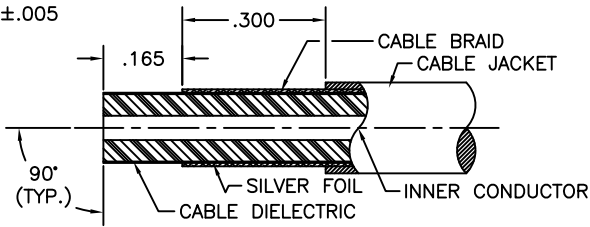


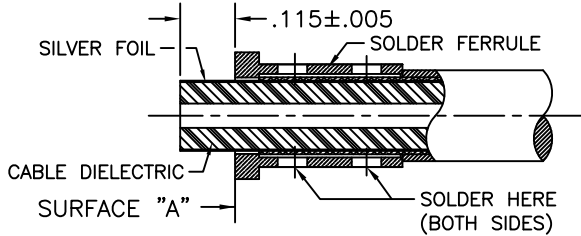
SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS

.XXX = ±.005



1.0 PREPARATION OF CABLE:

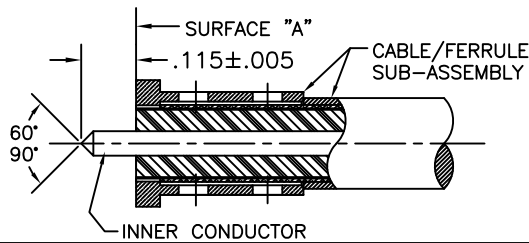
- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. ALL CUTS MADE TO CABLE LAYERS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, SILVER FOIL OR INNER BRAID DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



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.

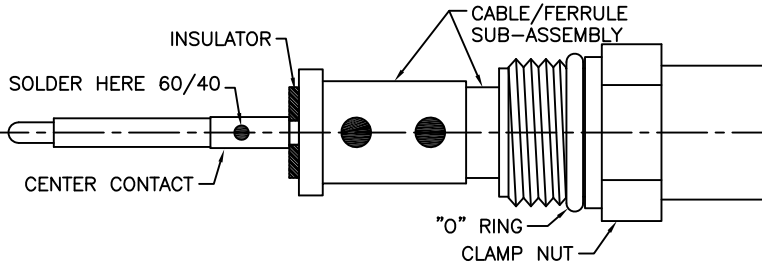
2.0 SOLDERING OF FERRULE TO INNER BRAID OF CABLE:

- 2.1 SLIDE CLAMP NUT WITH "O" RING ONTO CABLE AS SHOWN BELOW IN STEP 4.0.
- 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:

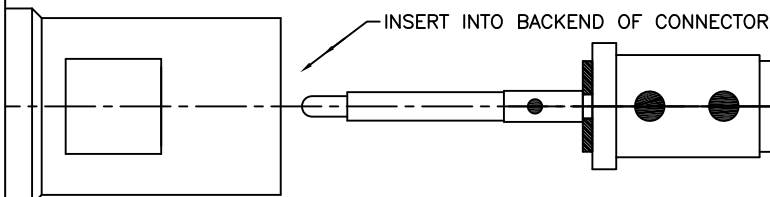
- 3.1 TRIM CABLE DIELECTRIC & FOIL FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



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

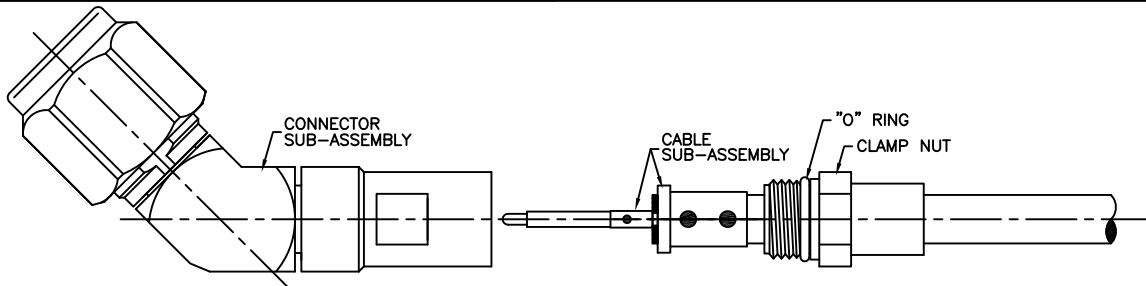
4.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:

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



5.0 INSTALLATION OF CABLE SUB-ASSEMBLY:

- 5.1 INSERT SUB-ASSEMBLY ONTO BACKEND OF CONNECTOR SUB-ASSEMBLY AS SHOWN. "CARE SHOULD BE TAKEN DURING THIS PROCESS TO INSURE THAT THE CONTACT AND/OR DIELECTRIC BEAD SUPPORT ARE NOT DAMAGED."
- 5.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS.



DWG NO.

245-60-20-810

TITLE:

TNCA MALE TO IW1801
CABLE (SOLDER CLAMP)
45 DEG ANGLE

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	12/10/13

TOOLS REQUIRED:

1. RESISTANCE SOLDERING MACHINE.
2. FLUX, SOLDER POT, 60/40 SOLDER.
3. RAZOR BLADES & SCOTCH BRITE.
4. SOLVENT (ISOPROPYL ALCOHOL).

"PROPRIETARY INFORMATION"