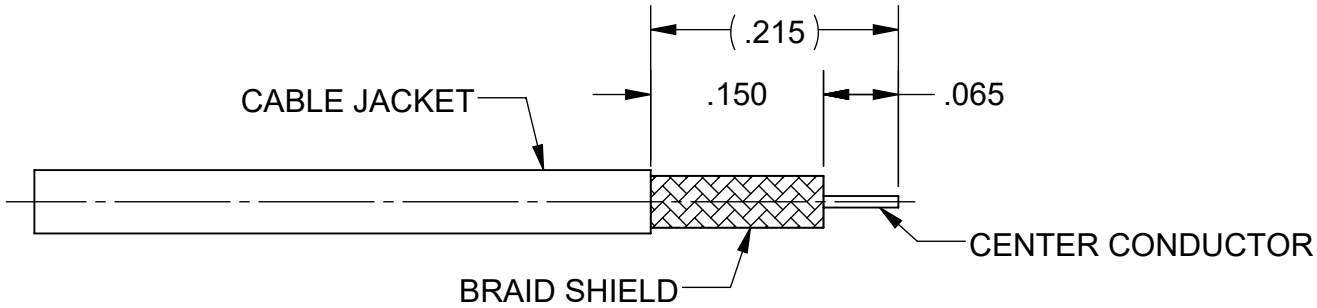
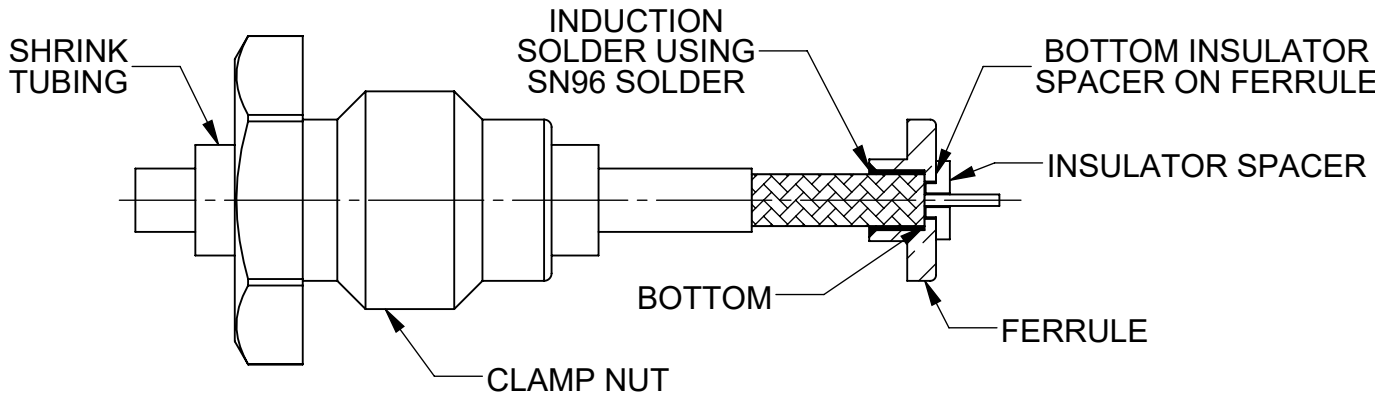


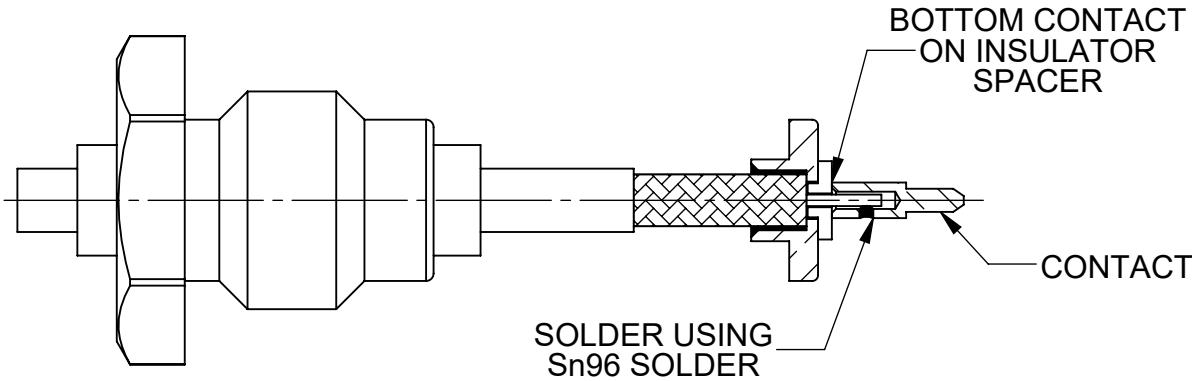
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	NRN 44020	05/19	BNK



