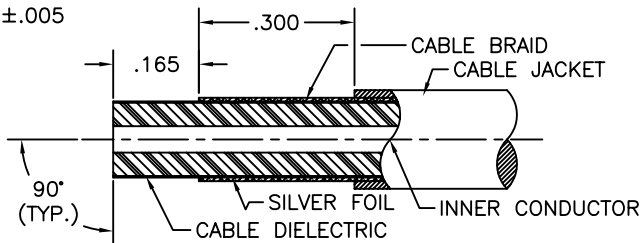


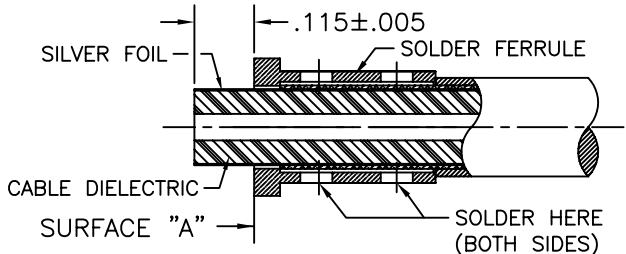
# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

.XXX = ±.005



## 1.0 PREPARATION OF CABLE:

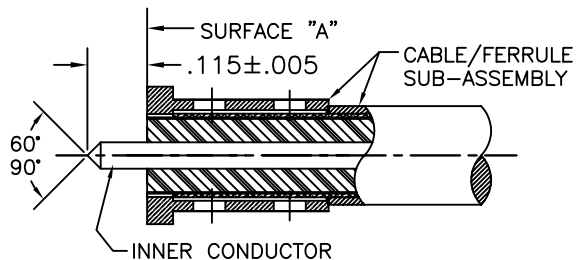
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL OR INNER BRAID DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



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

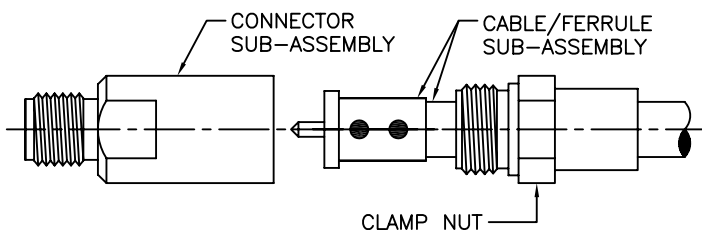
## 2.0 SOLDERING OF FERRULE TO INNER BRAID OF CABLE:

- 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:

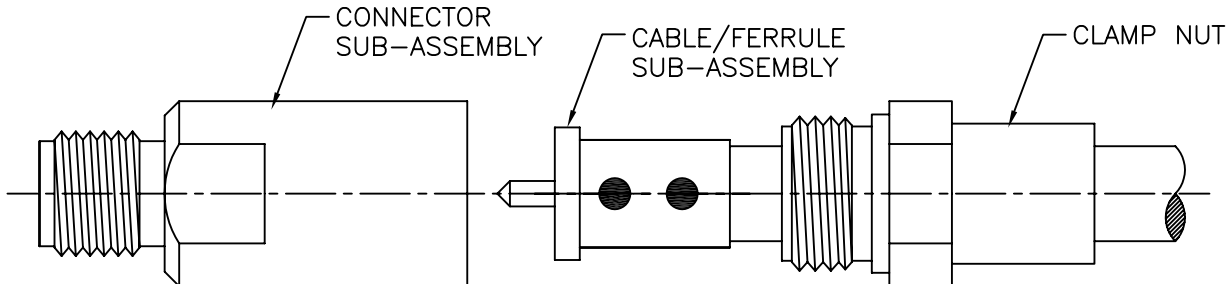
- 3.1 TRIM CABLE DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



## 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:



DWG NO.

200-37-20-810

**SGMC MICROWAVE**  
[www.sgmcmicrowave.com](http://www.sgmcmicrowave.com)

### TOOLS REQUIRED:

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

TITLE:

3.5mm FEMALE TO  
I.W. 1801 CABLE (REV. M)  
(SOLDER CLAMP)

SCALE: NTS    CAGE CODE: 1UYM4    SIZE: A

SHEET: 1 OF 1    DRAWN: LRH II    APPR:

REVISIONS

LTR:	DESCRIPTION: (ECN#)	DATE:
-	DWG. RELEASED	08/25/03

"PROPRIETARY INFORMATION"