

# SV Microwave Inc.

MARK LABEL PER PARTS LIST

CONNECTOR TYPE.....TNC PLUG  
 UG CLAMP ATTACHMENT

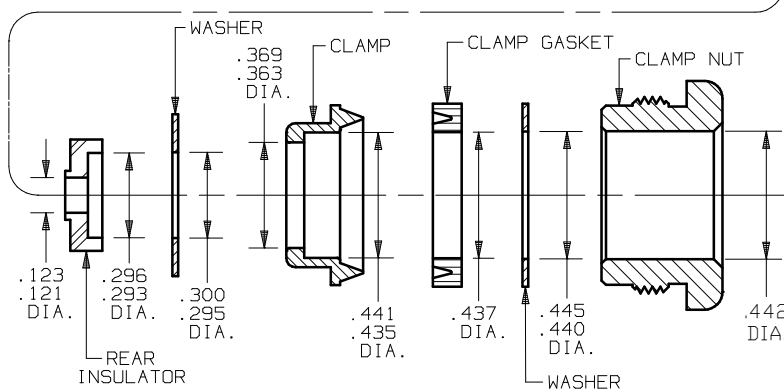
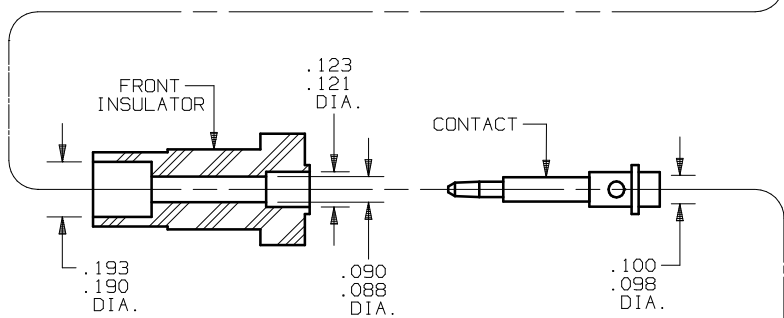
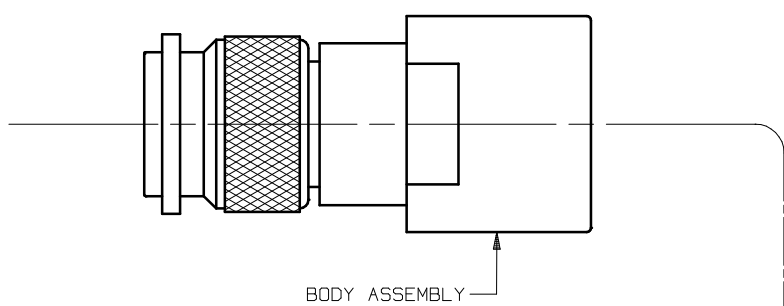
CABLE TYPE.....RG-144, RG-165, RG-213, RG-214,  
 RG-216, RG-393

SPECIAL TOOL.....NONE

INSTRUCTIONS FOR...M39012/26-0225

SYM.	DESCRIPTION	DATE	APPR.
-	REL.NRN 26296	08/00	SM
A	DCN 39203	07/12	STW

## PARTS SUPPLIED



CABLE ASSEMBLY INSTRUCTION PART NUMBER 300-80-955.

UNLESS OTHERWISE SPECIFIED:  
 1) ALL DIMENSIONS ARE AFTER PLATING.  
 2) BREAK CORNERS & EDGES .005 R. MAX.  
 3) CHAM. 1<sup>ST</sup> & 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 ±.030  
 FRACTIONAL ±1/64  
 ANGULAR X° ±1.0'  
 X°X' ±15'

MATERIAL: N/A  
 FINISH: N/A  
 AREA: N/A

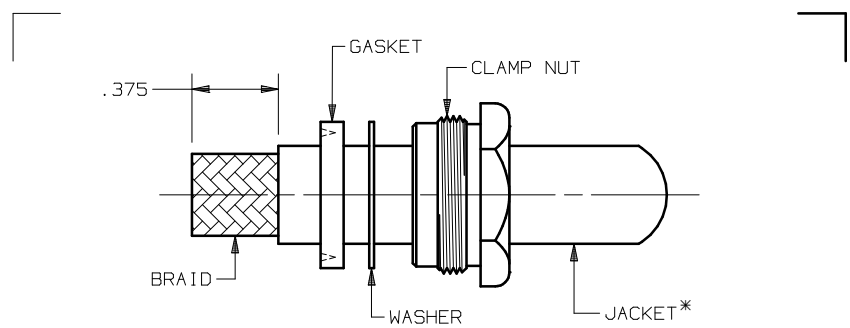
DRAWN: BRT 07/24/00  
 CHECKED: STW 08/04/00  
 APPROVED: STW 08/04/00