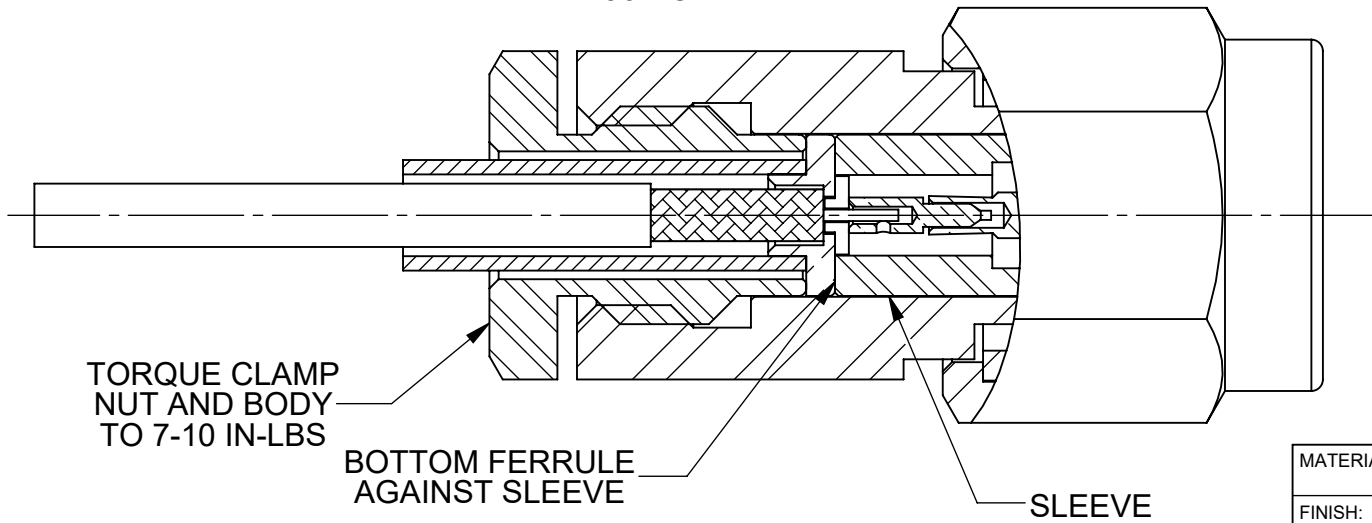
- STEP 1:**
- 1.1) TRIM CABLE JACKET ONLY TO DIMENSION SHOWN.
 - 1.2) APPLY FLUX AND TIN DIP CABLE IN SOLDER POT UP TO CABLE JACKET.
 - 1.3) TRIM CABLE DIELECTRIC TO DIMENSION SHOWN.



- STEP 2:**
- 2.1) SLIDE SHRINK TUBING AND CLAMP NUT OVER CABLE.
 - 2.2) SLIDE FERRULE INTO CABLE AND BOTTOM ON CABLE STOP AS SHOWN.
 - 2.3) INSTALL INSULATOR SPACER ONTO CABLE AND BOTTOM AS SHOWN.
 - 2.4) INDUCTION SOLDER CABLE TO FERRULE AS SHOWN USING Sn96 SOLDER.



- STEP 3:**
- 3.1) INSTALL CONTACT ONTO CABLE CENTER CONDUCTOR. BOTTOM CONTACT ON INSULATOR SPACER AS SHOWN.
 - 3.2) SOLDER CONTACT ONTO CABLE CENTER CONDUCTOR USING Sn96 SOLDER. **BE CAREFUL NOT TO OVERPRESS CONTACT ONTO INSULATOR SPACER.**



- STEP 4:**
- 4.1) INSTALL SLEEVE INSIDE OF CONNECTOR (**NOTE ORIENTATION ON FG DRAWING**).
 - 4.2) SHRINK TUBING OVER FERRULE AND CABLE JACKET.
 - 4.3) PLUG CABLE INTO CONNECTOR AND TORQUE CLAMP NUT TO 7-10 IN-LBS.

MATERIAL:		DIMENSIONS ARE IN INCHES TOLERANCES:		UNLESS OTHERWISE SPECIFIED	
FINISH: PER BOM		FRACTIONAL: $\pm 1/64$ ANGULAR: $X^{\circ} \pm 1^{\circ}0'$ $X^{\circ}X' \pm 15'$		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 .005 T.I.R. 6) REMOVE ALL BURRS	
SURFACE AREA:		DECIMAL: .X $\pm .030$.XX $\pm .010$.XXX $\pm .005$		DRAWN: DEF 05/14/19	
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SV MICROWAVE, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SV MICROWAVE, INC IS PROHIBITED.		INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994		CHECKED: BNK 05/14/19	
THIRD ANGLE PROJECTION		APPROVED: BNK 05/14/19		E.M. SIMULATION: N/A	
SF1511-60110		USED ON:		TITLE: CABLE ASSEMBLY INSTRUCTIONS	
SCALE: 6:1		SIZE B CAGE CODE 95077		DWG. NO. 300-15-064	
SHEET 1 OF 1					