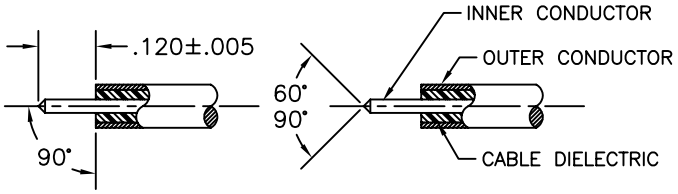
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

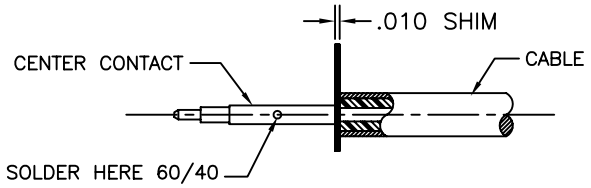


1.0 PREPARATION OF CABLE:

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:

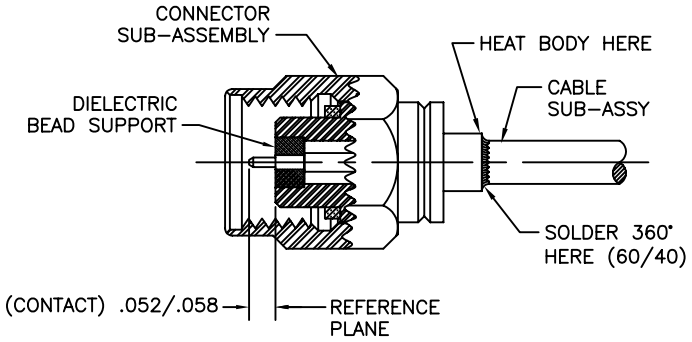
2.1 DIP PREPARED END OF CABLE INTO FLUX, THEN INTO SOLDER POT APPROX 1/2" FORMING A THIN COAT OF TIN ON OUTER & INNER CONDUCTOR. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT

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.



"CABLE CONNECTOR ASSEMBLY FIXTURE BASE NOT SHOWN"

3.0 SOLDERING OF CABLE SUB-ASSY TO CONNECTOR BODY:

3.1 SLIDE CONNECTOR SUB-ASSEMBLY ONTO CABLE SUB-ASSEMBLY AS SHOWN. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT AND/OR DIELECTRIC BEAD SUPPORT ARE NOT DAMAGED"

3.2 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.

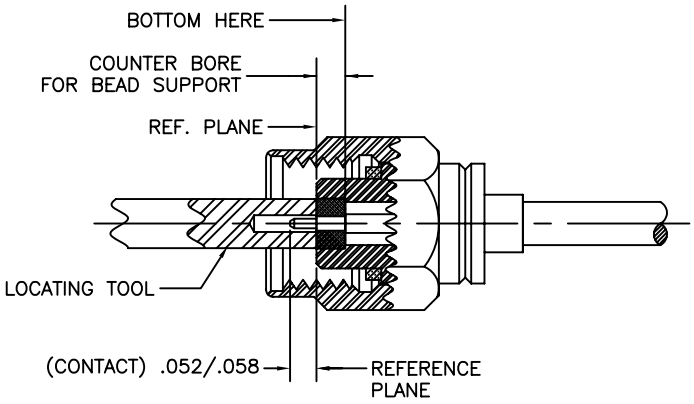
3.3 IF DURING STEP 3.1 THE DIELECTRIC BEAD SUPPORT WAS PRESSED OUT OF THE CONNECTOR SUB-ASSEMBLY YOU MAY USE THE LOCATING TOOL (SGMc PT#232-000) TO REINSERT THE DIELECTRIC. PROCEED TO STEP 4.0 FOR THIS PROCESS.

3.4 USING A RESISTIVE SOLDERING IRON, HEAT HOUSING (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.

3.5 REMOVE LOCATING TOOL AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.

3.6 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED. (.052/.058)

3.7 ASSEMBLY IS NOW COMPLETE.



4.0 REINSERTION 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 BE THREADED INTO THE FIXTURE BASE TO ASSIST IN THIS PROCESS AS SHOWN. " CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT AND/OR DIELECTRIC BEAD SUPPORT ARE NOT DAMAGED"

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.

4.3 UPON PROPER INSERTION OF THE DIELECTRIC BEAD SUPPORT CONTINUE WITH STEP 3.4 TO COMPLETE ASSEMBLY.

DWG NO. 200-32-10-860A

TITLE: 2.4mm MALE TO .085 SEMI-RIGID CABLE LOW LOSS (Direct Solder) "ASSEMBLED"

SGMC MICROWAVE
www.sgmcmicrowave.com

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

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).