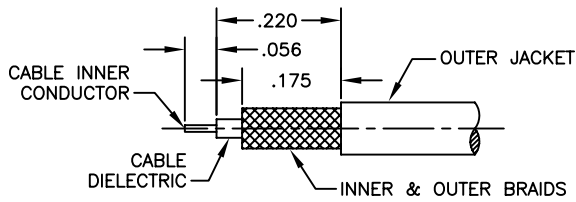


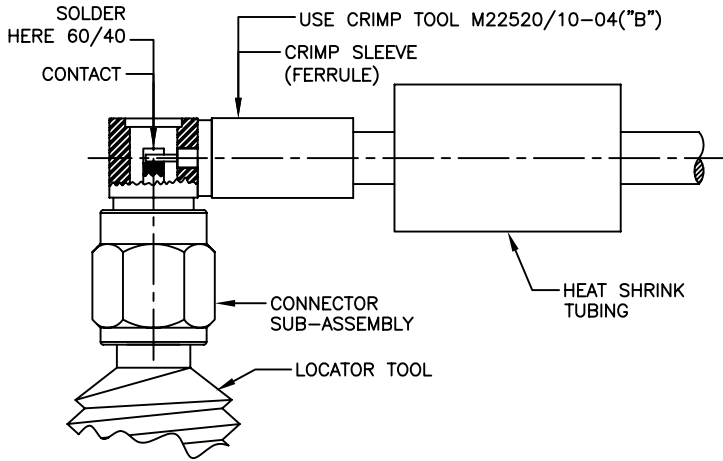
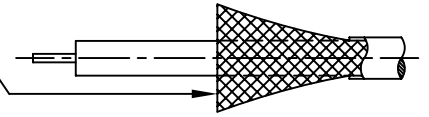
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



1.0 PREPARATION OF CABLE:

- 1.1 SLIDE CRIMP SLEEVE (FERRULE) AND SHRINK TUBE ONTO CABLE.
- 1.2 TRIM CABLE TO DIMENSIONS SHOWN.
- 1.3 FLARE BRAIDS BACK TO EXPOSE DIELECTRIC.

FLARE BRAID



2.0 SOLDERING OF CABLE INNER CONDUCTOR TO SUB-ASSEMBLY:

- 2.1 SECURE LOCATOR TOOL TO THREADS OF CONNECTOR SUB-ASSY.
- 2.2 POSITION AND SECURE CONNECTOR SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 2.3 TIN INNER CONDUCTOR OF CABLE.
- 2.4 INSERT CABLE INTO CONNECTOR SUB-ASSEMBLY.
- 2.5 NEST INNER CONDUCTOR IN CONTACT SLOT AS SHOWN.
- 2.6 HOLD DIELECTRIC FLUSH WITH I.D. OF BODY AS SHOWN.
- 2.7 PLACE SOLDERING IRON ON TIP OF CONTACT AND SOLDER.

3.0 CRIMP CABLE TO CONNECTOR SUB-ASSEMBLY:

- 3.1 SLIDE CRIMP SLEEVE (FERRULE) OVER FLARED PORTION OF INNER & OUTER BRAIDS.
- 3.2 HOLD CABLE FIRMLY SEATED AND CRIMP SLEEVE (FERRULE) IN PLACE.
- 3.3 TRIM ANY EXCESS BRAID AWAY IF NECESSARY.

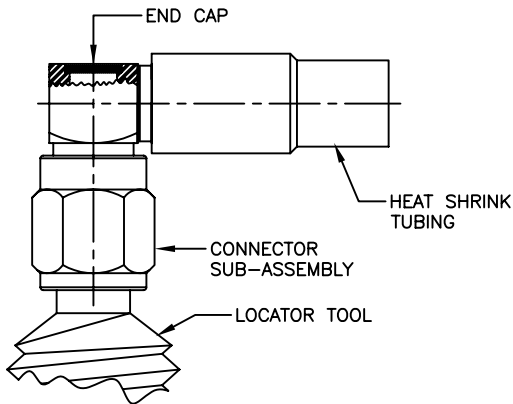
4.0 SEAL OPENING IN CONNECTOR SUB-ASSEMBLY:

4.1 OPTION #1: "SOLDER END CAP"

TIN PERIMETER OF OPENING AND PRESS END CAP INTO POSITION. APPLY HEAT TO CAP. DO NOT ALLOW SOLDER TO PENETRATE INSIDE CONNECTOR.

4.2 OPTION #2: "EPOXY END CAP"

END CAP MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE CONNECTOR.



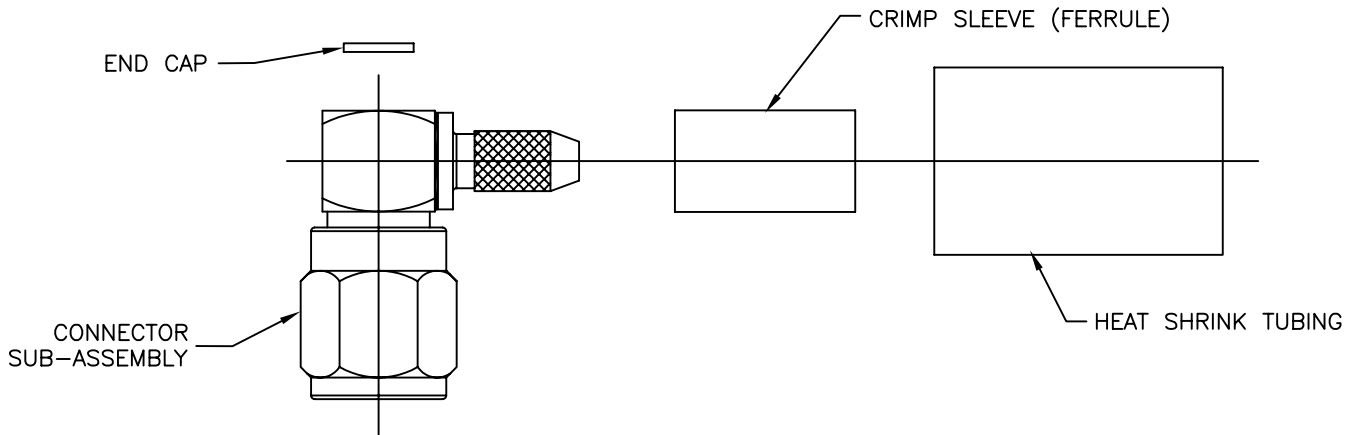
5.0 SHRINK HEAT SHRINK TUBING TO CABLE:

- 5.1 POSITION TUBING OVER OUTER SLEEVE AS SHOWN.
- 5.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK IN PLACE.
- 5.3 REMOVE LOCATOR.

INSPECT INTERFACE:

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

6.0 CONNECTOR LAYOUT:



DWG NO.

230-56-50-780

SGMC MICROWAVE
www.sgmcmicrowave.com

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES.
4. SOLVENT (ISOPROPYL ALCOHOL).
5. M22520/10-04 "B" CRIMP TOOL.
6. LOCATOR TOOL.

TITLE:

OSMM MALE R/A
TO RD-178 CABLE
CRIMP ATTACHMENT

SCALE: NTS	CAGE CODE: 1UYM4	SIZE: A
SHEET: 1 OF 1	DRAWN: LRH II	APPR:
REVISIONS		
LTR:	DESCRIPTION: (ECN#)	DATE:
--	DWG. RELEASED	03/30/05

"PROPRIETARY INFORMATION"