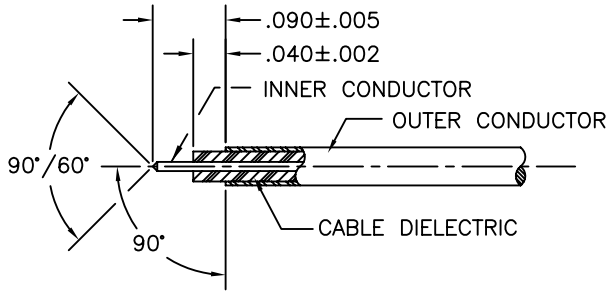
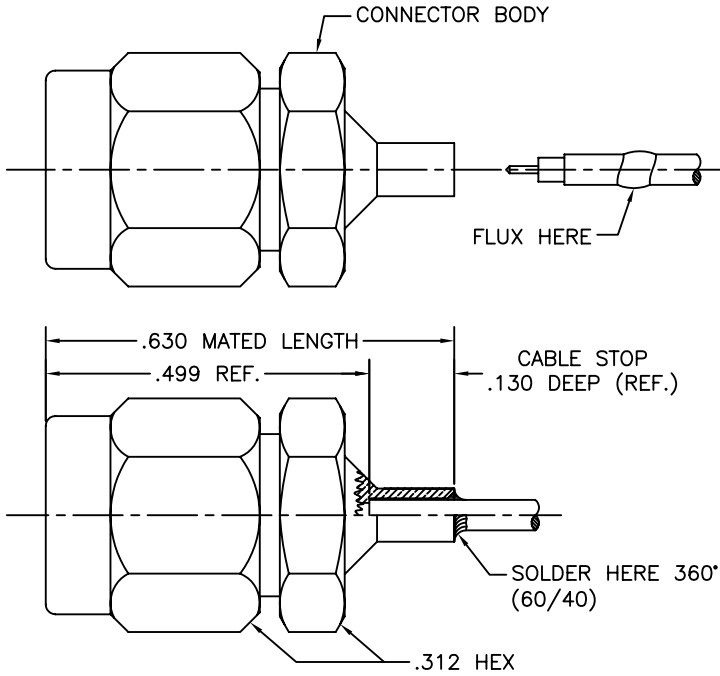


# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



## 1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & DIELECTRIC SHOULD BE 90° FROM CENTERLINE OF CABLE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC OR INNER CONDUCTOR DURING THIS OPERATION.
- 1.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 1.3 INSPECT CABLE PREPARATION FOR DISTORTION OR JAGGED EDGES. REMOVE BURRS & SHARP EDGES FROM OUTER CONDUCTOR WITH SCOTCH BRITE. CARE SHOULD BE TAKEN TO AVOID DAMAGING OR DISTORTING CABLE DIELECTRIC.



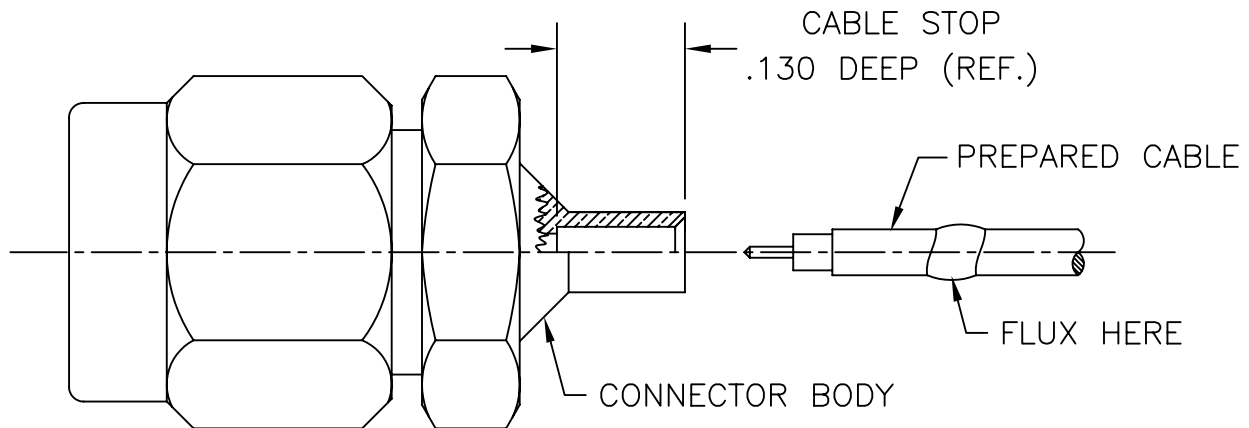
## 2.0 SOLDERING OF CABLE TO CONNECTOR BODY:

- 2.1 APPLY A SMALL AMOUNT OF FLUX APPROXIMATELY .130 INCHES FROM SHOULDER OF OUTER CONDUCTOR.
- 2.2 INSERT CABLE INTO BACK END OF CONNECTOR BODY UNTIL IT BOTTOMS AGAINST THE CABLE STOP LOCATED INSIDE CONNECTOR BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR, DIELECTRIC, OR CENTER CONTACT OF CONNECTOR.
- 2.3 PLACE CABLE / CONNECTOR BODY INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
- 2.4 USING A RESISTIVE SOLDERING IRON, HEAT BODY (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.
- 2.5 REMOVE CABLE ASSEMBLY FROM FIXTURE BASE AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.

### NOTE:

1. DO NOT FORCE CABLE INTO BODY OF CONNECTOR. ONLY MINIMAL FORCE IS REQUIRED DURING THIS PROCESS. IF THE CABLE BECOMES DIFFICULT TO INSERT INTO CONNECTOR BODY REFER TO STEP 1.3. INSPECT CABLE DIELECTRIC FOR DAMAGE & DISTORTION.
2. EXCESSIVE HEAT CAUSES DIELECTRIC (TEFLON) TO SHRINK BELOW ACCEPTABLE LEVELS. HEAT SOLDER ONLY UNTIL IT STARTS TO FLOW.

## 2.0 ENLARGED VIEW OF CABLE ASSEMBLY:



DWG NO. **200-34-10-470**

TITLE: **2.9mm MALE TO .047 SEMI-RIGID CABLE (Direct Solder)**

**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	01/17/03	

### 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"