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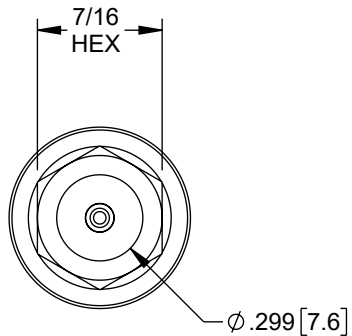
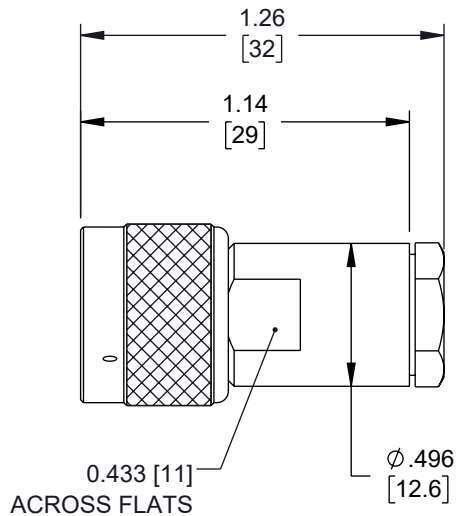
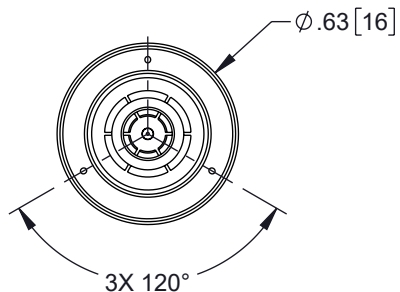
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REVISION

ZONE	REV	DESCRIPTION	DATE	CHANGED BY	APPROVED
D2:D6	C	ECO-13202	04/30/2024	KGLEBOVA	KHIETPAS



UNLESS OTHERWISE SPECIFIED LEADING DIMENSIONS ARE INCHES DIMENSIONS IN [ ] ARE MILLIMETERS

TOLERANCES:

X = ±.2 [5]	FRACTIONS ± 1/32
.XX = ±.02 [0.5]	ANGLES ± 1°
.XXX = ±.005 [0.13]	

CABLE LENGTH TOLERANCES:

≤12 [305]	= +1 [25] / -0
>12 [305] ≤ 60 [1524]	= +2 [51] / -0
>60 [1524] ≤ 120 [3048]	= +4 [102] / -0
>120 [3048] ≤ 300 [7620]	= +6 [152] / -0
>300 [7620]	= +5% / -0

ALL DIMENSIONS ARE FOR REFERENCE ONLY AND SUBJECT TO CHANGE WITHOUT NOTICE UN-DIMENSIONED/NON-CRITICAL FEATURES MAY VARY IN SIZE AND LOCATION COLORS MAY VARY



Website: [www.FairviewMicrowave.com](http://www.FairviewMicrowave.com)  
Phone: 1.800.715.4396 | 1.972.649.6678

<p>INTERPRET ALL DIMENSIONS AND TOLERANCES PER ASME Y14.5</p>	
SCALE NONE	SHEET 1 OF 2

DESCRIPTION  
**78 OHM TRT THREADED PLUG 1553 CONNECTOR  
CLAMP/SOLDER ATTACHMENT FOR FMBC-30-02001, TWC-78-2**

SIZE A	CAGE CODE 3FKR5	DRAWN BY SREITER	ITEM NO. FMCN10-09030-210	REV C
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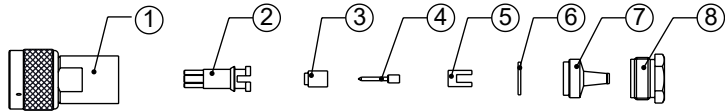
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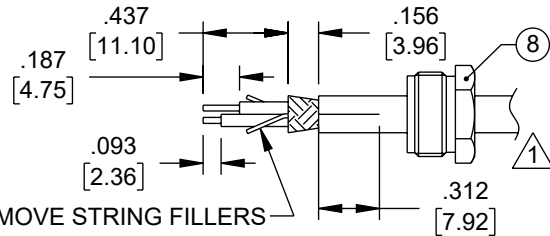
1

