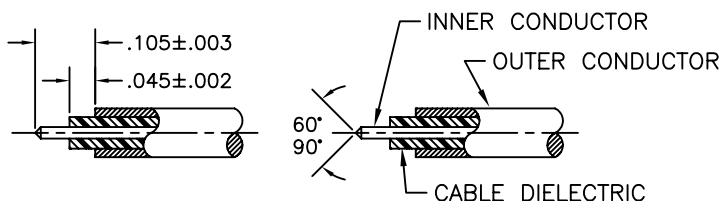


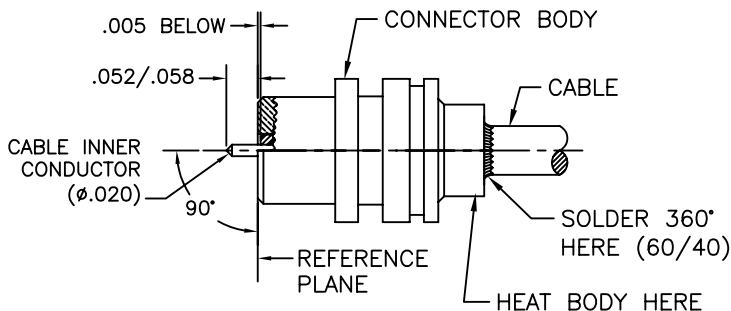
# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



## 1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & INNER DIELECTRIC SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 1.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 1.3 INSPECT CABLE PREPARATION. REMOVE BURRS & SHARP EDGES FROM OUTER CONDUCTOR WITH SCOTCH BRITE.

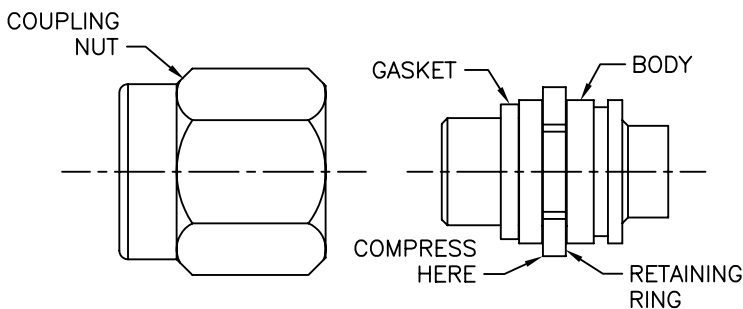
"CABLE CONNECTOR ASSEMBLY FIXTURE BASE NOT SHOWN"



NOTE: EXCESSIVE HEAT CAUSES DIELECTRIC (TEFLON) TO SHRINK BELOW ACCEPTABLE LEVELS. HEAT SOLDER ONLY UNTIL IT STARTS TO FLOW.

## 2.0 SOLDERING OF CABLE TO CONNECTOR BODY:

- 2.1 SLIDE TWO Ø.015 SOLDER RINGS ONTO CABLE. (USING Ø.089 GAUGE PIN, WRAP SOLDER TO FORM TWO RINGS)
- 2.2 SLIDE CONNECTOR BODY ONTO CABLE AS SHOWN UNTIL IT BOTTOMS AGAINST THE INTERNAL CABLE STOP.
- 2.3 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
- 2.4 USING A RESISTIVE SOLDERING IRON, HEAT HOUSING (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.
- 2.5 AVOID GETTING SOLDER ON OUTER FACE OF CONNECTOR.
- 2.6 REMOVE CABLE FROM FIXTURE BASE AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.
- 2.7 INSPECT CENTER CONDUCTOR LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED. (.052/.058)
- 2.8 INSPECT CABLE DIELECTRIC FOR DISTORTION. FACE OF DIELECTRIC SHALL BE .005" BELOW THE REFERENCE PLACE.

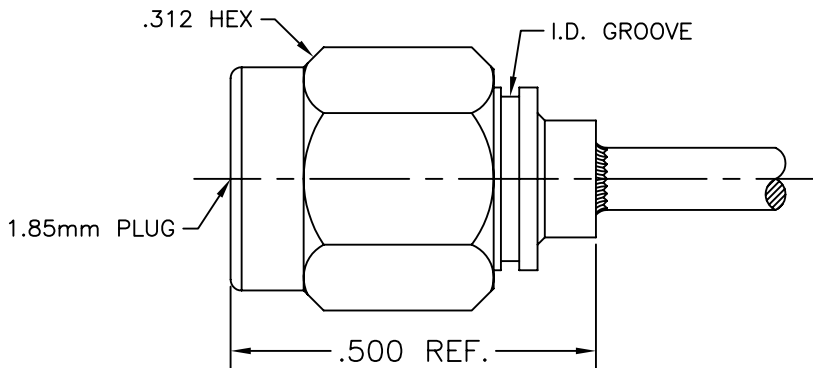


## 3.0 SECURING COUPLING NUT TO CONNECTOR BODY:

- 3.1 PLACE RETAINING RING & GASKET ON BODY AS SHOWN.
- 3.2 COMPRESS RETAINING RING WITH RETAINING RING PLIERS.
- 3.3 PUSH COUPLING NUT OVER THE BODY & RETAINING RING. THE RETAINING RING WILL SNAP INTO PLACE WHEN THE COUPLING NUT IS IN IT'S CORRECT POSITION.
- 3.4 COUPLING NUT SHOULD ROTATE FREELY.

"PROPRIETARY INFORMATION"

## 4.0 ENLARGED VIEW OF CABLE ASSEMBLY: WITHOUT CENTER CONTACT (SEE CABLE DIMENSIONS BELOW)



### TO BE USED ON V085 SEMI-RIGID CABLE:

Impedance: 50 Ohms  
 Dielectric: Ø.055" (Microporous Teflon)  
 Outside Diameter: Ø.085"  
 Center Conductor: Ø.020"

DWG NO.

200-30-15-860

**SGMC MICROWAVE**  
[www.sgmcmicrowave.com](http://www.sgmcmicrowave.com)

### TOOLS REQUIRED:

Equivalent tools may be used if the recommended tools are not available.

TITLE:

1.85mm MALE TO (V085)  
 .085 SEMI-RIGID CABLE  
 LOW LOSS (Direct Solder)  
**"UNASSEMBLED"**

SCALE: NTS	CAGE CODE: 1UYM4	SIZE: A
SHEET: 1 OF 1	DRAWN: LRH II	APPR:
REVISIONS		
LTR: DESCRIPTION: (ECN#)	DATE:	
-- DWG. RELEASED	02/01/06	

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RETAINING RING PLIERS, SCOTCH BRITE.
4. CABLE CONNECTOR ASSEMBLY FIXTURE.
5. SOLVENT (ISOPROPYL ALCOHOL).