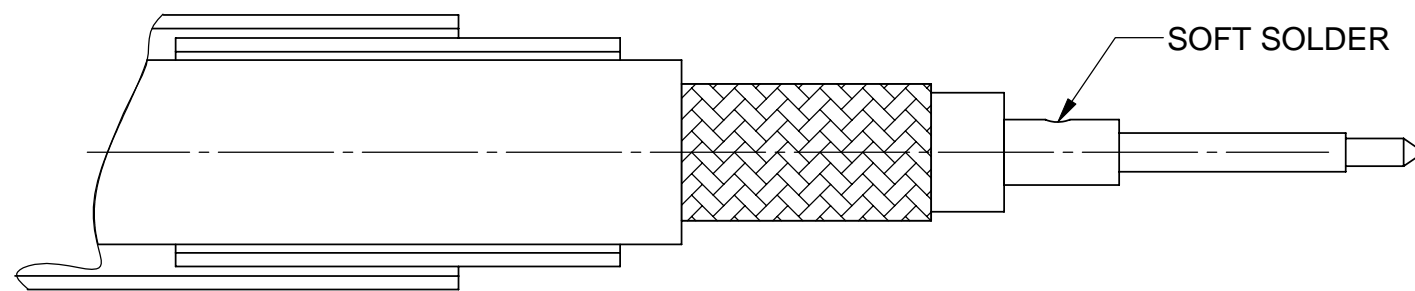


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	REL. NRN 35313	05/01/09	STW



STEP 1

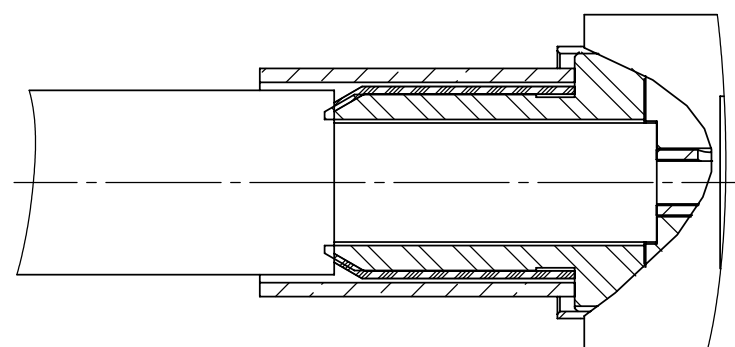
TRIM CABLE PER DIMENSIONS SHOWN.



STEP 2

SOLDER CONTACT TO CENTER CONDUCTOR, MAKING SURE BACK END OF CONTACT IS FLUSH WITH TRIMMED END OF CABLE DIELECTRIC.

SLIDE CRIMP RING AND SHRINK TUBING(IF APPLICABLE) ONTO CABLE.



STEP 3

INSERT PRPARED CABLE INTO CONNECTOR UNTIL FULLY SEATED, WITH ALL BRAID WIRES ON THE OUTSIDE OF CONNECTOR BODY.

SLIDE CRIMP RING FORWARD AND CRIMP AS CLOSE AS POSSIBLE TO BODY USING M22520/5-03, .128 DIE. DO NOT CRIMP REAR OF CRIMP RING

IF APPLICABLE, HEAT SHRINK TUBING OVER REAR OF CONNECTOR BODY AND CABLE JACKET USING HOT AIR GUN.

MATERIAL:	PER BOM
FINISH:	PER BOM
SURFACE AREA:	N/A
	PROPRIETARY
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SF9811-60005	USED ON:

DIMENSIONS ARE IN INCHES TOLERANCES:	
FRACTIONAL: ±1/64	ANGULAR: X° ±1'0" X'X' ±15'
DECIMAL: .X ±.030	.XX ±.010
	.XXX ±.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 √ MIL-STD-10.	
5) DIA.'S ON COMMON CENTERS TO BE CONCENTRIC WITHIN .004 T.I.R.	
6) REMOVE ALL BURRS	
DRAWN:	JMC 05/01/09
CHECKED:	STW 05/01/09
APPROVED:	STW 05/01/09
E.M. SIMULATION:	N/A

SV Microwave, Inc. 2400 Centrepark West Drive, Suite 100 West Palm Beach, FL 33409		
TITLE: CABLE ASSEMBLY INSTRUCTIONS		
SIZE B	CAGE CODE 95077	DWG. NO. 300-89-013
SCALE: 4:1		SHEET 1 OF 1