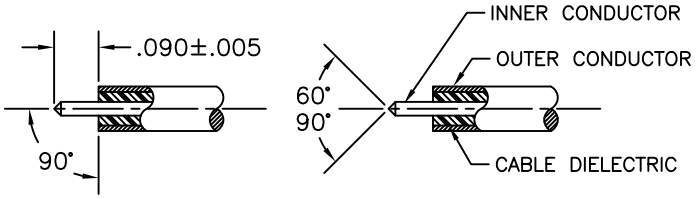
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

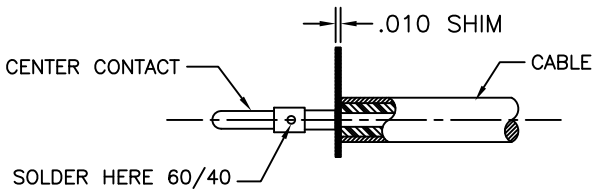


1.0 PREPARATION OF CABLE:

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:

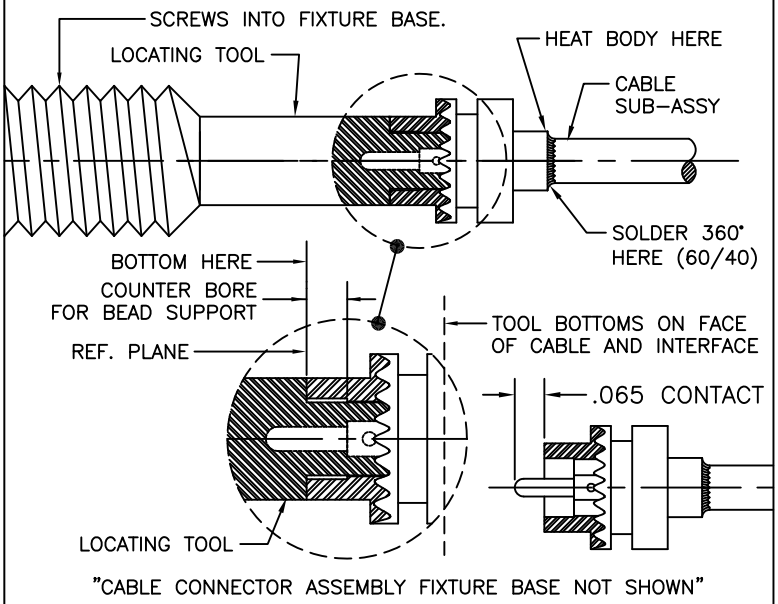
2.1 DIP PREPARED END OF CABLE INTO FLUX, THEN INTO SOLDER POT APPROX 1/2" FORMING A THIN COAT OF TIN ON OUTER & INNER CONDUCTOR. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT

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 BODY ONTO CABLE SUB-ASSEMBLY.

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

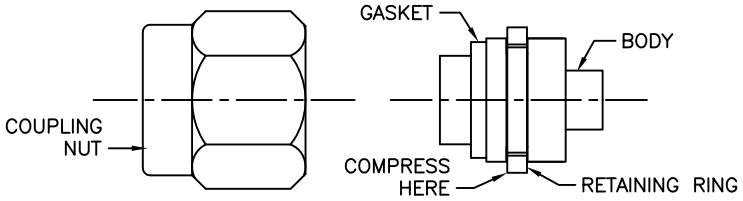
3.3 THREAD LOCATING TOOL INTO FIXTURE BASE.

3.4 TIGHTEN LOCATING TOOL (SGMC PT#234-085) INTO FIXTURE BASE UNTIL IT BOTTOMS COMPLETELY AGAINST THE CONNECTOR INTERFACE. **DO NOT OVER TIGHTEN TOOL.** THE TOOL WILL ALSO BOTTOM SIMULTANEOUSLY ON THE FACE OF THE CABLE REPLICATING A "CABLE STOP". "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT IS NOT DAMAGED OR PUSHED BACK INTO CABLE".

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

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

3.7 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED. (.056/.066)



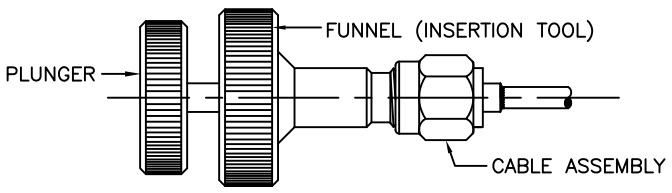
4.0 SECURING COUPLING NUT TO CONNECTOR BODY:

4.1 PLACE RETAINING RING & GASKET ON BODY AS SHOWN.

4.2 COMPRESS RETAINING RING WITH RETAINING RING PLIERS.

4.3 PUSH COUPLING NUT OVER THE BODY & RETAINING RING. THE RETAINING RING WILL SNAP INTO PLACE WHEN THE COUPLING NUT IS IN IT'S CORRECT POSITION.

4.4 COUPLING NUT SHOULD ROTATE FREELY.



5.0 INSERTION OF THE DIELECTRIC BEAD SUPPORT:

5.1 THREAD BEAD INSERTION TOOL (SGMC PN# 434-000) INTO THE COUPLING NUT COMPLETELY. PLACE BEAD INTO BACK OF TOOL AND PRESS INTO POSITION WITH PLUNGER.

5.2 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.

DWG NO. 200-34-10-850

TITLE: 2.92mm MALE TO .085 SEMI-RIGID CABLE (Direct Solder)

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	08/16/02
A	ECN. # 1232	08/01/11

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. .010 SOLDER SHIM, RAZOR BLADES.
4. LOCATING TOOL / CABLE STOP (234-085).
5. BEAD INSERTION TOOL (434-000).
6. RETAINING RING PLIERS, SCOTCH BRITE.
7. CABLE CONNECTOR ASSEMBLY FIXTURE.
8. SOLVENT (ISOPROPYL ALCOHOL).