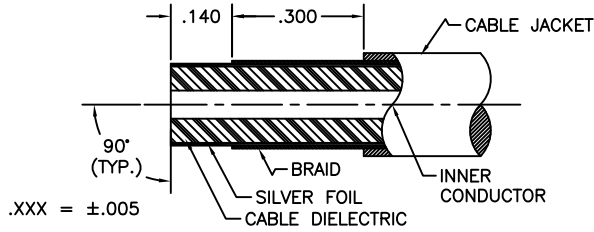
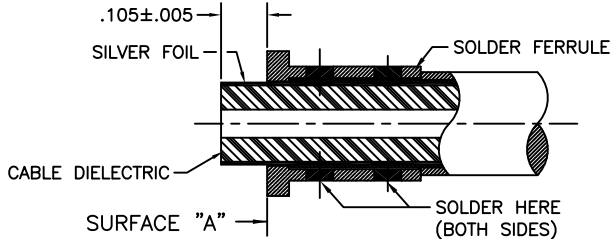


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



1.0 PREPARATION OF CABLE:

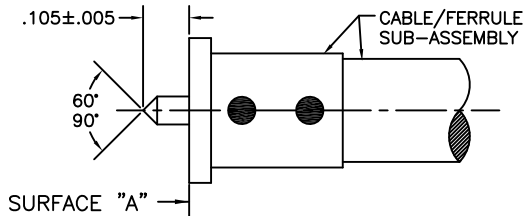
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL, OUTER BRAID DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



NOTE: DIELECTRIC & FOIL SHALL PROTRUDE PAST SURFACE "A" & REVEAL DIM'S PROVIDED ABOVE. CARE SHOULD BE TAKEN NOT TO NICK OR TEAR FOIL OR DIELECTRIC DURING THIS OPERATION.

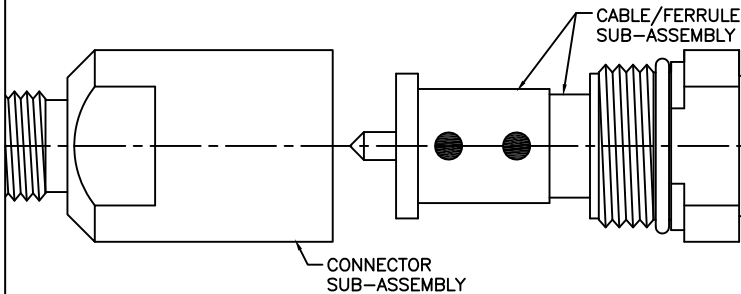
2.0 SOLDERING OF FERRULE TO INNER BRAID OF CABLE:

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



3.0 PREPARATION OF CABLE INNER CONDUCTOR:

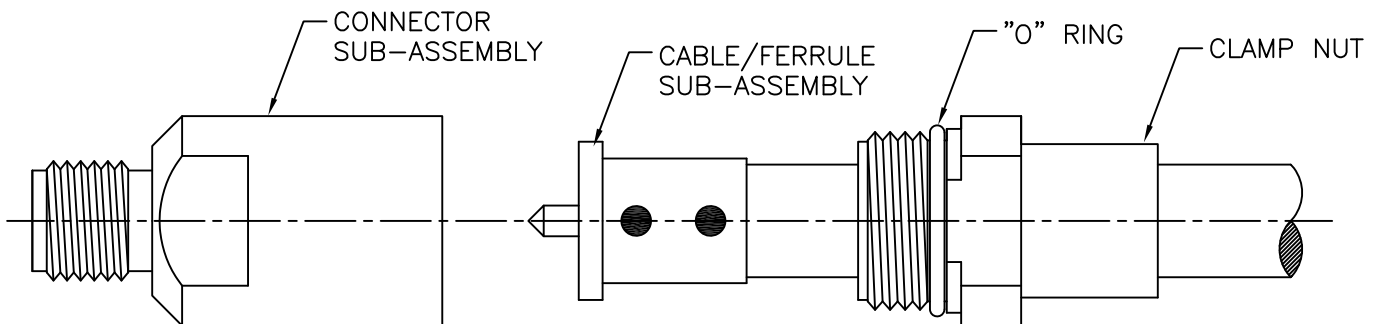
- 3.1 TRIM CABLE DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



4.0 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.

4.0 ENLARGED VIEW OF CABLE ASSEMBLY:



200-37-20-230

SGMC MICROWAVE
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TOOLS REQUIRED:

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

TITLE:

3.5mm FEMALE TO
I.W. 2301 CABLE (REV. N)
(SOLDER CLAMP)

SCALE: NTS CAGE CODE: 1UYM4 SIZE: A

SHEET: 1 OF 1 DRAWN: LRH II APPR:

REVISIONS

LTR:	DESCRIPTION: (ECN#)	DATE:
-	DWG. RELEASED	08/26/03

"PROPRIETARY INFORMATION"