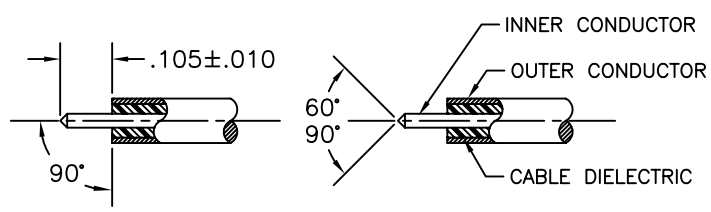
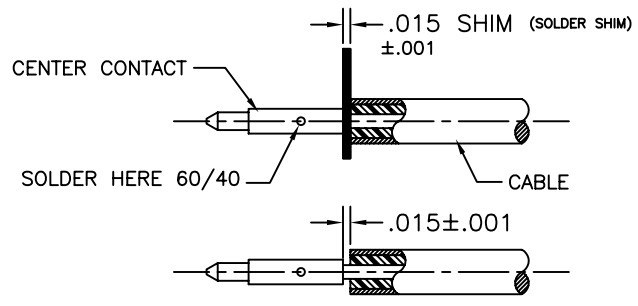


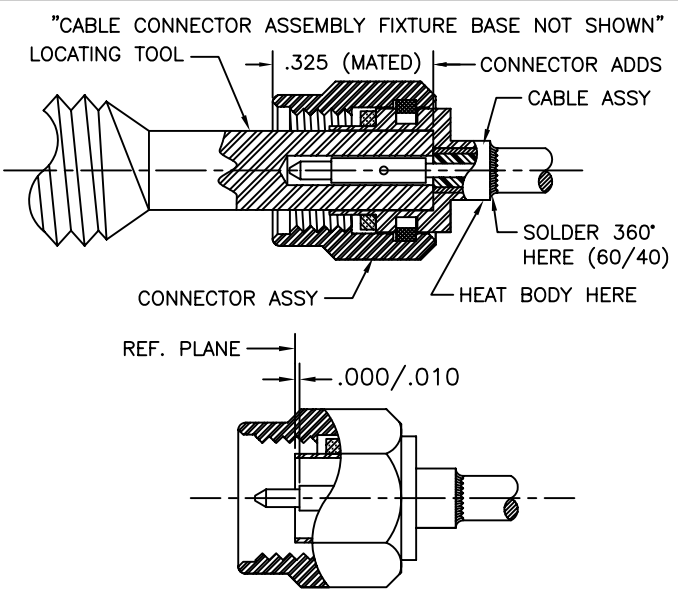
# SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



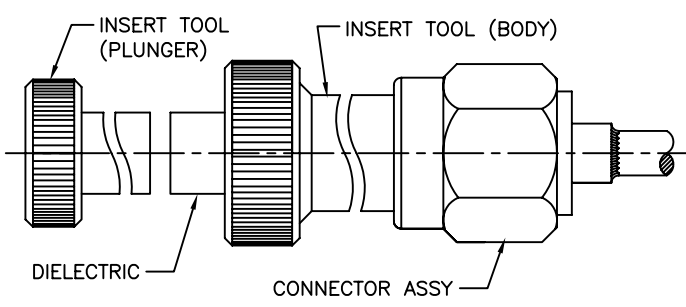
- 1.0 PREPARATION OF CABLE:**
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & INNER DIELECTRIC SHOULD BE 90° FROM CENTERLINE & FLUSH WITH EACH OTHER. CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
  - 1.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° 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 ASSY TO CONNECTOR ASSY:**
- 3.1 SLIDE CONNECTOR BODY ONTO CABLE SUB-ASSEMBLY.
  - 3.2 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
  - 3.3 THREAD LOCATING TOOL INTO FIXTURE BASE.
  - 3.4 TIGHTEN LOCATING TOOL INTO FIXTURE BASE UNTIL IT BOTTOMS COMPLETELY AGAINST SHOULDER OF CABLE. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT IS NOT DAMAGED"
  - 3.5 SLIDE BODY OVER CABLE SUB-ASSEMBLY UNTIL IT BOTTOMS AGAINST THE LOCATING TOOL.
  - 3.6 USING A RESISTIVE SOLDERING IRON, HEAT BODY (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.
  - 3.7 REMOVE LOCATING TOOL AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.
  - 3.8 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED.



- 4.0 INSERTION OF THE DIELECTRIC:**
- 4.1 THREAD INSERT TOOL INTO CONNECTOR ASSEMBLY.
  - 4.2 INSERT DIELECTRIC INTO INSERT TOOL BODY.
  - 4.3 PLACE PLUNGER INTO INSERT TOOL BODY AND PRESS UNTIL FLANGE BOTTOMS ON INSERT TOOL BODY.
  - 4.4 REMOVE INSERT TOOL FROM CONNECTOR ASSEMBLY.
  - 4.5 INSPECT DIELECTRIC FOR PROPER INSERTION.
- NOTE: DO NOT ALLOW SOLVENTS TO COME IN CONTACT WITH DIELECTRIC. THIS MAY DAMAGE DIELECTRIC AND EFFECT THE OVERALL PERFORMANCE OF CONNECTOR.

INTERFACE DIMINIONS LISTED BELOW:  
 PIN = .000/.010 (BELOW REF. PLANE)  
 DIELECTRIC = .000/.010 (BELOW REF. PLANE)

- 5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY:**
- 5.1 ADHERENCE TO STEPS PROVIDED WILL YIELD TOLERANCES SHOWN.

DWG NO. <b>200-50-10-850</b>	<b>SGMC MICROWAVE</b> <a href="http://www.sgmcmicrowave.com">www.sgmcmicrowave.com</a>	<b>TOOLS REQUIRED:</b> 1. RESISTANCE SOLDERING MACHINE. 2. FLUX, SOLDER POT, 60/40 SOLDER. 3. .015 SOLDER SHIM, RAZOR BLADES. 4. INTERFACE LOCATING TOOL. 5. DIELECTRIC INSERT TOOL. 6. SCOTCH BRITE. 7. CABLE CONNECTOR ASSEMBLY FIXTURE. 8. SOLVENT (ISOPROPYL ALCOHOL). <b>"PROPRIETARY INFORMATION"</b>
TITLE:  <b>SMA MALE TO .085 SEMI-RIGID CABLE (Direct Solder)</b>	SCALE: NTS    CAGE CODE: 1UYM4    SIZE: A SHEET: 1 OF 1    DRAWN: LRH II    APPR: REVISIONS LTR: DESCRIPTION: (ECN#)    DATE: - DWG. RELEASED    04/06/04	