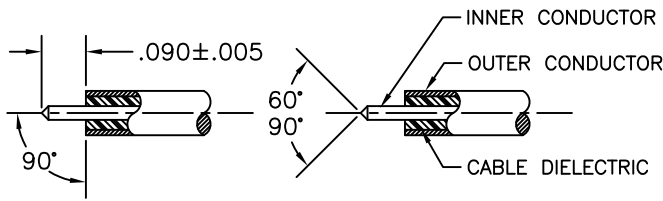
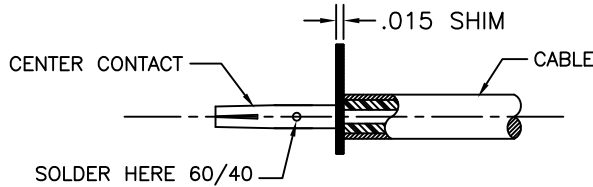


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



1.0 PREPARATION OF CABLE:

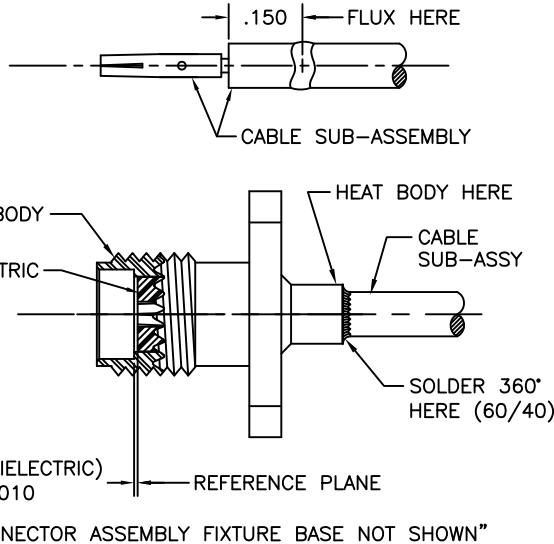
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & INNER DIELECTRIC SHOULD BE 90° FROM CENTERLINE & FLUSH WITH EACHOTHER. CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 1.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 1.3 INSPECT CABLE PREPARATION. 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" 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.
- 2.6 ALLOW CABLE SUB-ASSEMBLY TO COOL BEFORE PROCEEDING TO STEP 3.0.

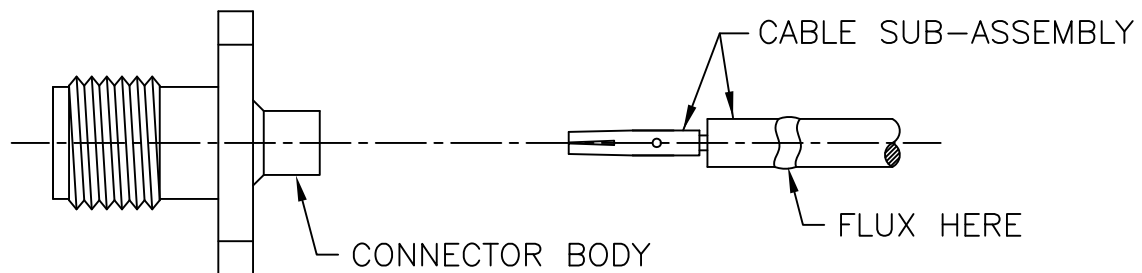
NOTE: EXCESSIVE HEAT CAUSES DIELECTRIC (TEFLON) TO SHRINK BELOW ACCEPTABLE LEVELS. HEAT ONLY UNTIL IT STARTS TO FLOW.



3.0 SOLDERING OF CABLE SUB-ASSY TO CONNECTOR BODY:

- 3.1 APPLY A SMALL AMOUNT OF FLUX APPROXIMATELY .150 INCHES FROM SHOULDER OF OUTER CONDUCTOR.
- 3.2 SLIDE CONNECTOR BODY ONTO CABLE SUB-ASSEMBLY UNTIL THE CONTACT SNAPS INTO DIELECTRIC AND REST FIRMLY ON SHOULDER OF CONTACT AS SHOWN. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT AND/OR DIELECTRIC ARE NOT DAMAGED"
- 3.3 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
- 3.4 USING A RESISTIVE SOLDERING IRON, HEAT HOUSING (HOLDING DOWNWARD) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND CONNECTOR BODY.
- 3.5 REMOVE CABLE ASSEMBLY AND CLEAN SOLDER JOINT WITH SOLVENT (ALCOHOL) AND VERIFY THAT SOLDER IS FREE OF VOIDS.
- 3.6 INSPECT CENTER CONTACT & DIELECTRIC LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH DIMENSIONS PROVIDED. (.000/- .010)
- 3.7 ASSEMBLY IS NOW COMPLETE.

4.0 ENLARGED VIEW OF CABLE ASSEMBLY:



DWG NO. **211-51-10-850**

TITLE:
**SMA FEMALE (4) HOLE FLANGE
TO .085 SEMI-RIGID 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	01/30/14

TOOLS REQUIRED:

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

"PROPRIETARY INFORMATION"