# ASSEMBLY INSTRUCTIONS



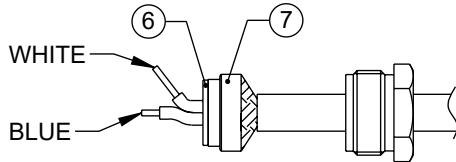
- ① BODY ASSEMBLY
- ② INNER SHIELD
- ③ DIELECTRIC
- ④ CONTACT
- ⑤ NOTCHED INSERT
- ⑥ INSULATING WASHER
- ⑦ CONE
- ⑧ CLAMP NUT

## STEP 1



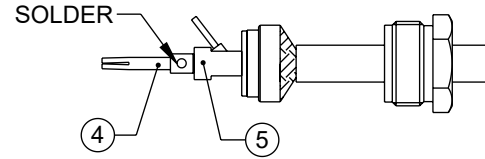
1. PLACE ⑧ ONTO CABLE.
2. STRIP CABLE AS SHOWN AND FLARE BRAID TO ALLOW FREE ENTER OF ⑦. (▲ LATERAL SLITS 180° APART MAY BE REQUIRED FOR INFLEXIBLE JACKET MATERIALS).
3. LIGHTLY TIN CENTER CONDUCTOR.

## STEP 2



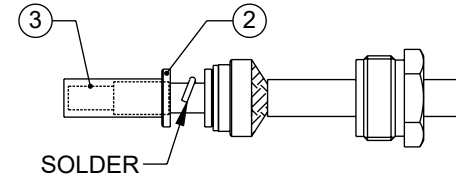
1. PUSH ⑦ UNDER BRAID UNTIL BRAID IS FLUSH WITH EDGE OF ⑦.
2. INSTALL ⑥ OVER CONDUCTORS AND SEAT AGAINST ⑦.
3. BEND LONGER BARED CONDUCTOR AT RIGHT ANGLE AND POSITION OTHER CONDUCTOR TO CENTER OF CABLE.

## STEP 3



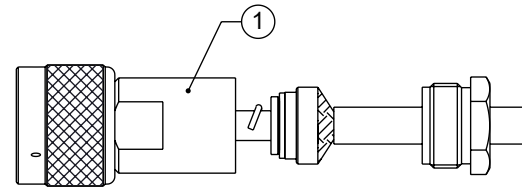
1. PLACE ⑤ OVER CONDUCTORS WITH CENTER CONDUCTOR THRU CENTER HOLE AND OTHER CONDUCTOR THRU SIDE SLOT UNTIL SEATED AGAINST ⑥ OR ⑦.
2. INSTALL ④ OVER CENTER CONDUCTOR. SEAT AGAINST ⑤ AND SOLDER IN PLACE.

## STEP 4



1. PLACE ③ OVER ④ UNTIL BOTTOMED.
2. INSTALL ② OVER ③ & ⑤ WITH CONDUCTOR THRU SIDE SLOT UNTIL BOTTOMED.
3. WRAP CONDUCTOR BETWEEN ② RIDGES AND SOLDER. BEING CAREFUL NOT TO ALLOW SOLDER OR CONDUCTOR TO EXTEND ABOVE ② RIDGES.

## STEP 5



1. BRING ⑧ UP ONTO TAPERED PORTION OF CABLE.
2. ASSEMBLE ① OVER ENTIRE ASSY AND ENGAGE WITH ⑧.
3. WRENCH TIGHTEN TO 25-35 IN LBS TORQUE.



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<small>INTERPRET ALL DIMENSIONS AND TOLERANCES PER ASME Y14.5</small>	
SCALE	SHEET
NONE	2 OF 2

DESCRIPTION  
78 OHM TRT THREADED PLUG 1553 CONNECTOR  
CLAMP/SOLDER ATTACHMENT FOR FMBC-30-02001, TWC-78-2

SIZE	CAGE CODE	DRAWN BY	ITEM NO.	REV
A	3FKR5	SREITER	FMCN10-09030-210	C

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