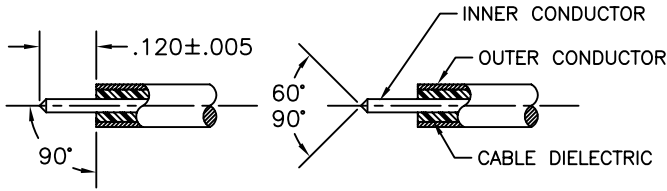


# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

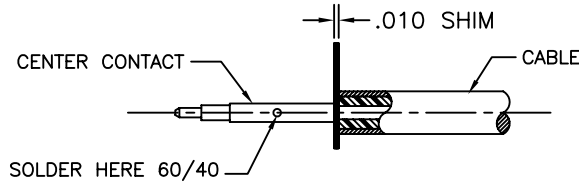
## 1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & INNER DIELECTRIC SHOULD BE 90° FROM CENTERLINE & FLUSH WITH EACHOTHER. 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.



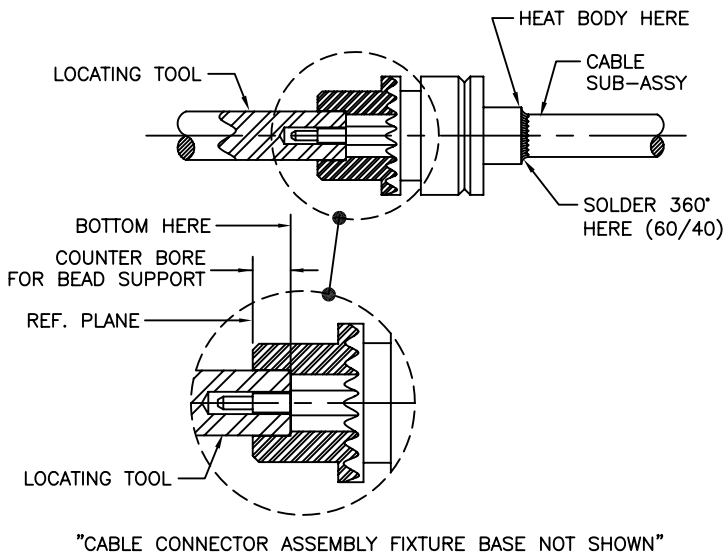
## 2.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

- 2.1 DIP PREPARED END OF CABLE INTO FLUX, THEN INTO SOLDER POT APPROX 1/2" FORMING A THIN COAT OF TIN ON OUTER & INNER CONDUCTOR. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT
- 2.2 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC.
- 2.3 HEAT CENTER CONTACT & PUSH IT OVER INNER CABLE CONDUCTOR TO REST FIRMLY AGAINST SHIM.
- 2.4 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
- 2.5 INSPECT CABLE SUB-ASSY. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT.



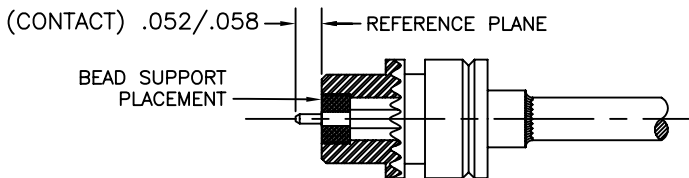
## 3.0 SOLDERING OF CABLE SUB-ASSY TO CONNECTOR BODY:

- 3.1 SLIDE CONNECTOR BODY ONTO CABLE SUB-ASSEMBLY.
- 3.2 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
- 3.3 THREAD LOCATING TOOL INTO FIXTURE BASE.
- 3.4 TIGHTEN LOCATING TOOL (SGMc PT#232-000) INTO FIXTURE BASE UNTIL IT BOTTOMS COMPLETELY AGAINST SHOULDER OF CONTACT. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT IS NOT DAMAGED"
- 3.5 SLIDE BODY OVER CABLE SUB-ASSEMBLY UNTIL IT BOTTOMS AGAINST THE LOCATING TOOL.
- 3.6 USING A RESISTIVE SOLDERING IRON, HEAT HOUSING (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.
- 3.7 REMOVE LOCATING TOOL AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.
- 3.8 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED. (.052/.058)



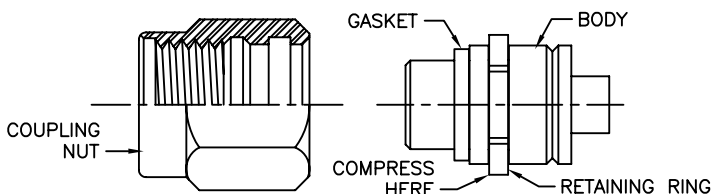
## 4.0 INSERTION OF THE DIELECTRIC BEAD SUPPORT:

- 4.1 PRESS BEAD SUPPORT OVER CENTER CONTACT UNTIL IT BOTTOMS AGAINST COUNTER BORE OF BODY. THE LOCATING TOOL MAY ALSO BE USED FOR THIS PROCESS.
- 4.2 INSPECT BEAD FOR PROPER INSERTION.  
NOTE: DO NOT ALLOW SOLVENTS TO COME IN CONTACT WITH BEAD. THIS MAY DAMAGE BEAD AND EFFECT THE OVERALL PERFORMANCE OF CONNECTOR.



## 5.0 SECURING COUPLING NUT TO CONNECTOR BODY:

- 5.1 PLACE RETAINING RING & GASKET ON BODY AS SHOWN.
- 5.2 COMPRESS RETAINING RING WITH RETAINING RING PLIERS.
- 5.3 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.
- 5.4 COUPLING NUT SHOULD ROTATE FREELY.



DWG NO.

200-32-10-850

**SGMC MICROWAVE**  
www.sgmcmicrowave.com

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. .010 SOLDER SHIM, RAZOR BLADES.
4. INTERFACE MATING TOOL (PT#232-000).
5. RETAINING RING PLIERS, SCOTCH BRITE.
6. CABLE CONNECTOR ASSEMBLY FIXTURE.
7. SOLVENT (ISOPROPYL ALCOHOL).

TITLE:

2.4mm MALE TO  
.085 SEMI-RIGID  
CABLE (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 08/09/01

"PROPRIETARY INFORMATION"