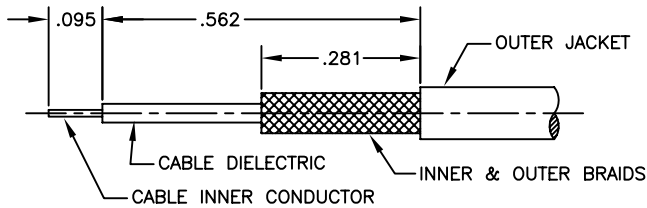


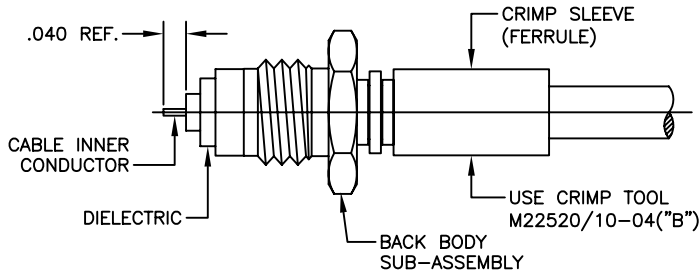
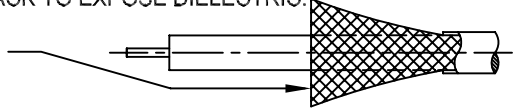
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



1.0 PREPARATION OF CABLE:

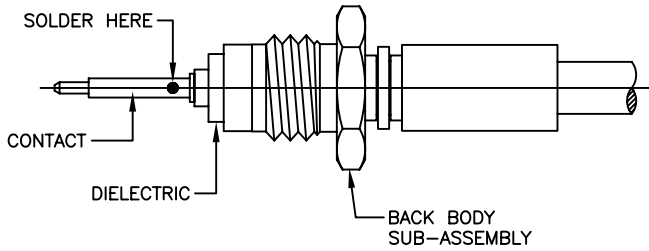
- 1.1 SLIDE CRIMP SLEEVE (FERRULE) AND SHRINK TUBE ONTO CABLE.
- 1.2 TRIM CABLE TO DIMENSIONS SHOWN.
- 1.3 FLARE BRAIDS BACK TO EXPOSE DIELECTRIC.

FLARE BRAID



2.0 CRIMP CABLE TO BACK BODY SUB-ASSEMBLY:

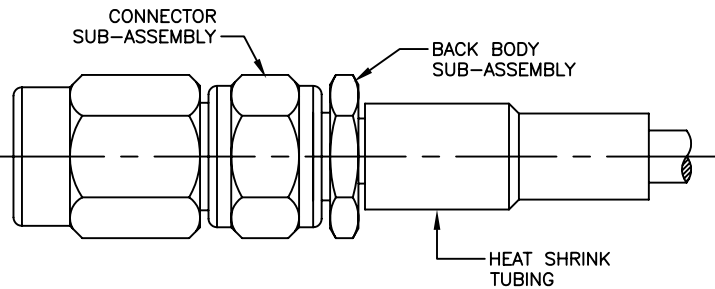
- 2.1 TIN INNER CONDUCTOR OF CABLE.
- 2.2 POSITION AND SECURE BACK BODY SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 2.3 INSERT CABLE INTO BACK BODY SUB-ASSEMBLY AND SEAT FIRMLY. INSPECT INNER CONDUCTOR DIMENSION. (.040" REF.)
- 2.4 SLIDE CRIMP SLEEVE (FERRULE) OVER FLARED PORTION OF INNER & OUTER BRAIDS.
- 2.5 HOLD CABLE FIRMLY SEATED AND CRIMP SLEEVE (FERRULE) IN PLACE.
- 2.6 TRIM ANY EXCESS BRAID AWAY IF NECESSARY.



3.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

- 2.2 HEAT CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH THE LARGE DIAMETER OF CONTACT RESTING FIRMLY AGAINST DIELECTRIC (BACK BODY SUB-ASSEMBLY).
- 2.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
- 2.4 INSPECT CABLE SUB-ASSEMBLY AND REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT.

USE MINIMAL HEAT TO MINIMIZE MELTING OF DIELECTRIC.



4.0 INSERT CABLE SUB-ASSEMBLY INTO CONNECTOR BODY:

- 4.1 SLIDE FORWARD DIELECTRIC OVER CENTER CONTACT.
- 4.2 LOCTITE (IF REQUIRED) AND ENGAGE THREADS OF BACK BODY SUB-ASSEMBLY INTO CONNECTOR BODY AND TORQUE TO 25-30 INCH POUNDS.

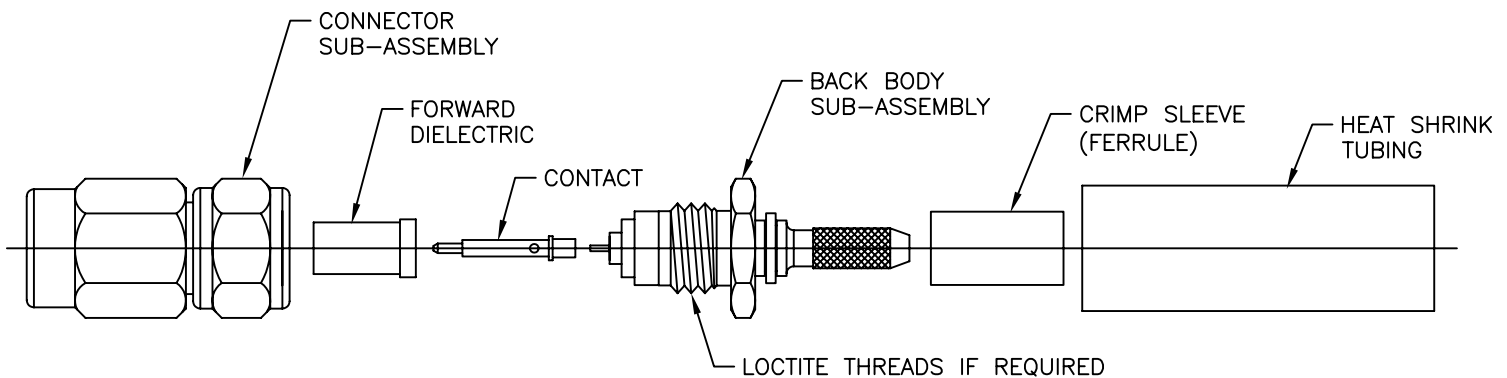
5.0 SHRINK HEAT SHRINK TUBING TO CABLE:

- 5.1 POSITION TUBING OVER OUTER SLEEVE AS SHOWN.
- 5.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK IN PLACE.

"INSPECT INTERFACE"

STANDARD SSMA INTERFACE DIMENSIONS ARE:
.000/- .010 CONTACT & DIELECTRIC.

6.0 CONNECTOR LAYOUT:



DWG NO.

200-52-50-780

TITLE:

SSMA MALE
TO RD-178 CABLE
CRIMP ATTACHMENT

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	03/25/05

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES.
4. SOLVENT (ISOPROPYL ALCOHOL).
5. M22520/10-04 "B" CRIMP TOOL.

"PROPRIETARY INFORMATION"