

# SV Microwave Inc.

MARK LABEL PER PARTS LIST

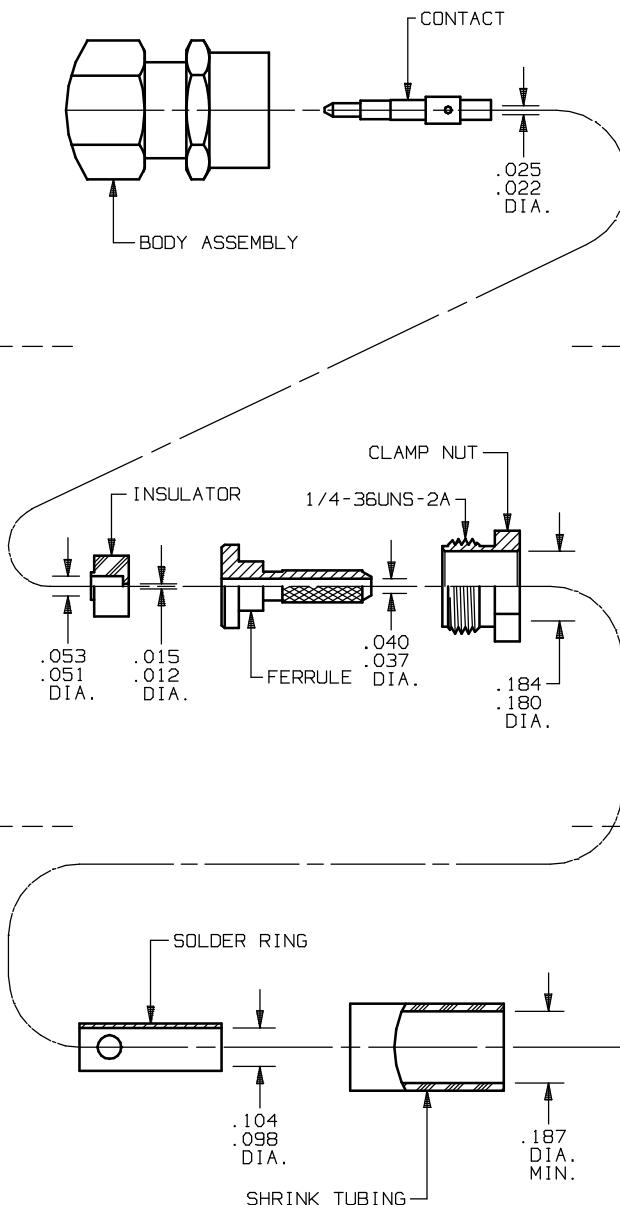
CONNECTOR TYPE.....SMA PLUG  
SOLDER CLAMP ATTACHMENT

CABLE TYPE.....RG-178

SPECIAL TOOL.....NONE

INSTRUCTIONS FOR...M39012/55-3006

## PARTS SUPPLIED



UNFOLD FOR ASSEMBLY INSTRUCTIONS  
CABLE ASSEMBLY PART NUMBER 300-80-947.

SYM.	DESCRIPTION	DATE	APPR.
-	REL. DCN 26018	04/00	STM

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.

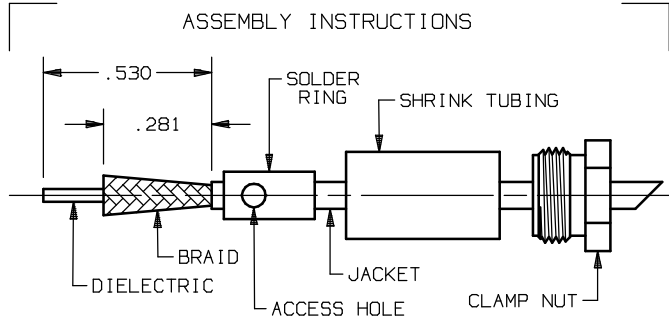
DRAWN: BRT 04/04/00  
 CHECKED: STM 04/11/00  
 APPROVED: STM 04/11/00

DIMENSIONS ARE IN INCHES  
 DECIMALS TOLERANCES: FRACTIONAL  
 .X ±.030  
 .XX ±.015  
 .XXX ±.005  
 MATERIAL: N/A  
 FINISH: N/A  
 AREA: N/A

