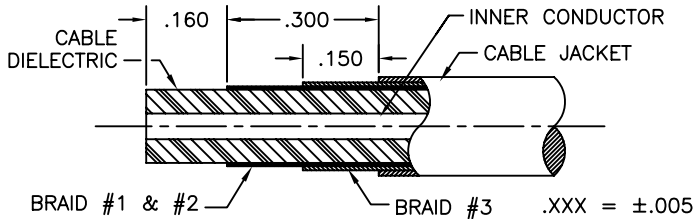
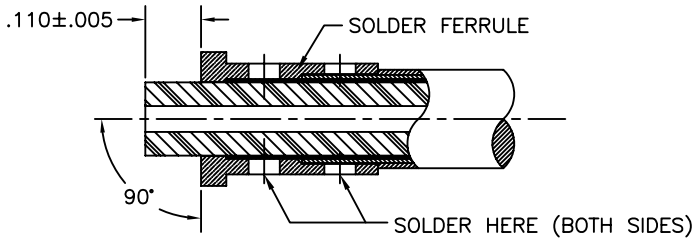


# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



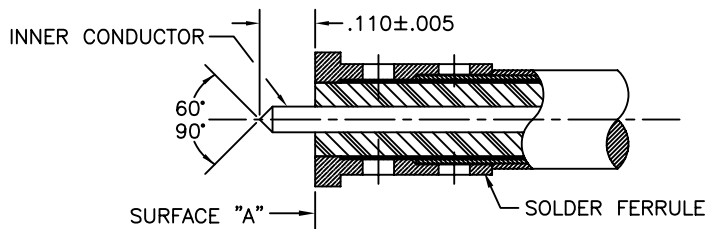
## 1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER JACKET, INNER CONDUCTOR, & INNER BRAIDS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, OR INNER BRAIDS DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



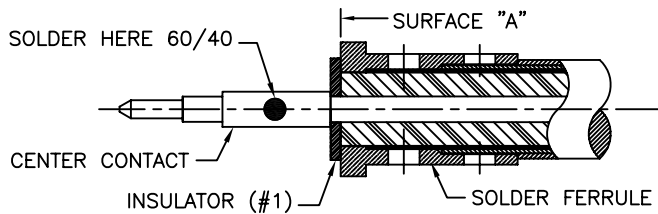
## 2.0 SOLDERING OF FERRULE TO CABLE OUTER CONDUCTOR:

- 2.1 SLIDE CLAMP NUT ONTO CABLE AS SHOWN BELOW IN STEP 5.0 (ENLARGED VIEW).
- 2.2 TIN INNER BRAIDS OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (OUTER CONDUCTOR).
- 2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).
- 2.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.



## 3.0 PREPARATION OF CABLE INNER CONDUCTOR:

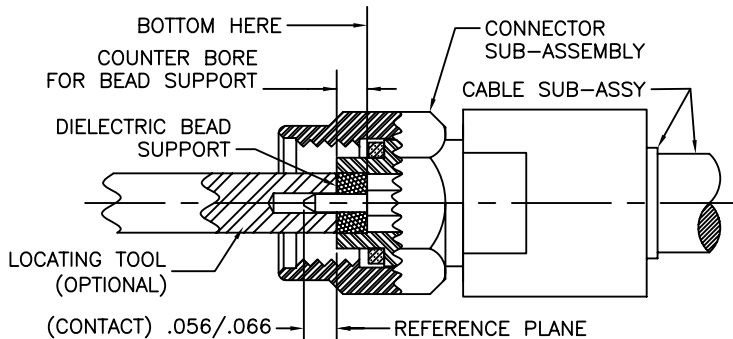
- 3.1 TRIM DIELECTRIC FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



## 4.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

- 4.1 SLIDE INSULATOR (#1) OVER CENTER CONDUCTOR OF CABLE UNTIL IT REST FIRMLY AGAINST SURFACE "A" (FERRULE).
- 4.2 TIN INNER CONDUCTOR OF CABLE. HEAT CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST AGAINST INSULATOR (#1).
- 4.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
- 4.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.

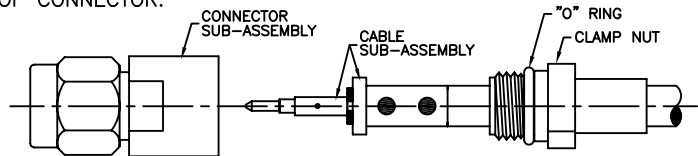
**NOTE:** EXCESSIVE HEAT CAUSES DIELECTRIC (TEFLON) TO SHRINK BELOW ACCEPTABLE LEVELS. HEAT SOLDER ONLY UNTIL IT STARTS TO FLOW.



## 5.0 INSTALLATION OF CABLE SUB-ASSEMBLY:

- 5.1 SLIDE CONNECTOR SUB-ASSEMBLY ONTO CABLE SUB-ASSEMBLY AS SHOWN. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT AND/OR DIELECTRIC BEAD SUPPORT ARE NOT DAMAGED."
- 5.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS.
- 5.2 IF DURING STEP 5.1 & 5.2 THE DIELECTRIC BEAD SUPPORT WAS PRESSED OUT OF THE CONNECTOR SUB-ASSEMBLY YOU MAY USE THE LOCATING TOOL (SGMc PT#234-000) TO REINSERT THE DIELECTRIC. "IF NEEDED: PLACE CABLE CONNECTOR INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT. PRESS BEAD SUPPORT OVER CENTER CONTACT UNTIL IT BOTTOMS AGAINST COUNTER BORE OF BODY. THE LOCATING TOOL MAY BE THREADED INTO THE FIXTURE BASE TO ASSIST IN THIS PROCESS AS SHOWN. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT AND/OR DIELECTRIC BEAD SUPPORT ARE NOT DAMAGED".
- 5.3 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED. (.056/.066).

**NOTE:** DO NOT ALLOW SOLVENTS TO COME IN CONTACT WITH BEAD. THIS MAY DAMAGE BEAD AND EFFECT THE OVERALL PERFORMANCE OF CONNECTOR.



DWG NO. **200-34-20-421**

**SGMC MICROWAVE**  
www.sgmcmicrowave.com

### TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES.
4. SOLVENT (ISOPROPYL ALCOHOL).
5. INTERFACE MATING TOOL (PT#234-000).
6. CABLE CONNECTOR ASSEMBLY FIXTURE.

TITLE:  
**2.9mm MALE TO  
LL 142 CABLE  
(Solder Clamp)**

SCALE: NTS	CAGE CODE: 1UYM4	SIZE: A
SHEET: 1 OF 1	DRAWN: LRH II	APPR:
REVISIONS		
LTR: DESCRIPTION: (ECN#)	DATE:	
- DWG. RELEASED	11/23/05	

**"PROPRIETARY INFORMATION"**