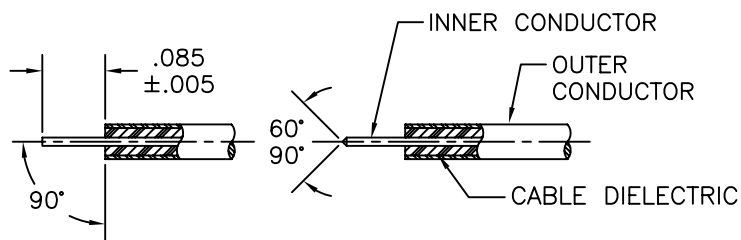
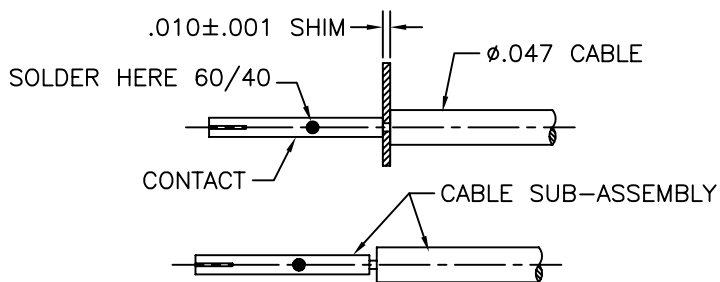


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



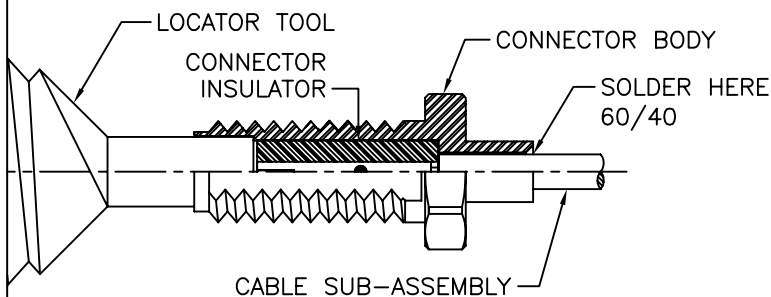
1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER CONDUCTOR & DIELECTRIC SHOULD BE 90° FROM CENTERLINE OF CABLE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC OR INNER CONDUCTOR DURING THIS OPERATION.
- 1.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 1.3 INSPECT CABLE PREPARATION FOR DISTORTION OR JAGGED EDGES. REMOVE BURRS & SHARP EDGES FROM OUTER CONDUCTOR WITH SCOTCH BRITE. CARE SHOULD BE TAKEN TO AVOID DAMAGING OR DISTORTING CABLE DIELECTRIC.



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 & OUTER CONDUCTOR.
- 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-ASSEMBLY. REMOVE EXCESS SOLDER & CLEAN WITH SOLVENT.



NOTE: THE PURPOSE OF THE LOCATOR TOOL IS TO SEAT THE CABLE FIRMLY INTERNALLY AND TO PREVENT THE INSULATOR AND/OR CONTACT FROM BEING PUSHED ABOVE THE REFERENCE PLANE DURING THE ASSEMBLY PROCESS.

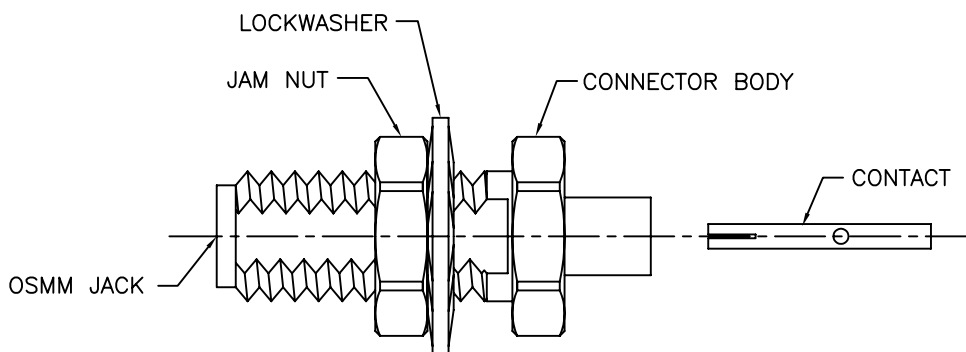
3.0 SOLDERING OF CABLE SUB-ASSY TO CONNECTOR BODY:

- 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.
- 3.4 TIGHTEN LOCATING TOOL TO SEAT CABLE FIRMLY. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT IS NOT DAMAGED"
- 3.5 USING A RESISTIVE SOLDERING IRON, HEAT HOUSING (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.

INSPECT INTERFACE:

CONTACT: .000 (FLUSH) to -.010 (BELOW) REF. PLANE
DIELECTRIC: .000 (FLUSH) to -.010 (BELOW) REF. PLANE

4.0 CONNECTOR LAYOUT:



DWG NO.

215-57-10-470

TITLE:

OSMM FEMALE BULKHEAD
TO .047 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	03/28/05

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES.
4. SCOTCH BRITE.
5. SOLVENT (ISOPROPYL ALCOHOL).
6. LOCATOR TOOL.
7. FIXTURE BASE.

"PROPRIETARY INFORMATION"