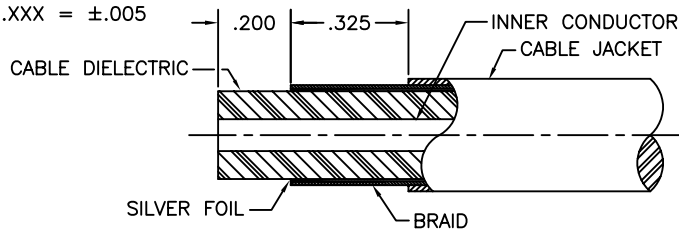


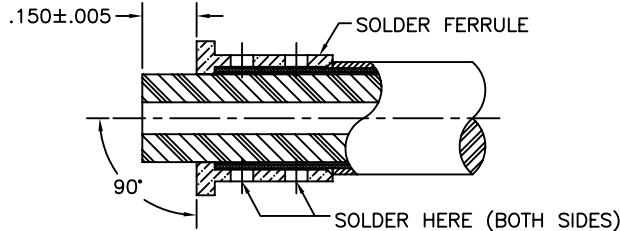
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

.XXX = ±.005



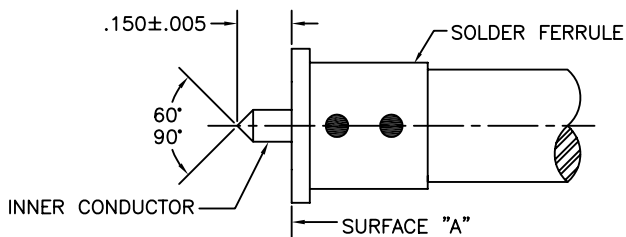
1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER JACKET, INNER CONDUCTOR, & INNER BRAIDS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL OR INNER BRAID DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



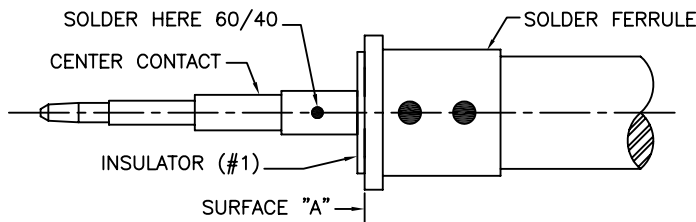
2.0 SOLDERING OF FERRULE TO CABLE OUTER CONDUCTOR:

- 2.1 SLIDE CLAMP NUT ONTO CABLE AS SHOWN BELOW IN STEP 5.0 (ENLARGED VIEW).
- 2.2 TIN INNER BRAIDS OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (CABLE JACKET).
- 2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).
- 2.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.



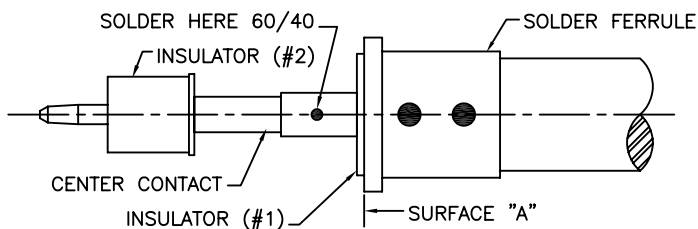
3.0 PREPARATION OF CABLE INNER CONDUCTOR:

- 3.1 TRIM DIELECTRIC FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



4.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

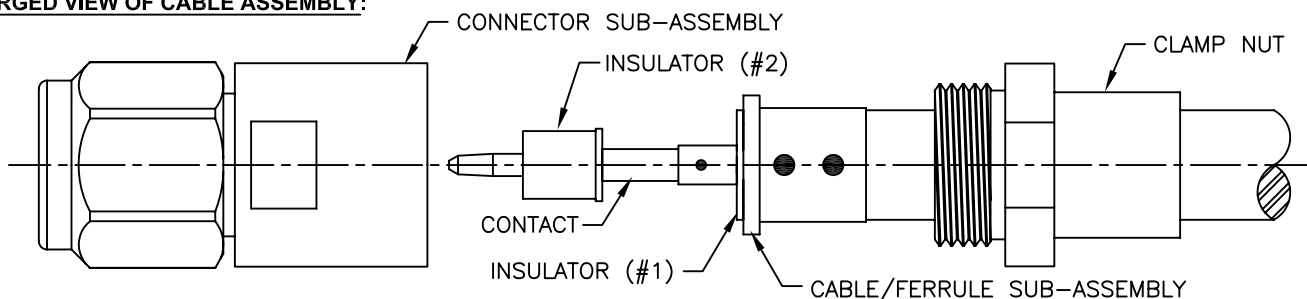
- 4.1 SLIDE INSULATOR (#1) OVER CENTER CONDUCTOR OF CABLE UNTIL IT REST FIRMLY AGAINST SURFACE "A" (FERRULE).
- 4.2 TIN INNER CONDUCTOR OF CABLE. HEAT CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST AGAINST INSULATOR (#1).
- 4.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
- 4.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.



5.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:

- 5.1 SLIDE INSULATOR (#2) ONTO CONTACT AS SHOWN.
- 5.2 PLACE CABLE / FERRULE SUB-ASSEMBLY INTO THE BACK OF CONNECTOR SUB-ASSEMBLY BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR OR INSULATOR OF CONNECTOR.
- 5.3 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS. INSPECT INTERFACE DIMENSIONS.

5.0 ENLARGED VIEW OF CABLE ASSEMBLY:



DWG NO.

200-60-20-800

SGMC MICROWAVE
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TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES.
4. SOLVENT (ISOPROPYL ALCOHOL).

TITLE:

**TNCA MALE TO
IW2801 CABLE
(Solder Clamp)**

SCALE: NTS	CAGE CODE: 1UYM4	SIZE: A
SHEET: 1 OF 1	DRAWN: LRH II	APPR:
REVISIONS		
LTR: DESCRIPTION: (ECN#)	DATE:	
-- DWG. RELEASED	05/11/11	

"PROPRIETARY INFORMATION"