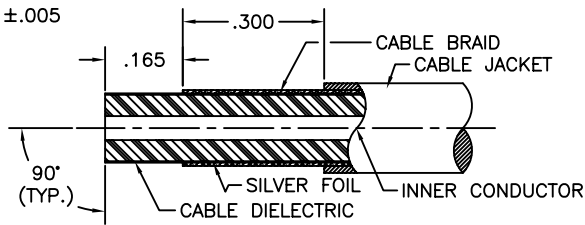


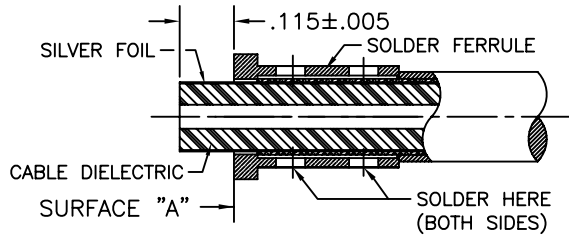
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

.XXX = ±.005



1.0 PREPARATION OF CABLE:

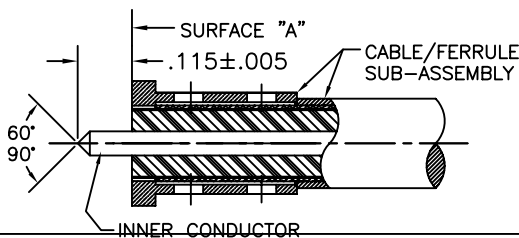
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL OR INNER BRAID DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



NOTE: DIELECTRIC & FOIL SHALL PROTRUDE PAST SURFACE "A" & REVEAL DIM'S SHOWN ABOVE. CARE SHOULD BE TAKEN NOT TO NICK OR TEAR FOIL OR DIELECTRIC DURING THIS OPERATION.

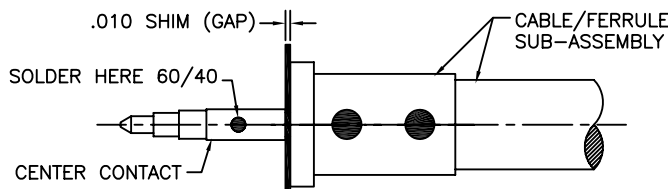
2.0 SOLDERING OF FERRULE TO INNER BRAID OF CABLE:

- 2.1 SLIDE CLAMP NUT WITH "O" RING ONTO CABLE AS SHOWN BELOW IN STEP 5.0.
- 2.2 TIN INNER BRAID 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 AND CLEAN WITH SOLVENT (ALCOHOL).



3.0 PREPARATION OF CABLE INNER CONDUCTOR:

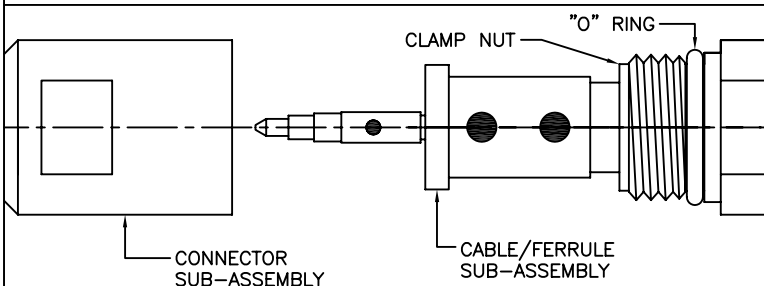
- 3.1 TRIM CABLE DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



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

4.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

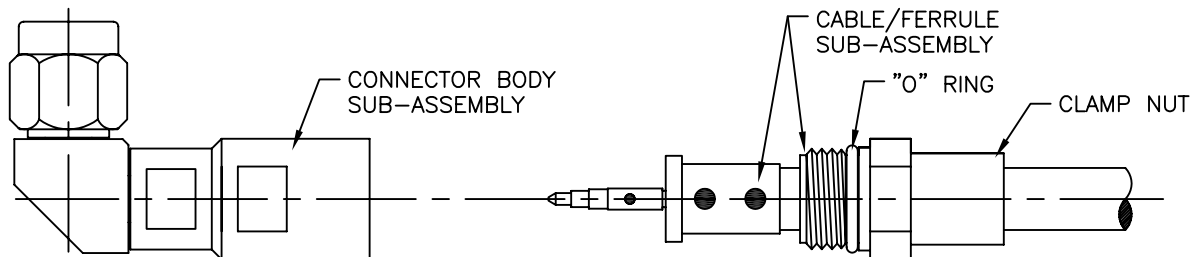
- 4.1 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST SOLDER FERRULE.
- 4.2 TIN INNER CONDUCTOR OF CABLE. HEAT CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST SHIM.
- 4.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
- 4.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.



5.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:

- 5.1 PLACE CABLE / FERRULE SUB-ASSEMBLY INTO THE BACK OF THE CONNECTOR SUB-ASSEMBLY BODY. THE CENTER CONTACT SHALL MATE WITH THE CENTER CONDUCTOR LOCATED INSIDE THE CONNECTOR SUB-ASSEMBLY. CARE SHOULD BE TAKEN DURING THIS STEP TO INSURE THE INNER CONDUCTOR IS NOT BENT OR DAMAGED.
- 5.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS.

4.0 ENLARGED VIEW OF CABLE ASSEMBLY:



DWG NO.

231-34-20-810

SGMC MICROWAVE
www.sgmcmicrowave.com

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES & SCOTCH BRITE.
4. SOLVENT (ISOPROPYL ALCOHOL).
5. INTERFACE MATING TOOL (PT#234-000).
6. CABLE CONNECTOR ASSEMBLY FIXTURE.

TITLE:

**2.92mm MALE R/A TO
I.W. 1801 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	07/15/10

"PROPRIETARY INFORMATION"