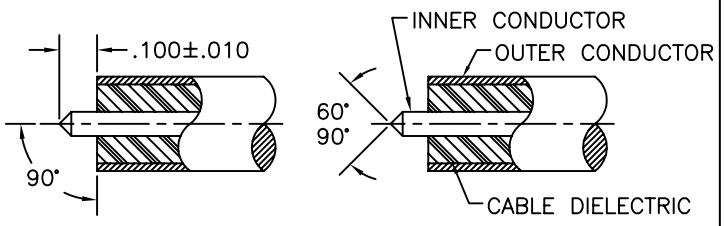
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

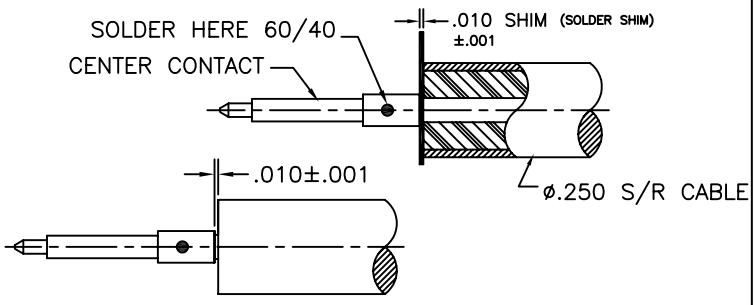


1.0 PREPARATION OF CABLE:

1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & INNER DIELECTRIC SHOULD BE 90° FROM CENTERLINE & FLUSH WITH EACH OTHER. CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.

1.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.

1.3 INSPECT CABLE PREPARATION. REMOVE BURRS & SHARP EDGES FROM OUTER CONDUCTOR WITH SCOTCH BRITE.



2.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

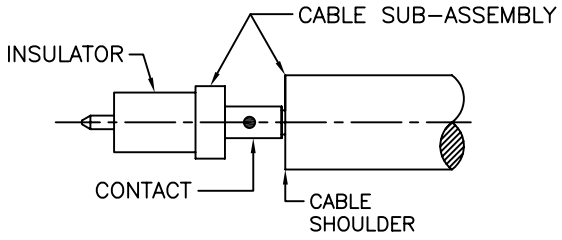
2.1 DIP PREPARED END OF CABLE INTO FLUX, THEN INTO SOLDER POT FORMING A THIN COAT OF TIN ON OUTER & INNER CONDUCTOR. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT.

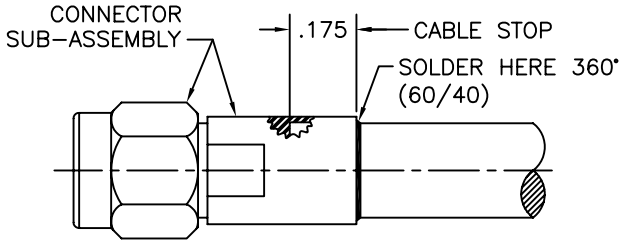
2.2 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC & OUTER CONDUCTOR.

2.3 HEAT CENTER CONTACT & PUSH IT OVER INNER CABLE CONDUCTOR TO REST FIRMLY AGAINST SHIM. (SOLDER GAGE)

2.4 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.

2.5 INSPECT CABLE SUB-ASSY. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT.





3.0 SOLDERING OF CABLE SUB-ASSY TO CONNECTOR SUB-ASSY:

3.1 SLIDE INSULATOR ONTO CONTACT AS SHOWN.

3.2 SLIDE CABLE SUB-ASSEMBLY INTO CONNECTOR SUB-ASSEMBLY UNTIL THE SHOULDER OF THE CABLE BOTTOMS COMPLETELY AGAINST THE CABLE STOP LOCATED INSIDE THE CONNECTOR BODY.

3.3 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.

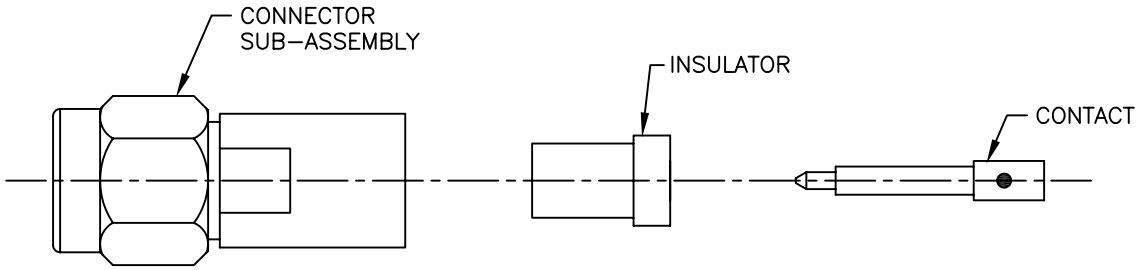
3.4 USING A RESISTIVE SOLDERING IRON, HEAT BODY (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.

3.5 REMOVE CABLE ASSEMBLY AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.

INSPECT INTERFACE DIMENSION:

PIN = .000/-.010 (FLUSH TO BELOW REF. PLANE)
DIELECTRIC = .000/-.010 (FLUSH TO BELOW REF. PLANE)

5.0 CONNECTOR LAYOUT:



DWG NO. 200-50-10-250

TITLE:

SMA MALE TO
.250 SEMI-RIGID CABLE
(Direct Solder)

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	04/13/05

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. .010 SOLDER SHIM, RAZOR BLADES.
4. SCOTCH BRITE.
5. CABLE CONNECTOR ASSEMBLY FIXTURE.
6. SOLVENT (ISOPROPYL ALCOHOL).