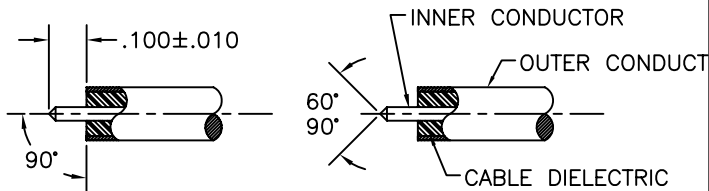
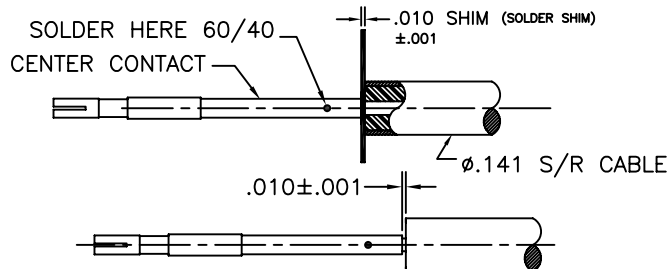


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



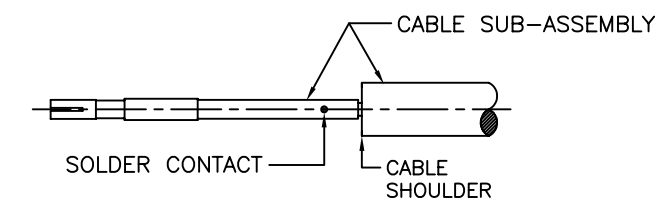
1.0 PREPARATION OF CABLE:

- 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.

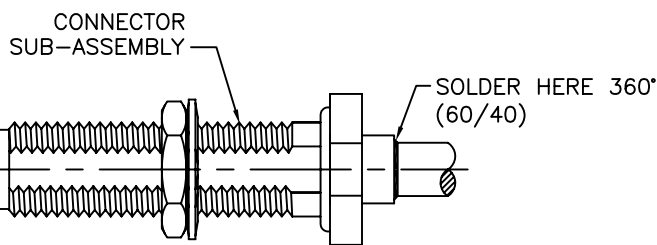


3.0 SOLDERING OF CABLE SUB-ASSY TO CONNECTOR SUB-ASSY:

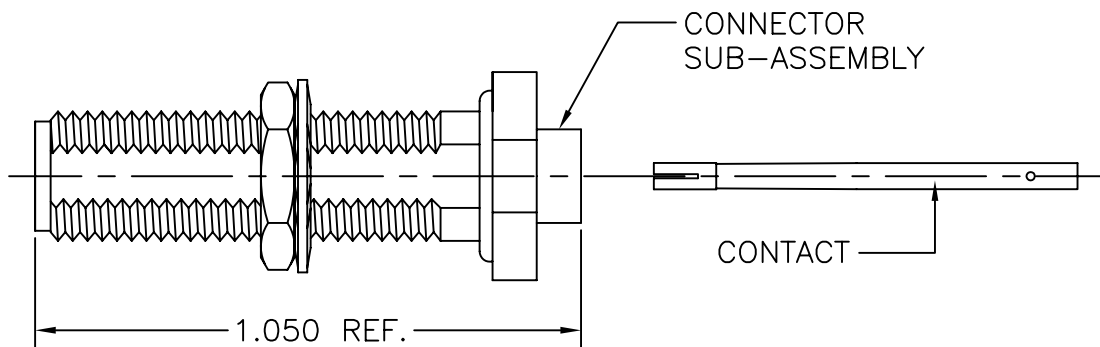
- 3.1 SLIDE INSULATOR ONTO CONTACT AS SHOWN.
- 3.2 SLIDE CABLE SUB-ASSEMBLY INTO CONNECTOR SUB-ASSEMBLY UNTIL THE SHOULDER OF THE CABLE BOTTOMS COMPLETELY AGAINST THE CABLE STOP LOCATED INSIDE THE CONNECTOR BODY.
- 3.3 PLACE CABLE INTO FIXTURE BASE AND SECURE TO PREVENT MOVEMENT WHILE SOLDERING.
- 3.4 USING A RESISTIVE SOLDERING IRON, HEAT BODY (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.

INSPECT INTERFACE DIMENSION:

CONTACT = .000/- .010 (FLUSH TO BELOW REF. PLANE)
 DIELECTRIC = .000/- .010 (FLUSH TO BELOW REF. PLANE)



5.0 CONNECTOR LAYOUT:



DWG NO.

215-51-10-411

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. SCOTCH BRITE.
5. CABLE CONNECTOR ASSEMBLY FIXTURE.
6. SOLVENT (ISOPROPYL ALCOHOL).

TITLE:

SMA FEMALE BULKHEAD
 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	01/04/07

"PROPRIETARY INFORMATION"