SIZE CODE IDENT. SCALE  
 A 95077 N/A

**SV Microwave, Inc.**  
 2400 Centrepark West Drive, Suite 100  
 West Palm Beach, FL 33409

TITLE: CABLE ASSEMBLY INSTRUCTIONS

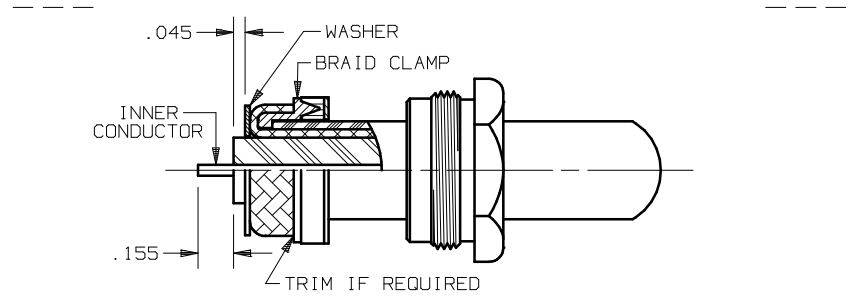
DMG.ND. SHT. 1 OF 2 300-80-955



\* WHEN USING M17/86-00001 CABLE, TRIM OUTER JACKET AS NEEDED, IF NECESSARY.

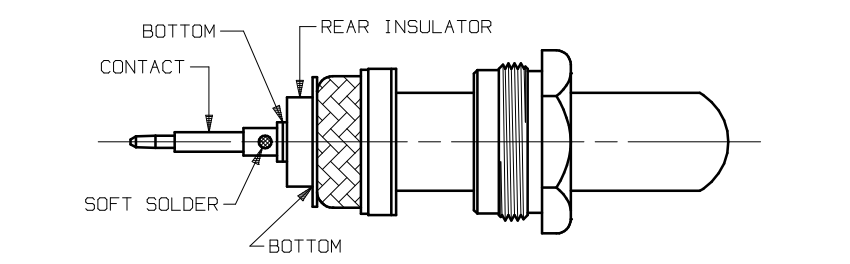
1.0 PREPARE CABLE END

- 1.1 SLIDE CLAMP NUT, WASHER AND GASKET ONTO CABLE.
- 1.2 TRIM CABLE JACKET TO DIMENSION SHOWN WITHOUT NICKING CABLE BRAID.\*



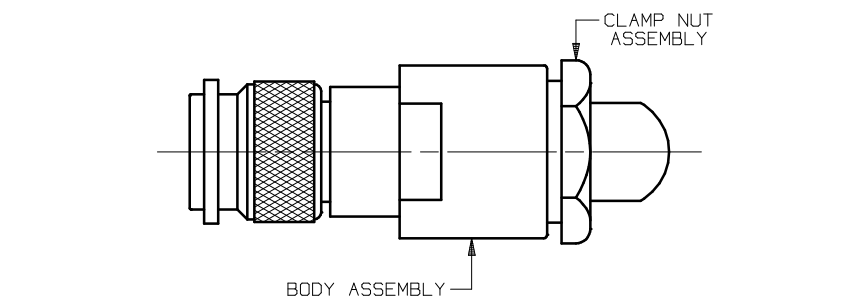
2.0 FORM CABLE BRAID OVER CLAMP

- 2.1 COMB OUT BRAID
- 2.2 INSTALL CLAMP AND FOLD BRAID BACK OVER CLAMP.
- 2.3 TRIM EXCESS BRAID IF REQUIRED.
- 2.4 PLACE WASHER OVER DIELECTRIC AND BOTTOM AGAINST CABLE BRAID.
- 2.5 TRIM DIELECTRIC AND INNER CONDUCTOR TO DIMENSION SHOWN.
- 2.6 TIN INNER CONDUCTOR.



3.0 SOLDER CONTACT

- 3.1 INSTALL INSULATOR BOTTOMING ON WASHER.
- 3.2 INSTALL CONTACT BOTTOMING AGAINST INSULATOR SHOULDER.
- 3.3 SOFT SOLDER CONTACT TO INNER CONDUCTOR.
- 3.4 REMOVE EXCESS SOLDER.



4.0 INSTALL FRONT INSULATOR AND CLAMP NUT INTO BODY ASSEMBLY

- 4.2 INSTALL FRONT INSULATOR INTO BODY ASSEMBLY UNTIL IT BOTTOMS.
- 4.1 THREAD CLAMP NUT ASSEMBLY INTO BODY ASSEMBLY AND WRENCH TIGHTEN TO RECOMMENDED TORQUE: 25-30 IN-LBS.

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DRAWN: BRT 07/24/00  
 CHECKED: STW 08/04/00  
 APPROVED: STW 08/04/00

DIMENSIONS ARE IN INCHES	
DECIMALS	TOLERANCES:
.X ±.030	FRACTIONAL
.XX ±.015	±1/64
.XXX ±.005	
MATERIAL:	ANGULAR
N/A	X° ±1°0'
	X°X' ±15'

FINISH: N/A AREA: N/A  
 SIZE CODE IDENT. SCALE  
 A 95077 N/A

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 DMG.ND. SHT. 2 OF 2  
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