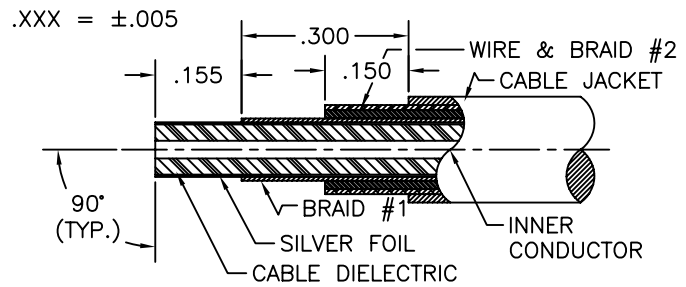
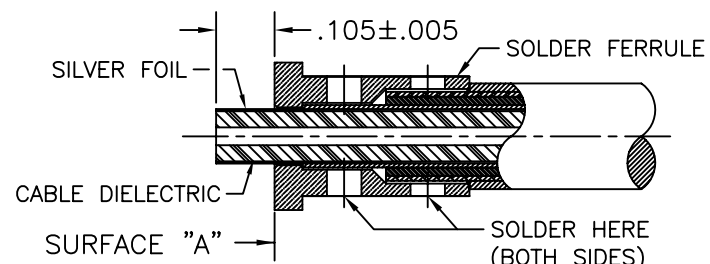


# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

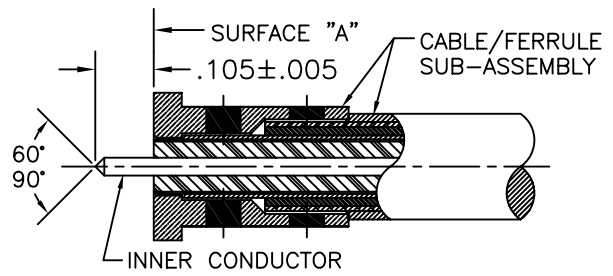


- 1.0 PREPARATION OF CABLE:**
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL, STEEL WIRE, OR INNER BRAID DURING THIS OPERATION.
  - 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS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

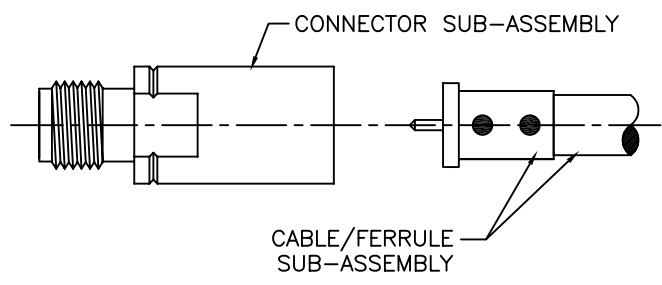


**NOTE:** DIELECTRIC & FOIL SHALL PROTRUDE PAST SURFACE "A" & REVEAL DIM'S PROVIDED ABOVE. CARE SHOULD BE TAKEN NOT TO NICK OR TEAR FOIL OR DIELECTRIC DURING THIS OPERATION.

- 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 (ENLARGED VIEW).
  - 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).

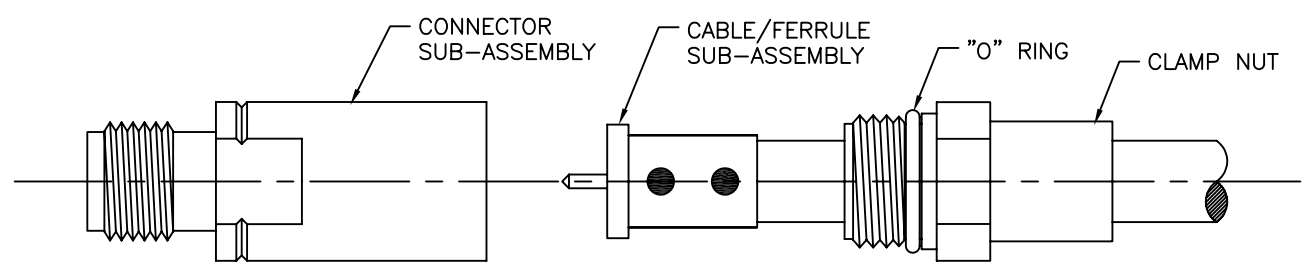


- 3.0 PREPARATION OF CABLE INNER CONDUCTOR:**
- 3.1 TRIM CABLE DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
  - 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
  - 3.3 INSPECT CABLE PREPARATION.



- 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:**



DWG NO. **200-33-20-430**

TITLE:  
**2.4mm FEMALE TO I.W. 1403 CABLE (REV. G) (SOLDER CLAMP)**

**SGMC MICROWAVE**  
[www.sgmcmicrowave.com](http://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       | 08/19/02 |
|               |                     |          |
|               |                     |          |

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