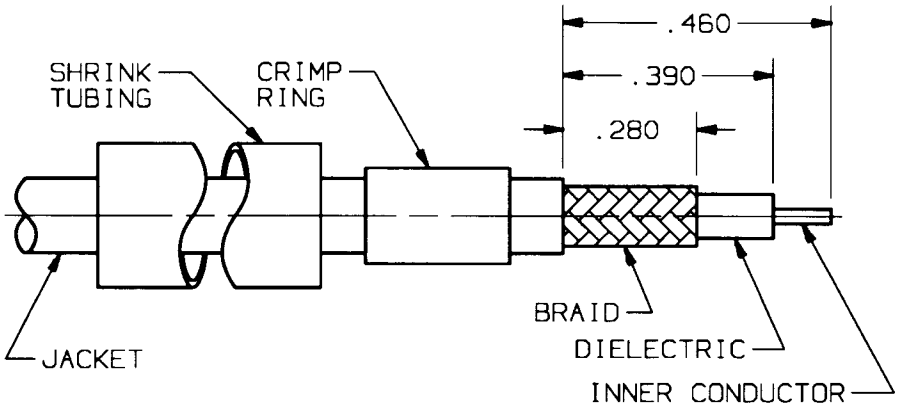
USED ON: 2913-6018

| CAD GENERATED DRAWING | DCN CONTROLLED DOCUMENT | DWG. NO. 300-80-840 |
|---|---|---|



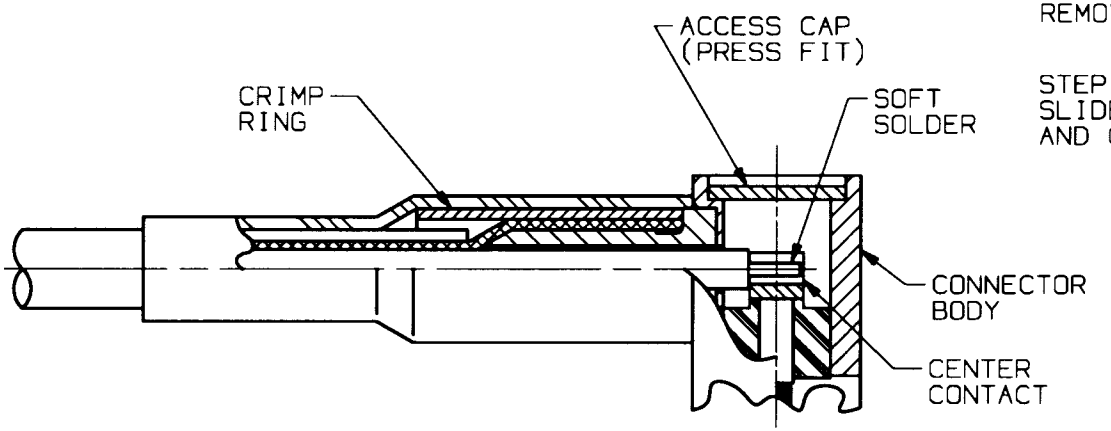

STEP 1
SLIDE SHRINK TUBING AND CRIMP RING ONTO CABLE AS SHOWN. TRIM CABLE JACKET, BRAID, DIELECTRIC AND INNER CONDUCTOR TO DIMENSIONS SHOWN. DO NOT NICK BRAID OR INNER CONDUCTOR.

STEP 2
TIN CABLE INNER CONDUCTOR. INSERT CONNECTOR ONTO CABLE UNDER BRAID UNTIL DIELECTRIC BOTTOMS. SLIDE CRIMP RING FORWARD OVER CABLE BRAID AS SHOWN.

STEP 3
USING A M22520/5-19(CLOSURE B) CRIMP TOOL WITH A .213 DIE CAVITY(OR EQUIVALENT) CRIMP "CRIMP RING" OVER CABLE BRAID.

STEP 4
SOFT SOLDER CENTER CONTACT TO INNER CONDUCTOR. REMOVE EXCESS SOLDER. INSTALL ACCESS CAP(PRESS).

STEP 5
SLIDE SHRINK TUBING FORWARD OVER CRIMP RING AND CONNECTOR BODY. APPLY HEAT TO SHRINK.




| SYM. | DESCRIPTION | DATE | APPR. |
|---|---|---|---|
| - | REL. DCN 23417 | 5/97 | JM |
| A | REV. DCN 24891 | 12/98 | |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | |

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.

DRAWN: BRT 4/15/97
CHECKED: SW 5/02/97
APPROVED: JM 5/06/97

DIMENSIONS ARE IN INCHES
TOLERANCES:

| DECIMALS | FRACTIONAL | ANGULAR |
|---|---|---|
| .X ±.030 | ±1/64 | X° ±1°0′ |
| .XX ±.015 | | X°X′±15′ |
| .XXX ±.005 | | |

MATERIAL: N/A
FINISH: N/A
□" AREA:
O.D. N/A
I.D. N/A

| SIZE | CAGE NO. | SCALE |
|---|---|---|
| A | 95077 | 2X |

SOLITRON VECTOR MICROWAVE
3301 ELECTRONICS WAY
WEST PALM BEACH, FL, 33407

TITLE: CABLE ASSEMBLY INSTRUCTIONS (CRIMP)

DWG. NO. 300-80-840