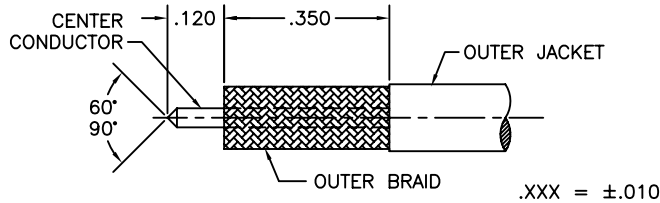
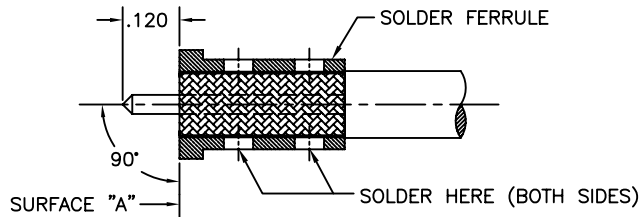


# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



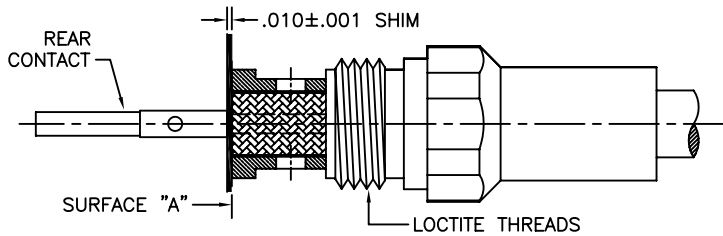
## 1.0 PREPARATION OF CABLE:

- 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 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 1.3 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



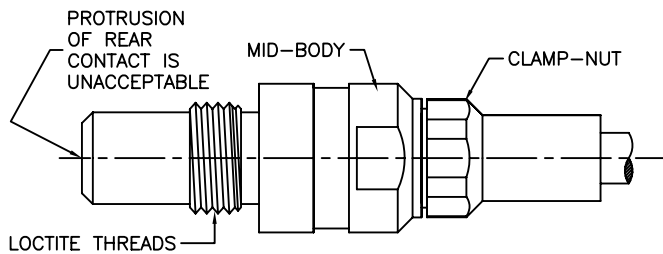
## 2.0 SOLDERING OF FERRULE TO CABLE OUTER BRAID:

- 2.1 SLIDE CLAMP NUT ONTO CABLE AS SHOWN BELOW IN STEP 5.0 (ENLARGED VIEW).
- 2.2 TIN OUTER BRAID OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (OUTER JACKET).
- 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 SOLDERING OF REAR CONTACT TO INNER CABLE CONDUCTOR:

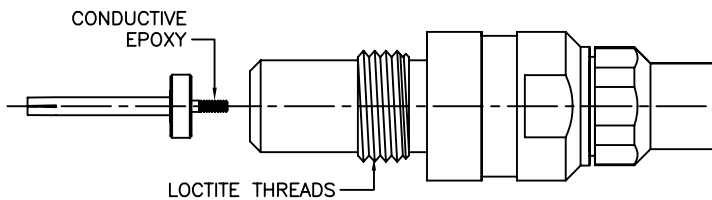
- 3.1 TIN INNER CONDUCTOR OF CABLE.
- 3.2 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC / FERRULE SURFACE "A". HEAT REAR CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST SOLDER SHIM.
- 3.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
- 3.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.



## 4.0 CLAMP NUT AND MID-BODY ASSEMBLY:

- 4.1 APPLY ONE DROP OF LOCTITE #271 ON CLAMP NUT THREADS.
- 4.2 SLIDE THE CLAMP NUT OVER CABLE UNTIL IT BOTTOMS ON THE FLANGE OF THE SOLDER FERRULE. THREAD CLAMP NUT INTO MID-BODY AND TIGHTEN USING FLATS / HEX PROVIDED.
- 4.3 INSPECT CENTER CONTACT LOCATION WITH RESPECT TO MID-BODY.
- 4.4 CONTACT MUST BE FLUSH TO BELOW .002 MAX. PROTRUSION OF REAR CONTACT IS UNACCEPTABLE.

## "EXCESS CONDUCTIVE EPOXY WILL CAUSE FAILURES"

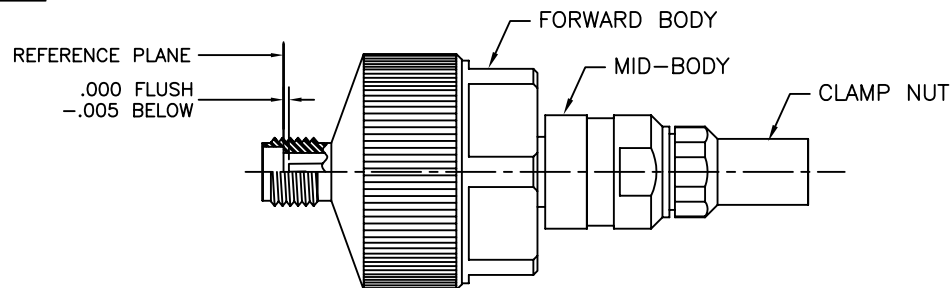


## 5.0 FORWARD CONTACT / FORWARD BODY ASSEMBLY:

- 5.1 APPLY A THIN FILM OF CONDUCTIVE EPOXY ON THE THREADS OF THE FORWARD CONTACT SUB-ASSEMBLY.
- 5.2 THREAD FORWARD CONTACT INTO REAR CONTACT. TIGHTEN USING FINGERS. THE BEAD SHOULD REST AGAINST THE SURFACE OF THE MID-BODY. THERE SHOULD NOT BE ANY SPACE BETWEEN THE MID-BODY AND BEAD. APPLY ONE DROP OF LOCTITE # 271 ON THE THREADS OF MID-BODY. THREAD FORWARD BODY ONTO MID-BODY CABLE ASSEMBLY. TIGHTEN USING FLATS / HEX PROVIDED.

## 5.0 ENLARGED VIEW OF CABLE ASSEMBLY:

### "INSPECT INTERFACE"



DWG NO. **200-35-20-360**

**SGMC MICROWAVE**  
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### TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
  2. FLUX, SOLDER POT, 60/40 SOLDER.
  3. RAZOR BLADES.
  4. 3/4, 5/16 & 3/8 WRENCHES.
  5. LOCTITE 271 (RED)
  6. CONDUCTIVE EPOXY.
  7. SOLVENT (ISOPROPYL ALCOHOL).
- "PROPRIETARY INFORMATION"**

TITLE:  
**2.92mm FEMALE TO  
ALPEN A40 & A36 CABLES  
SOLDER CLAMP**

SCALE: NTS	CAGE CODE: 1UYM4	SIZE: A
SHEET: 1 OF 1	DRAWN: LRH II	APPR:
REVISIONS		
LTR: DESCRIPTION: (ECN#)	DATE:	
- DWG. RELEASED	11/19/04	
A ECN. #1145	01/18/05	