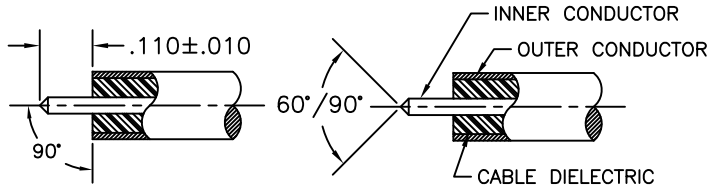
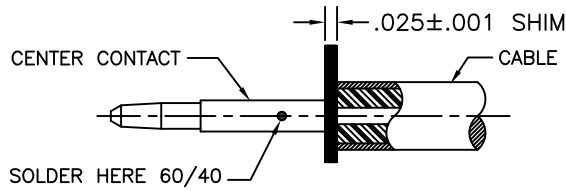


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



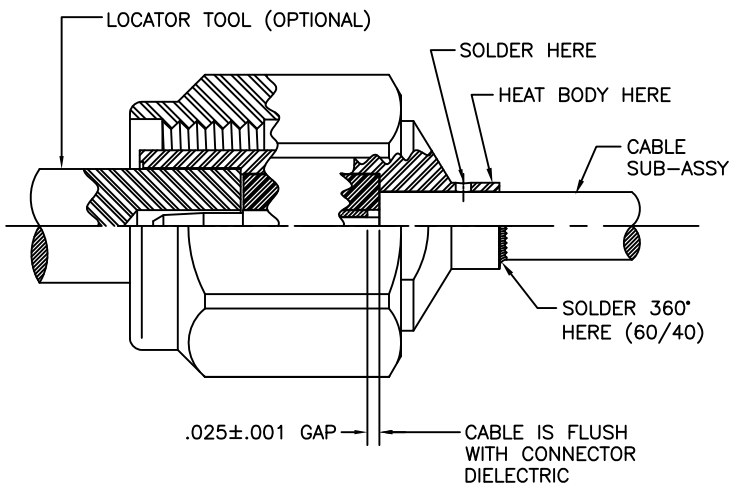
1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & INNER DIELECTRIC SHOULD BE 90° FROM CENTERLINE & FLUSH WITH EACHOTHER. 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:

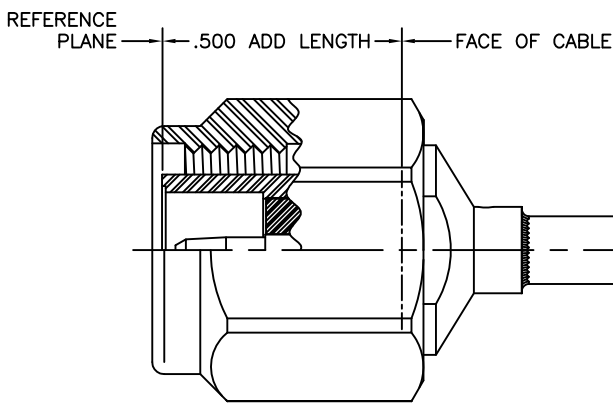
- 2.1 DIP PREPARED END OF CABLE INTO FLUX, THEN INTO SOLDER POT APPROX 1/2" to 3/8" FORMING A THIN COAT OF TIN ON OUTER & INNER CONDUCTOR. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT
- 2.2 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC.
- 2.3 HEAT CENTER CONTACT & PUSH IT OVER INNER CABLE CONDUCTOR TO REST FIRMLY AGAINST SHIM.
- 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 BODY:

- 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 (OPTIONAL).
- 3.4 TIGHTEN LOCATING TOOL. INTO FIXTURE BASE TO SEAT CABLE FIRMLY AGAINST CONNECTOR DIELECTRIC. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT & OR DIELECTRIC IS NOT DAMAGED"
- 3.5 USING A RESISTIVE SOLDERING IRON, HEAT BODY (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.
- 3.6 REMOVE LOCATING TOOL AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.

NOTE: EXCESSIVE HEAT CAUSES DIELECTRIC (TEFLON) TO SHRINK BELOW ACCEPTABLE LEVELS. HEAT SOLDER ONLY UNTIL IT STARTS TO FLOW.



4.0 INSPECT COMPLETED CONNECTOR ASSEMBLY:

- 4.1 FOLLOWING THE ASSEMBLY PROCEDURES IN THIS INSTRUCTION SHEET SHOULD YIELD TOLERANCES SHOWN.

DWG NO.

200-60-10-415

SGMC MICROWAVE
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TOOLS REQUIRED:

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

TITLE:

TNCA MALE TO
.141 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	12/12/12

"PROPRIETARY INFORMATION"