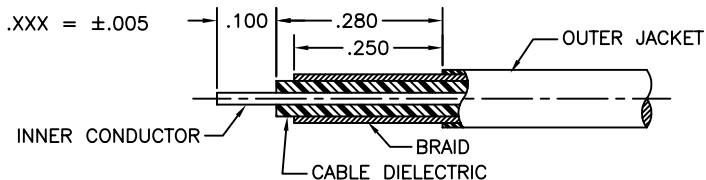
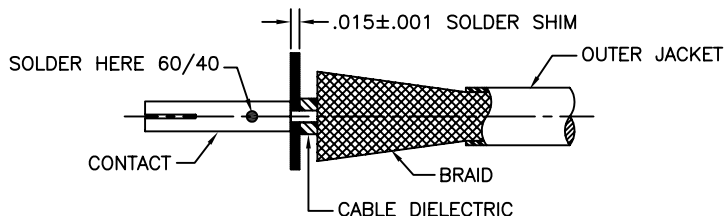
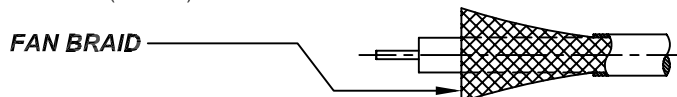


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



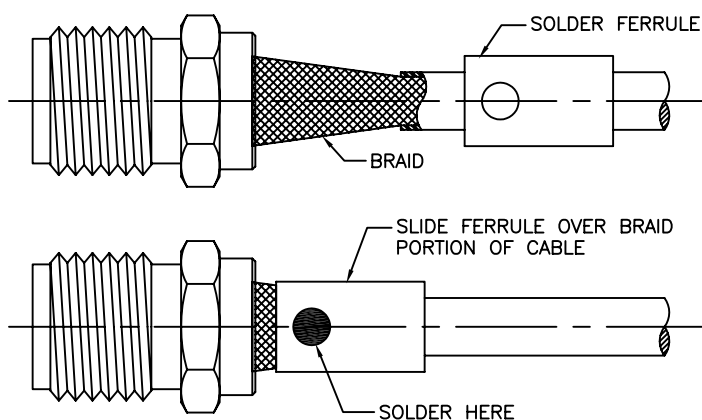
1.0 PREPARATION OF CABLE:

- 1.1 SLIDE FERRULE AND SHRINK TUBING ONTO CABLE.
- 1.2 TRIM CABLE TO DIMENSIONS SHOWN.
- 1.3 FAN (FLARE) BRAID BACK AS SHOWN BELOW.



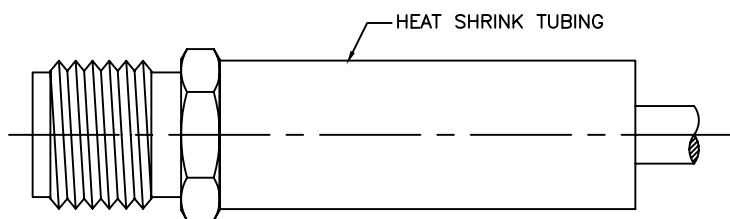
2.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

- 2.2 TIN INNER CONDUCTOR OF CABLE.
 - 2.3 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC & BRAID CLAMP.
 - 2.4 HEAT CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST SOLDER SHIM.
 - 2.5 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
 - 2.6 INSPECT CABLE SUB-ASSEMBLY AND REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT.
- USE MINIMAL HEAT TO MINIMIZE MELTING OF CABLE DIELECTRIC.**



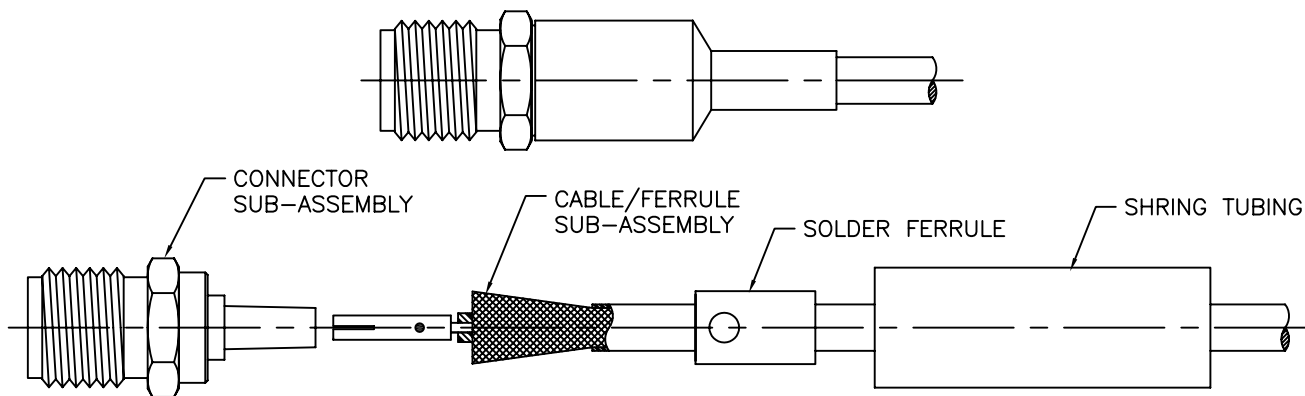
3.0 SOLDERING OF CABLE TO CONNECTOR BODY:

- 3.1 INSERT THE CABLE INTO BACK END OF CONNECTOR BODY UNTIL IT BOTTOMS AGAINST THE INSULATOR INSIDE THE BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR, DIELECTRIC, OR CENTER CONTACT OF CONNECTOR.
- 3.2 PLACE THE CABLE / CONNECTOR BODY INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
- 3.3 SLIDE THE SOLDER FERRULE OVER THE FANED (FLARED) PORTION OF THE CABLE BRAID AS SHOWN.
- 3.4 ONCE THE CABLE IS SECURED IN PLACE SOLDER THROUGH THE HOLES IN THE SOLDER FERRULE.



4.0 SHRINK HEAT SHRINK TUBING TO CABLE:

- 4.1 POSITION TUBING OVER OUTER SLEEVE AS SHOWN.
 - 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK IN PLACE.
 - 4.3 REMOVE FROM FIXTURE BASE / LOCATOR TOOL IF USED.
- INSPECT INTERFACE:**
 CONTACT: .000 (FLUSH) to -.010 (BELOW) REF. PLANE
 DIELECTRIC: .000 (FLUSH) to -.010 (BELOW) REF. PLANE



DWG NO. **200-51-10-160**

TITLE: **SMA FEMALE TO RG-316 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	01/18/06

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. .015 SOLDER SHIM, RAZOR BLADES.
4. SOLVENT (ISOPROPYL ALCOHOL).
5. LOCATOR TOOL (OPTIONAL).

"PROPRIETARY INFORMATION"