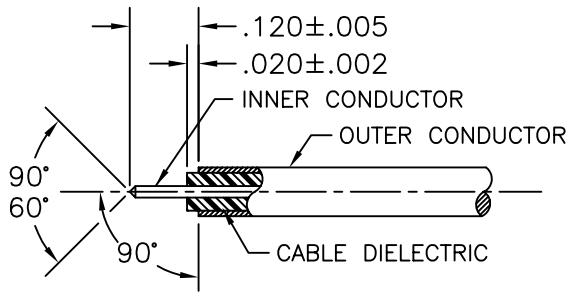
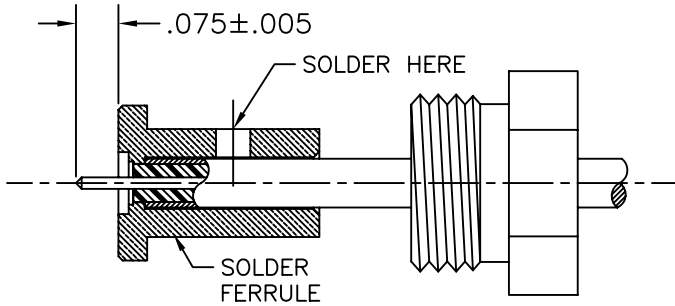


SGMC MICROWAVE CABLE ASSEMBLY INSTRUCTIONS



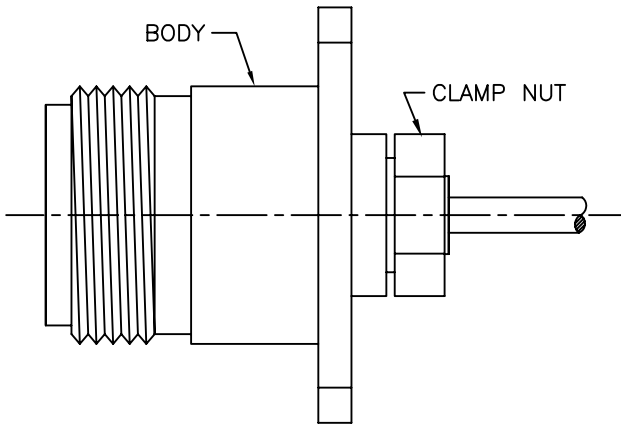
1.0 PREPARATION OF CABLE:

- 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 FERRULE TO CABLE OUTER CONDUCTOR:

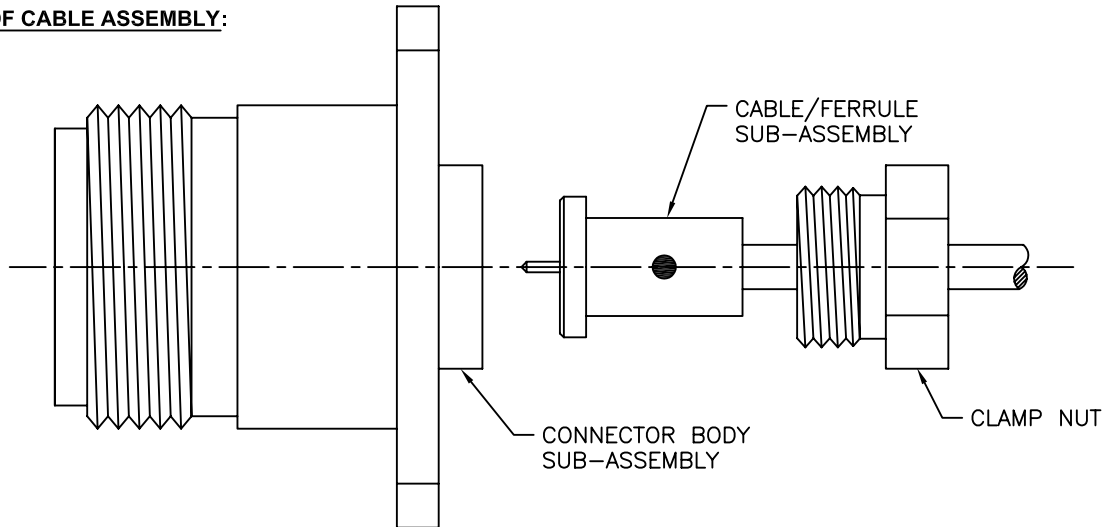
- 2.1 SLIDE CLAMP NUT ON CABLE AS SHOWN.
- 2.2 TIN OUTER CONDUCTOR OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (OUTER CONDUCTOR).
- 2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER.
- 2.4 INSPECT & REMOVE EXCESS SOLDER AND CLEAN WITH SOLVENT (ALCOHOL).



3.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:

- 3.1 PLACE CABLE / FERRULE SUB-ASSEMBLY INTO THE BACK OF CONNECTOR SUB-ASSEMBLY BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR OR CENTER CONTACT OF CONNECTOR.
- 3.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15-30 INCH-POUNDS.

3.0 ENLARGED VIEW OF CABLE ASSEMBLY:



DWG NO.

211-21-20-850

SGMC MICROWAVE
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TOOLS REQUIRED:

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

TITLE:

N FEMALE (4) HOLE FLANGE
TO .085 SEMI-RIGID
CABLE (Direct Solder)

SCALE: NTS CAGE CODE: 1UYM4 SIZE: A

SHEET: 1 OF 1 DRAWN: LRH II APPR:

REVISIONS

LTR:	DESCRIPTION: (ECN#)	DATE:
--	DWG. RELEASED	11/10/08

"PROPRIETARY INFORMATION"