

ASSEMBLY INSTRUCTIONS

1.0 PREPARING THE CABLE

- 1.1 TRIM THE CABLE TO DIMENSIONS SHOWN
- 1.2 FILE THE BLUNT END OF THE CABLE INNER CONDUCTOR TO A 60° / 90° CONE
- 1.3 REMOVE BURRS AND SHARPEN EDGES FROM OUTER CONDUCTOR WITH SCOTCH BRITE
- 1.4 DIP PREPARED END OF CABLE INTO FLUX, THEN INTO SOLDER POT APPROXIMATELY 1/2 INCH FORMING A THIN COAT OF TIN ON THE OUTER AND INNER CONDUCTOR. THEN REMOVE EXCESS SOLDER, IF NEEDED, AND CLEAN WITH SOLVENT.

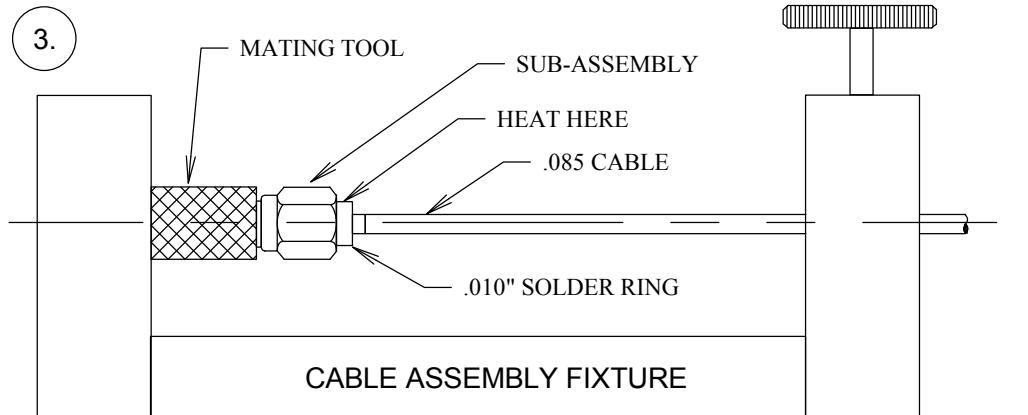
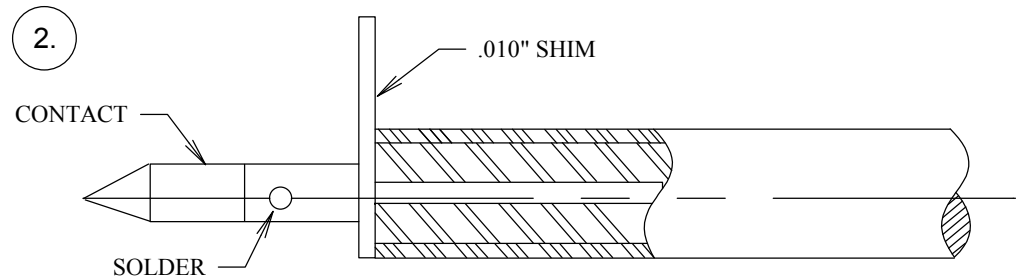
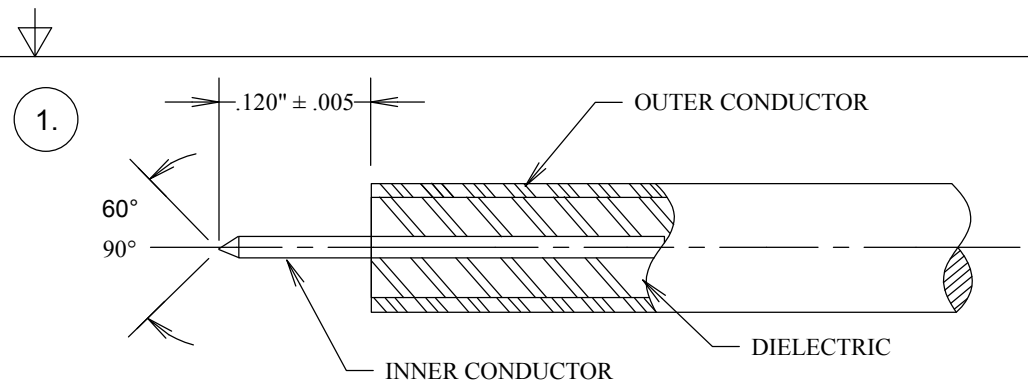
2.0 SOLDERING CENTER CONTACT TO INNER CABLE CONDUCTOR

- 2.1 PLACE SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC
- 2.2 HEAT CENTER CONTACT AND SLIDE IT OVER THE INNER CONDUCTOR TO REST FIRMLY AGAINST SHIM.
- 2.3 SOLDER CONTACT AS SHOWN USING 60/40.
- 2.4 REMOVE EXCESS SOLDER AND CLEAN WITH SOLVENT.

3.0 SOLDERING CABLE SUB-ASSEMBLY TO BODY

- 3.1 FORM A RING(360°) WITH .010 SOLDER AROUND CABLE.
- 3.2 THREAD MATING TOOL INTO CONNECTOR.
- 3.3 INSERT CABLE SUB-ASSEMBLY INTO BACK OF CONNECTOR HOUSING UNTIL IT BOTTOMS. PLACE INTO FIXTURE AND CLAMP CABLE TO PREVENT MOVEMENT WHILE SOLDERING.
- 3.4 USING RESISTIVE SOLDERING IRON, HEAT HOUSING(HOLDING DOWNWARDS) UNTIL SOLDER FLOWS EVENLY AROUND CABLE AND HOUSING.
- 3.5 REMOVE MATING TOOL AND CLEAN SOLDER JOINT WITH SOLVENT(ALCOHOL). VERIFY THAT SOLDER IS FREE OF VOIDS.
- 3.6 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE(.052/.058)

CAUTION: AVOID USING CLEANING FLUIDS CONTAINING HALOGENATED AND AROMATIC HYDROCARBONS, THESE CHEMICALS CAN CAUSE DAMAGE TO THE CENTER CONDUCTOR SUPPORT BEND. USE ISOPROPYL ALCOHOL FOR CLEANING PROCEDURES.



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TITLE			
2.92mm M .085 SEMI-RIGID			
SIZE	CAGE CODE	DWG NO	REV
A	3FKR5	SMC292-085M	--
SCALE		SHEET	