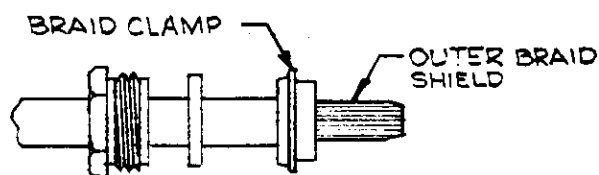
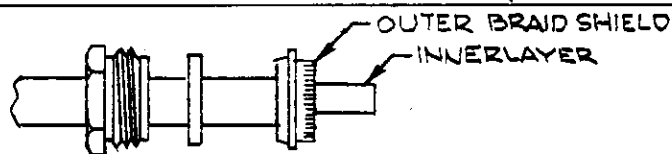


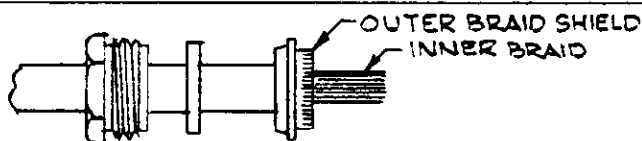
1. Cut cable end square, place clamp nut and gasket over jacket. Remove jacket to dimension shown. Note groove direction of gasket.



2. Comb out braid shield and taper forward. Place braid clamp over braid against jacket cut.



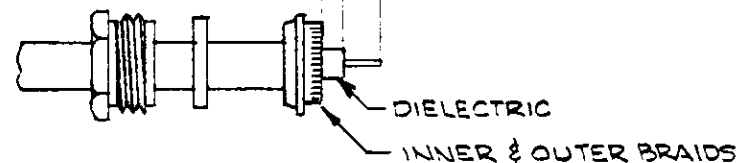
3. Fold braid back over braid clamp and trim as shown.



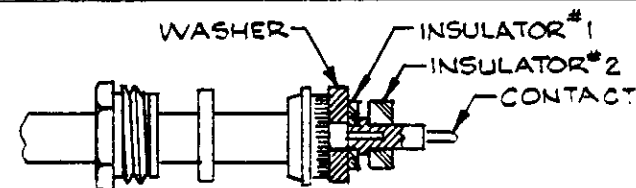
4. Remove interlayer to expose inner braid (cable outer conductor) as shown. Comb out braid, then fold braid back over clamp and trim as done previously.

.220 REF.
.135

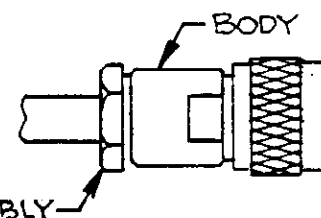
300-80-481



5. Trim dielectric (core) to .135 dimension.



6. Assemble washer, insulator #1 & contact onto cable. Solder contact to center conductor. Assemble insulator #2 onto contact.



7. Thread sub assembly into conductor body and tighten securely by applying 40-50 inch lbs. torque

SYM	DESCRIPTION	DATE	APPR.	UNLESS OTHERWISE SPECIFIED
-	REL. F9110	10/82	(P)	1. ALL DIMENSIONS ARE AFTER PLATING 2. BREAK ALL CORNERS & EDGES .005 R MAX. 3. CHAMFER 1ST & LAST THREADS 45° 4. SURFACE ROUGHNESS 63 ✓ MIL-STD-10 5. DIAMETERS ON COMMON CENTERS TO BE CONCENTRIC WITHIN T.I.R. 6. REMOVE ALL BURRS
				DIMENSIONS ARE IN INCHES TOLERANCES
				DECIMALS FRACTIONAL ANGULAR
				.X ± .030 X' ± 1°0'
				.XX ± .015 ± 1/64
				.XXX ± .005 X'X' ± 15'
				DRAWN JBM DATE 10-15-82
				CHECKED RE DATE 10/19-82
				APPROVED (P) DATE 10/19/82

SOLITRON/MICROWAVE PORT SALERNO, FLORIDA			REF.
MATERIAL _____			TITLE CABLE ASSEMBLY INSTRUCTIONS
FINISH _____	AREA _____		
SCALE —	CODE IDENT. NO. 95077	SIZE A	DRAWING NO. 300-80-481