

300-80-111

REV. D

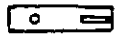
DCN 27663

CABLE ASSEMBLY INSTRUCTIONS

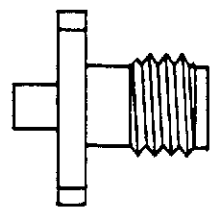
S/M 80049/8334

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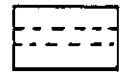
ENG. FILE COPY



CONTACT



BODY



INSULATOR

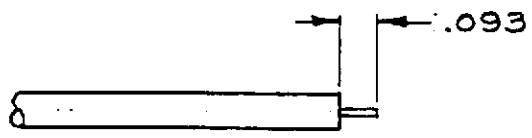
APPR. *[Signature]*

CHECKED *[Signature]* # 2/88

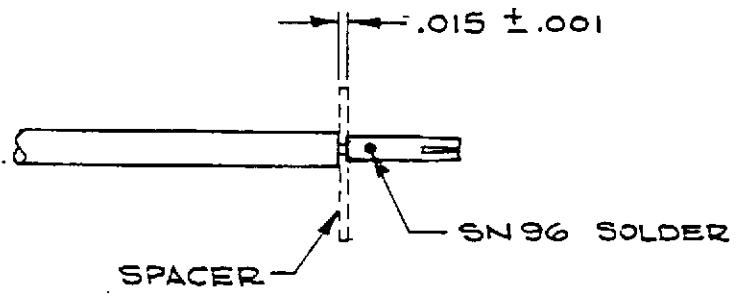
DRAWN R.P.A.

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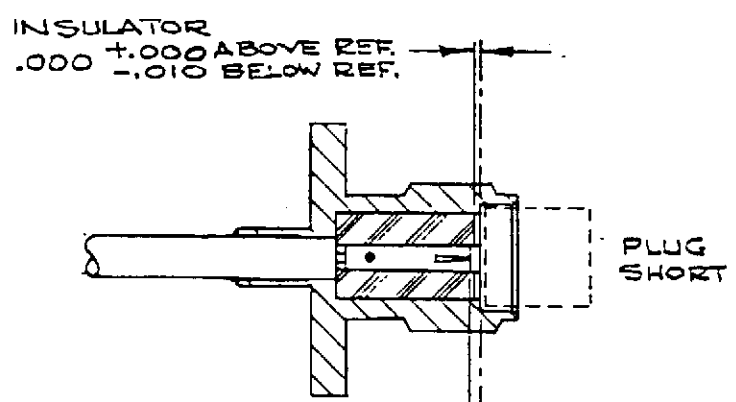
Soliton/Microwave



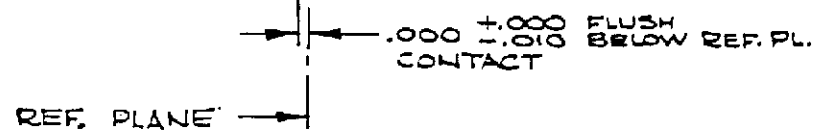
STEP 1.
Trim Cable Jacket and Insulator to Dimensions shown. Being Careful Not to Nick Center Conductor.



STEP 2.
Solder Contact to Center Conductor Using SN96 Solder, Holding Dimension Between Cable Jacket and Contact as Shown Using A $.015 \pm .001$ Spacer. Remove Excess Solder From Contact Outer Diameter to Maintain $.051$ Maximum Contact Diameter.



STEP 3.
Insert Cable Assembly into Connector Assembly Holding Dimensions Shown. Recommend Using A Plug Short at Interface to Control Dimensions. Solder Cable to Connector Using 60/40 Solder. Insert Insulator into Connector Holding Dimensions Shown.



SALES

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