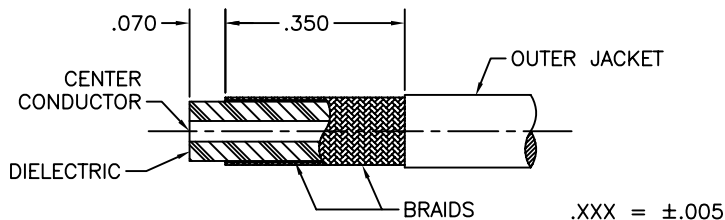
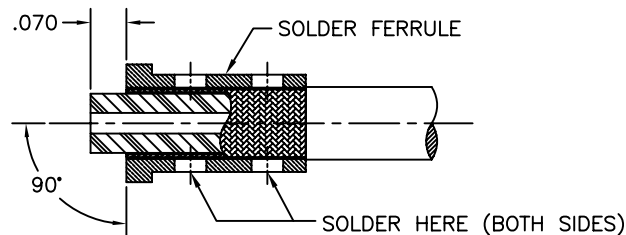


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



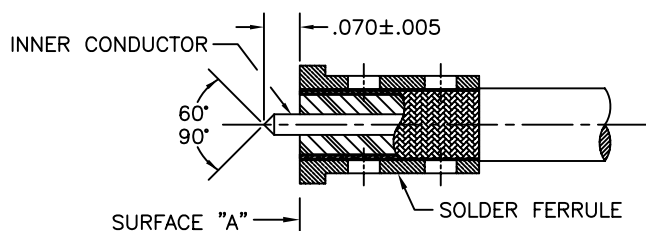
1.0 PREPARATION OF CABLE:

- 1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER JACKET, INNER CONDUCTOR, & INNER BRAIDS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, OR INNER BRAIDS DURING THIS OPERATION.
- 1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.



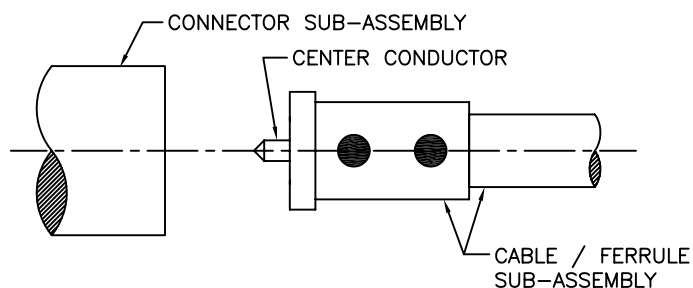
2.0 SOLDERING OF FERRULE TO CABLE OUTER CONDUCTOR:

- 2.1 SLIDE CLAMP NUT WITH "O" RING ONTO CABLE AS SHOWN BELOW IN STEP 5.0 (ENLARGED VIEW).
- 2.2 TIN INNER BRAIDS OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (OUTER JACKET).
- 2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).
- 2.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.



3.0 PREPARATION OF CABLE INNER CONDUCTOR:

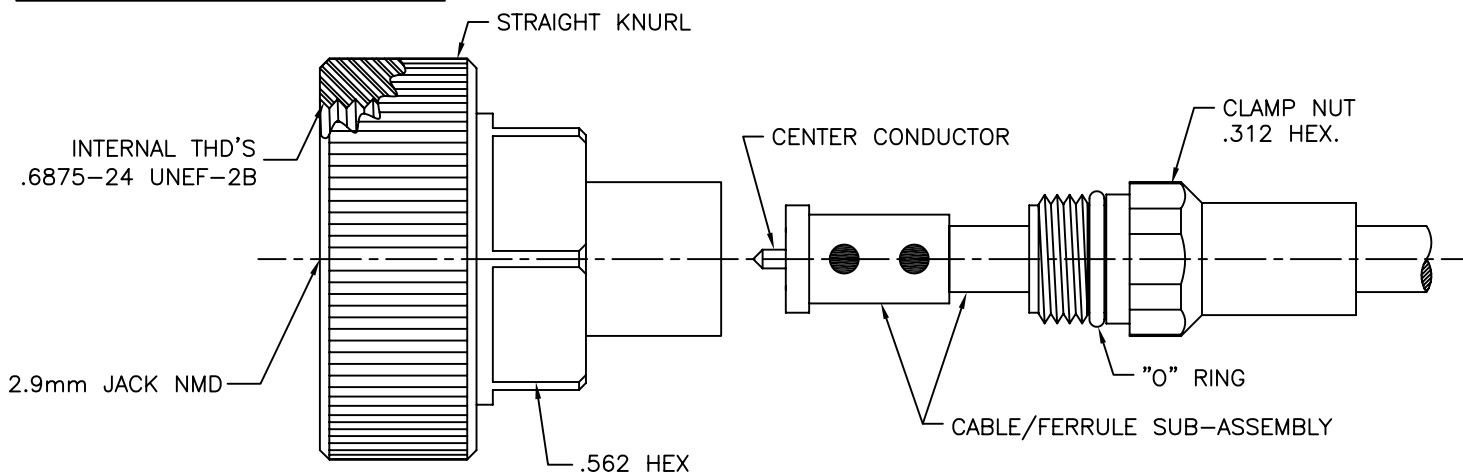
- 3.1 TRIM DIELECTRIC FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
- 3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
- 3.3 INSPECT CABLE PREPARATION.



4.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:

- 4.1 MATE THE CABLE / FERRULE SUB-ASSEMBLY WITH THE BACK OF THE CONNECTOR SUB-ASSEMBLY BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR OF CABLE OR INNER CONDUCTOR (CONTACT) OF CONNECTOR.
- 4.3 SLIDE THE CLAMP NUT OVER CABLE & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS.

5.0 ENLARGED VIEW OF CABLE ASSEMBLY:



DWG NO. **290-35-20-040**

TITLE:
2.9mm FEMALE NMD TO ALPEN A40UFP CABLE SOLDER CLAMP (Ø.1417)

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 | 05/03/04 |

TOOLS REQUIRED:

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

"PROPRIETARY INFORMATION"