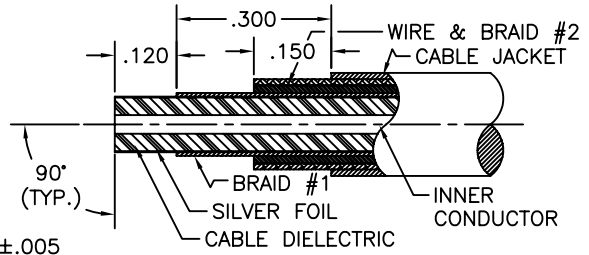
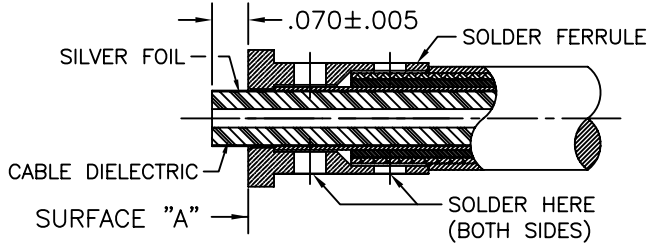


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

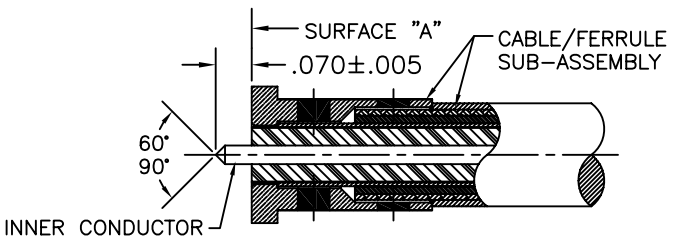


- 1.0 PREPARATION OF CABLE:**
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL, STEEL WIRE, OR INNER BRAID DURING THIS OPERATION.
 - 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.

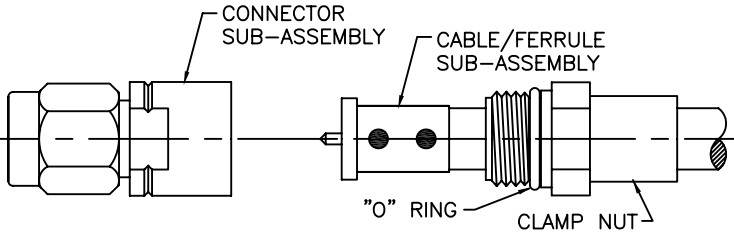


NOTE: DIELECTRIC & FOIL SHALL PROTRUDE PAST SURFACE "A" & REVEAL DIM'S PROVIDED ABOVE. CARE SHOULD BE TAKEN NOT TO NICK OR TEAR FOIL OR DIELECTRIC DURING THIS OPERATION.

- 2.0 SOLDERING OF FERRULE TO INNER BRAID OF CABLE:**
- 2.1 SLIDE CLAMP NUT WITH "O" RING ONTO CABLE AS SHOWN BELOW IN STEP 4.0.
 - 2.2 TIN INNER BRAID OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (CABLE JACKET).
 - 2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).
 - 2.4 INSPECT & REMOVE EXCESS SOLDER AND CLEAN WITH SOLVENT (ALCOHOL).

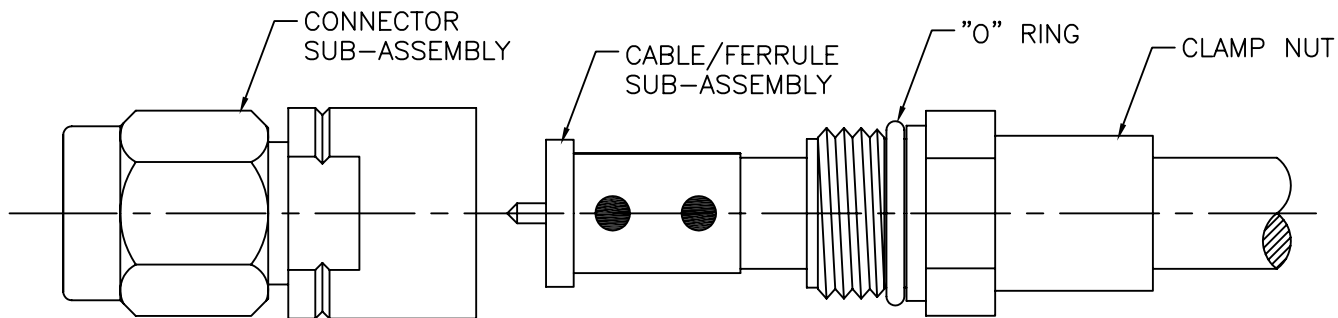


- 3.0 PREPARATION OF CABLE INNER CONDUCTOR:**
- 3.1 TRIM CABLE DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
 - 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
 - 3.3 INSPECT CABLE PREPARATION.



- 4.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:**
- 4.1 PLACE CABLE / FERRULE SUB-ASSEMBLY INTO THE BACK OF CONNECTOR SUB-ASSEMBLY BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR OR CENTER CONTACT OF CONNECTOR.
 - 4.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS.

4.0 ENLARGED VIEW OF CABLE ASSEMBLY:



200-32-20-530

SGMC MICROWAVE
www.sgmcmicrowave.com

- TOOLS REQUIRED:**
1. RESISTANCE SOLDERING MACHINE.
 2. FLUX, SOLDER POT, 60/40 SOLDER.
 3. RAZOR BLADES & SCOTCH BRITE.
 5. SOLVENT (ISOPROPYL ALCOHOL).

TITLE:
2.4mm MALE TO
I.W. 1503 CABLE (REV. G)
(SOLDER CLAMP)

SCALE: NTS	CAGE CODE: 1UYM4	SIZE: A
SHEET: 1 OF 1	DRAWN: LRH II	APPR:
REVISIONS		
LTR:	DESCRIPTION: (ECN#)	DATE:
-	DWG. RELEASED	11/08/04

"PROPRIETARY INFORMATION"