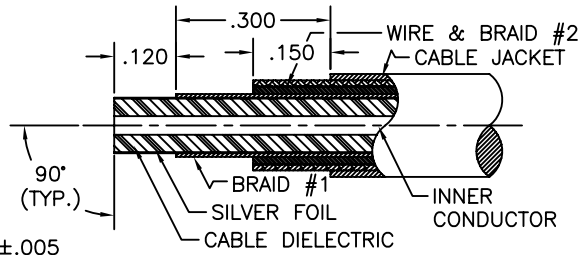


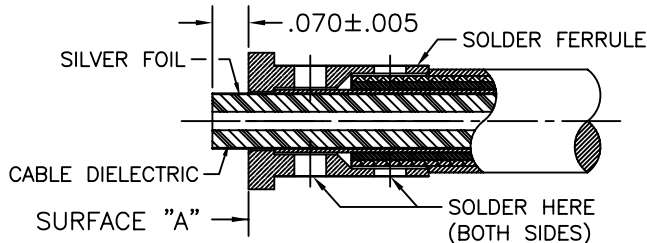
# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



.XXX = ±.005

## 1.0 PREPARATION OF CABLE:

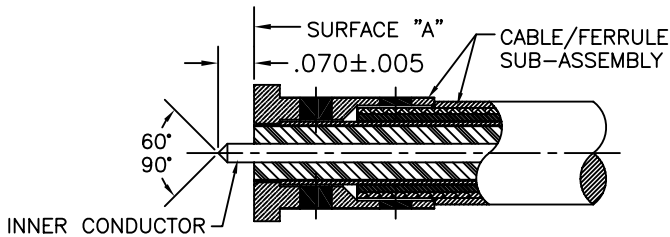
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL, STEEL WIRE, OR INNER BRAID DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



**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.

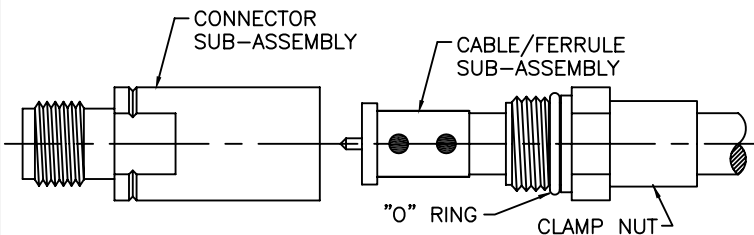
## 2.0 SOLDERING OF FERRULE TO INNER BRAID OF CABLE:

- 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:

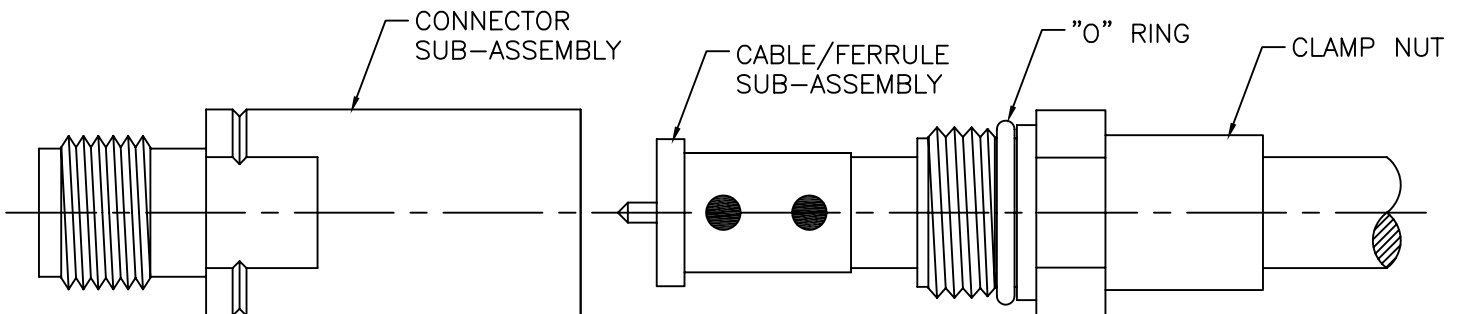
- 3.1 TRIM DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



## 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:



200-33-20-530

**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 FEMALE 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"