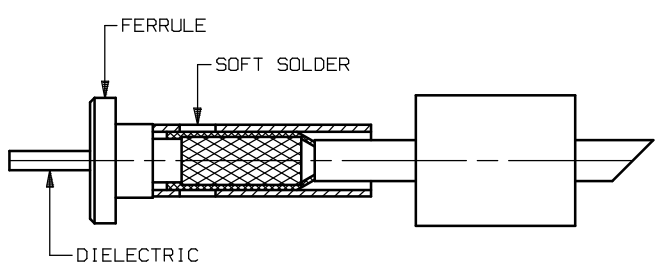
SIZE CODE IDENT. SCALE  
 A 95077 N/A

**SV Microwave, Inc.**  
 3301 Electronics Way  
 West Palm Beach, FL, 33407

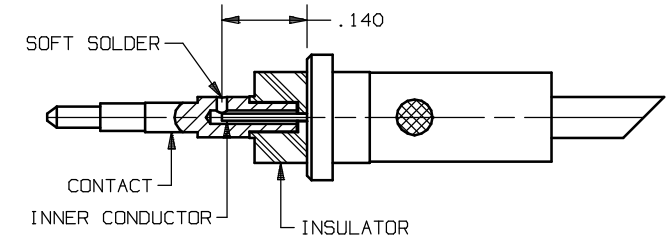
CABLE ASSEMBLY INSTRUCTIONS  
 DWG. NO. 300-80-947  
 SHT. 1 OF 2



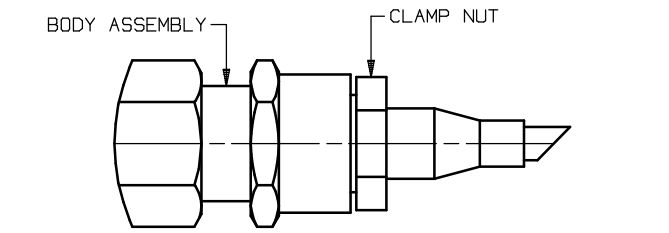
- 1.0 PREPARE CABLE END
  - 1.1 SLIDE CLAMP NUT, SHRINK TUBING AND SOLDER RING ONTO CABLE.
  - 1.2 TRIM CABLE JACKET, BRAID & DIELECTRIC TO DIMENSIONS SHOWN WITHOUT NICKING BRAID.
  - 1.3 FLARE BRAID AS SHOWN.



- 2.0 ATTACH CABLE BRAID TO FERRULE
  - 2.1 SLIDE FERRULE ONTO DIELECTRIC UNTIL FERRULE BOTTOMS.
  - 2.2 SLIDE SOLDER RING FORWARD OVER FLARED BRAID AND POSITION AS SHOWN.
  - 2.3 ATTACH FERRULE BY SOFT SOLDERING SOLDER RING TO BRAID AND FERRULE THRU ACCESS HOLES.



- 3.0 ATTACH CONTACT TO CABLE
  - 3.1 TRIM DIELECTRIC FLUSH WITH FERRULE SHOULDER EXPOSING INNER CONDUCTOR.
  - 3.2 TRIM INNER CONDUCTOR TO DIMENSION SHOWN.
  - 3.3 TIN INNER CONDUCTOR.
  - 3.4 SLIDE CONTACT INTO INSULATOR AND BOTTOM AS SHOWN.
  - 3.5 SLIDE CONTACT/INSULATOR ONTO INNER CONDUCTOR AND BOTTOM AS SHOWN.
  - 3.6 SOFT SOLDER CONTACT ONTO INNER CONDUCTOR.
  - 3.7 REMOVE EXCESS SOLDER IF REQUIRED.



- 4.0 ATTACH CLAMP NUT AND SHRINK TUBING
  - 4.1 SLIDE SHRINK TUBING FORWARD OVER SOLDER RING AND FERRULE BOTTOMING ON FERRULE SHOULDER.
  - 4.2 APPLY HEAT (275°F MIN.) TO SHRINK TUBING.
  - 4.3 INSERT FERRULE ASSEMBLY INTO BODY ASSEMBLY.
  - 4.4 SLIDE CLAMP NUT FORWARD AND TIGHTEN TO COMPLETE ASSEMBLY. (RECOMMENDED TORQUE: 15-20 INCH-POUNDS)

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-	REL. DCN 26018	04/00	STM		
DRAWN: BRT 04/05/00				FINISH: N/A	AREA: N/A
CHECKED: STM 04/11/00				SIZE: A	CODE IDENT: 95077
APPROVED: STM 04/11/00				SCALE: N/A	
DWG. NO. 300-80-947 SHT. 2 OF 2 TITLE: CABLE ASSEMBLY INSTRUCTIONS SOLITRON/VECTOR MICROWAVE 3301 ELECTRONICS WAY WEST PALM BEACH, FL., 33407					