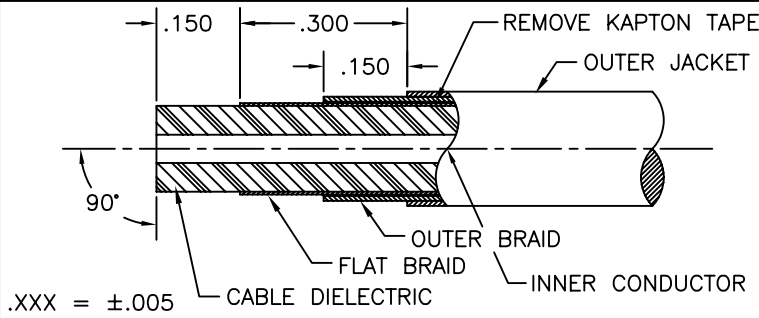
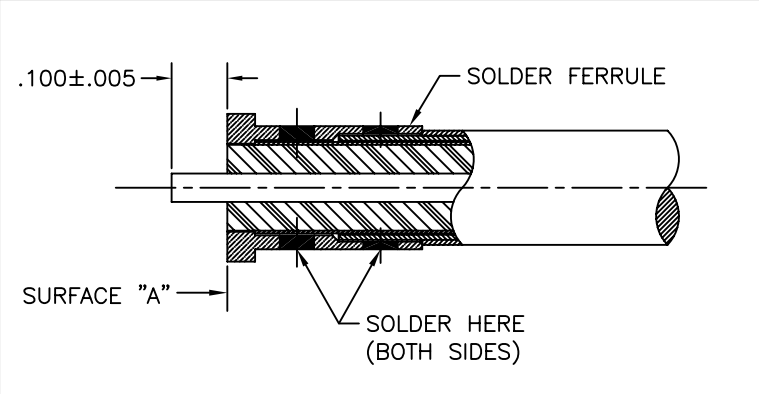


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



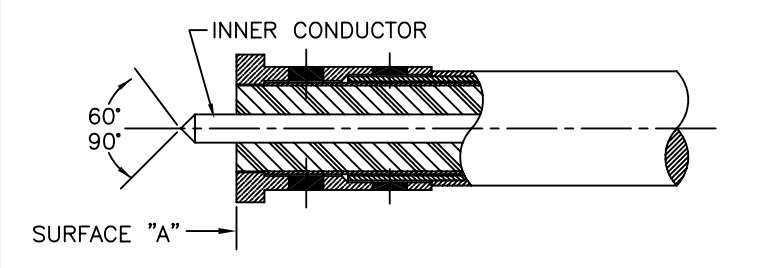
1.0 PREPARATION OF CABLE:

- 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.



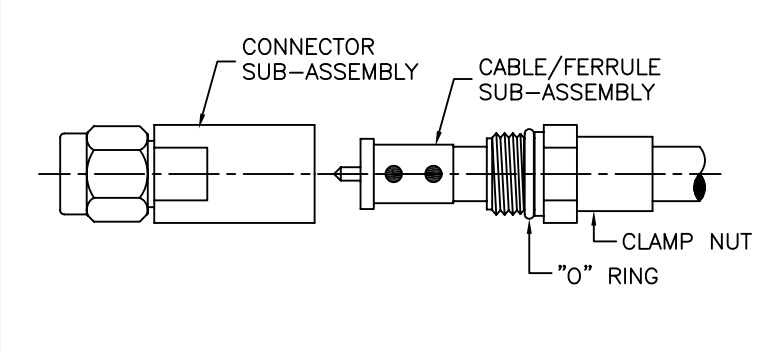
2.0 SOLDERING OF FERRULE TO CABLE OUTER CONDUCTOR:

- 2.1 SLIDE CLAMP NUT WITH "O" RING ONTO CABLE AS SHOWN BELOW IN STEP 4.0 (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 INSPECT CABLE DIELECTRIC. DIELECTRIC SHOULD BE FLUSH TO SURFACE "A".
- 2.4 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).
- 2.5 INSPECT & REMOVE EXCESS SOLDER AND CLEAN WITH SOLVENT (ALCOHOL).



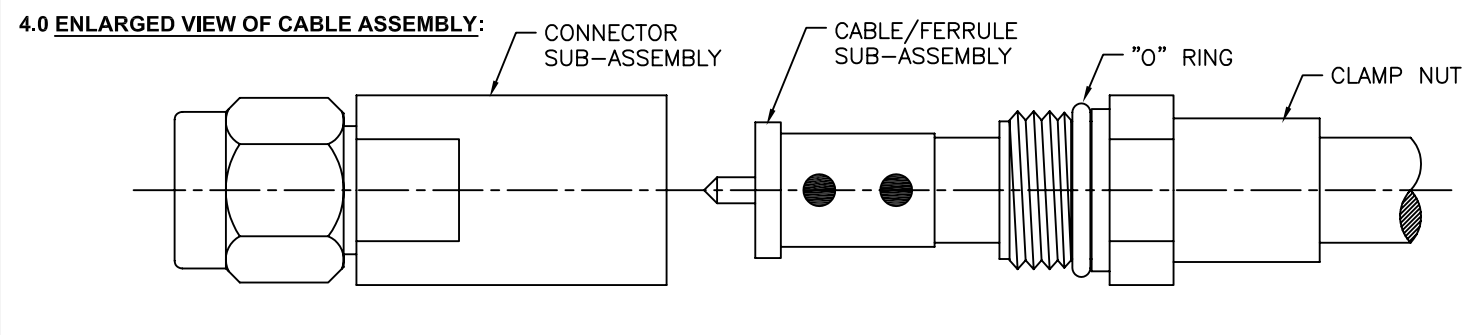
3.0 PREPARATION OF CABLE INNER CONDUCTOR:

- 3.1 INSPECT DIELECTRIC SURFACE. DIELECTRIC SHOULD BE FLUSH TO SURFACE "A".
- 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.



DWG NO. **200-36-20-050**

TITLE:
**3.5mm MALE TO
SFT 205 CABLE
Low Loss (Solder Clamp)**

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	05/13/04	

TOOLS REQUIRED:
1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES.
4. SOLVENT (ISOPROPYL ALCOHOL).

"PROPRIETARY INFORMATION"