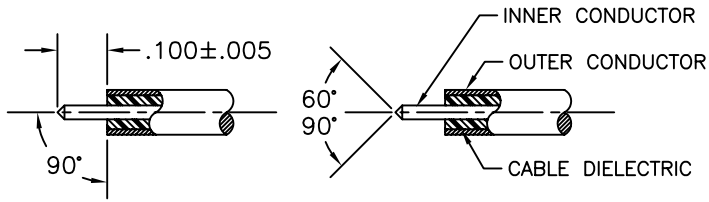
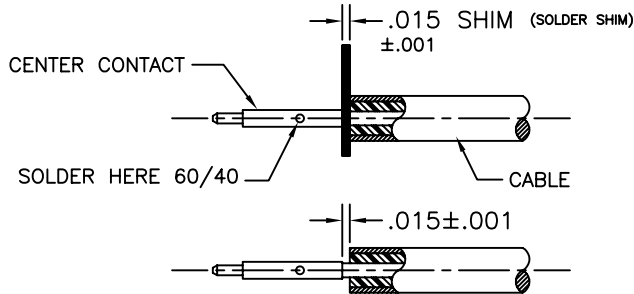


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



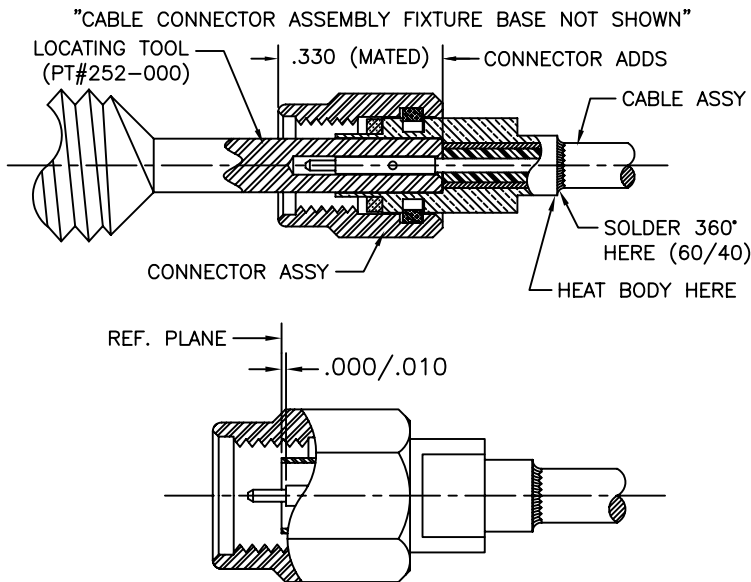
1.0 PREPARATION OF CABLE:

- 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.



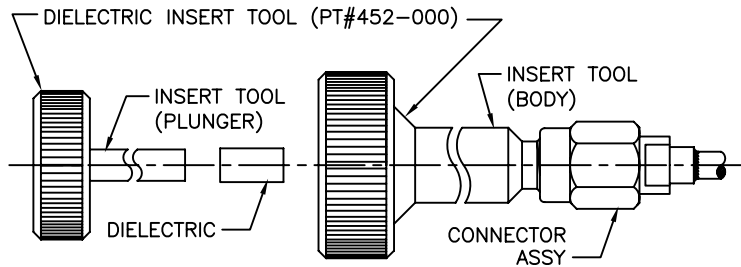
2.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

- 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 (SGMc PT#252-000) 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 (SGMc PT#452-000) 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 DIMENSIONS 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.

"PROPRIETARY INFORMATION"

DWG NO.

200-52-10-851

SGMC MICROWAVE
www.sgmcmicrowave.com

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. .015 SOLDER SHIM, RAZOR BLADES.
4. INTERFACE LOCATING TOOL (PT#252-000).
5. DIELECTRIC INSERT TOOL (PT#452-000).
5. SCOTCH BRITE.
6. CABLE CONNECTOR ASSEMBLY FIXTURE.
7. SOLVENT (ISOPROPYL ALCOHOL).

TITLE:

SSMA MALE TO
.085 SEMI-RIGID
CABLE (Direct Solder)

SCALE: NTS CAGE CODE: 1UYM4 SIZE: A

SHEET: 1 OF 1 DRAWN: LRH II APPR:

REVISIONS

| LTR: | DESCRIPTION: (ECN#) | DATE: |
|------|---------------------|----------|
| -- | DWG. RELEASED | 11/04/03 |