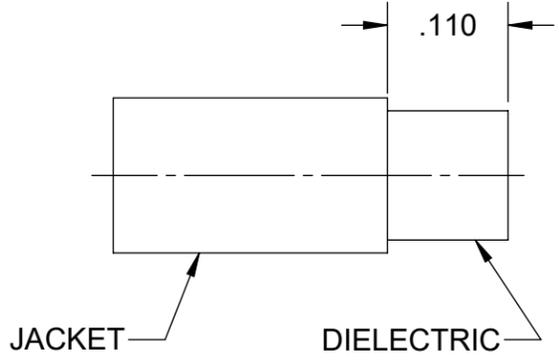
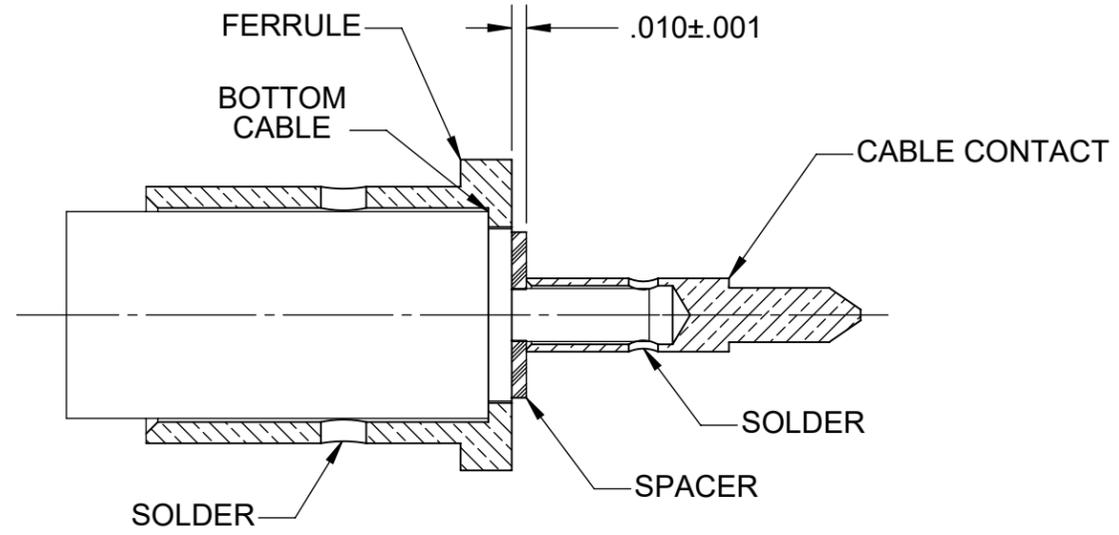


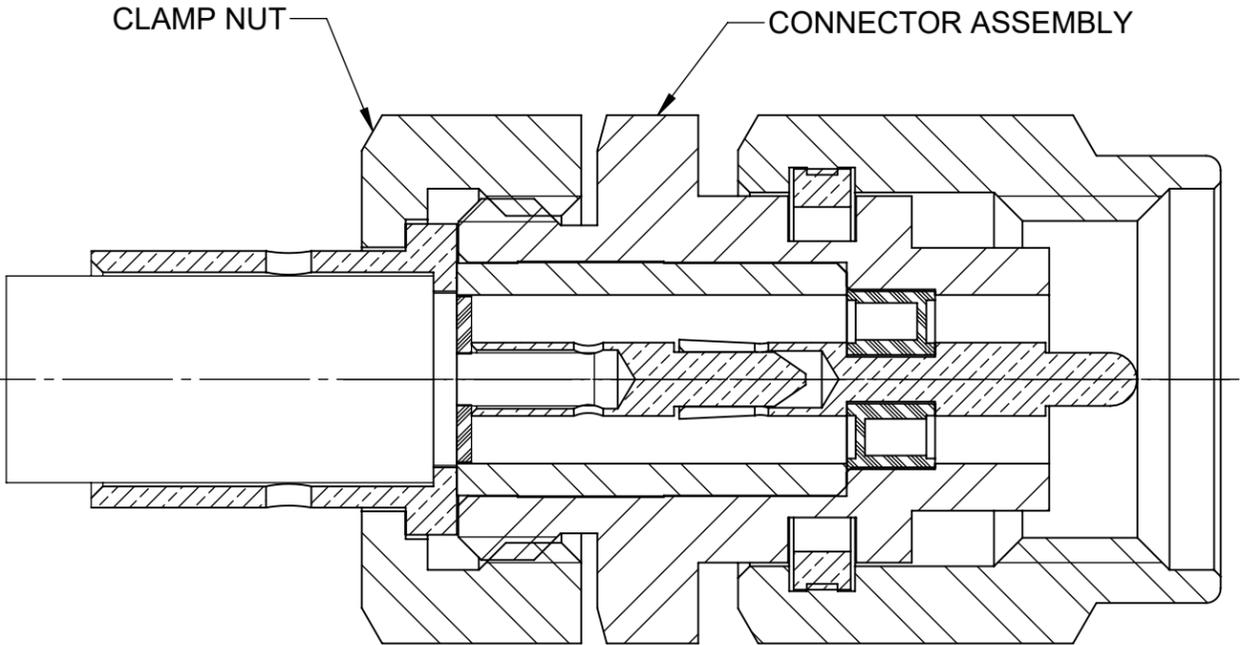
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
B	DCN 33526	08/05	SEE PDM
C	DCN 51224	12/21	



STEP 1:
TRIM CABLE JACKET AS SHOWN.



STEP 2:
SLIDE CLAMP NUT ONTO CABLE WITH CORRECT ORIENTATION. INSERT CABLE INTO FERRULE AND BOTTOM. SOLDER CABLE JACKET TO FERRULE USING SN96. TRIM CABLE DIELECTRIC FLUSH TO FACE, WITHOUT NICKING CABLE CENTER CONDUCTOR. INSTALL SUPPLIED PTFE SPACER ONTO CABLE CENTER CONDUCTOR. BOTTOM ON FERRULE FACE. INSTALL CONTACT ONTO CABLE CENTER CONDUCTOR, BOTTOM ON SPACER AND SOLDER USING SN96 SOLDER. MAINTAIN .010 ± .001 DIMENSION (CRITICAL DIMENSION). REMOVE EXCESS SOLDER.



STEP 3:
MAKE SURE CONTACT IS STRAIGHT AND NOT BENT PRIOR TO INSTALLATION. INSERT CABLE ASSEMBLY INTO BODY ASSEMBLY WITH GREAT CARE. SLIDE CLAMP NUT UP AND TORQUE IN PLACE 20-25 IN.-LBS.

MATERIAL: PER BOM	DIMENSIONS ARE IN INCHES TOLERANCES:	UNLESS OTHERWISE SPECIFIED	 <p>Amphenol www.svmicrowave.com</p>
FINISH: PER BOM	FRACTIONAL: ±1/64 ANGULAR: X° ±1'0" X'X' ±15'	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 T.I.R. 6) REMOVE ALL BURRS	
SURFACE AREA: N/A	DECIMAL: X ±.030 .XX ±.010 .XXX ±.005	INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994	TITLE: CABLE ASSEMBLY INSTRUCTIONS
PROPRIETARY	THIRD ANGLE PROJECTION	DRAWN: STW 08/21/05	SIZE DWG. NO. 300-80-908
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SF1505-6100		APPROVED: SEE PDM	SHEET 1 OF 1
USED ON:		E.M. SIMULATION: N/A	