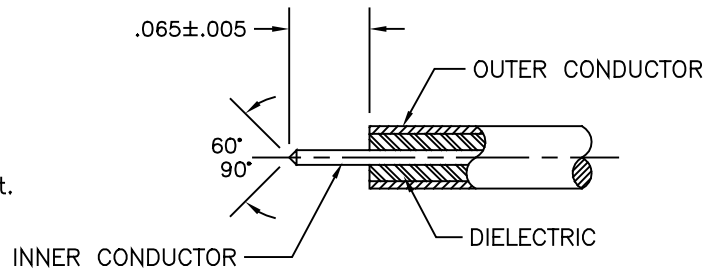


1.

1.0 PREPARATION OF CABLE:

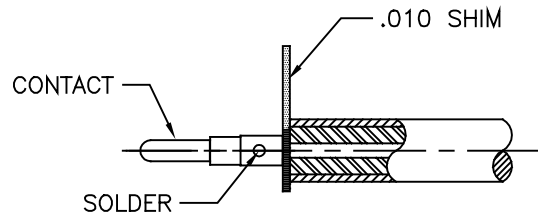
- 1.1 Trim cable to dimensions shown.
- 1.2 File blunt end of cable inner conductor to a 60°/90° Cone.
- 1.3 Remove burrs and sharp edges from outer conductor with scotch brite.
- 1.4 Dip prepared end of cable into flux, then into solder pot approx. 1/2 inch. Forming a thin coat of tin on the outer and inner conductor.
(Remove Excess solder if needed) clean with solvent.



2.

2.0 SOLDERING OF CENTER CONTACT TO INNER CABLE CONDUCTOR.

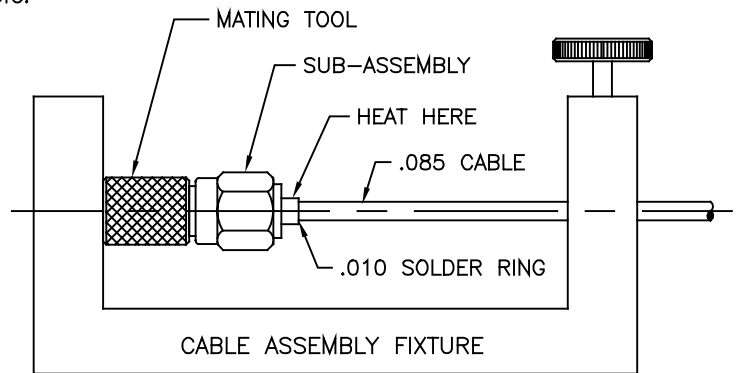
- 2.1 Place shim on center conductor resting firmly against Cable Dielectric.
- 2.2 Heat center contact and slide it over inner conductor to rest firmly against shim.
- 2.3 Solder contact as shown using 60/40.
- 2.4 Remove excess solder and clean with solvent.



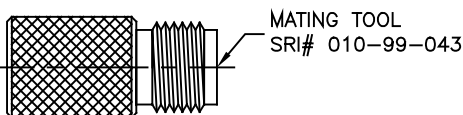
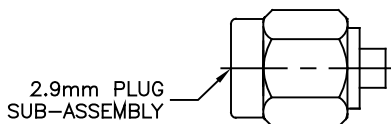
3.

3.0 SOLDERING OF 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 bead. (Use Isopropyl Alcohol for Cleaning Procedures.)



USED ON		
24-000-1004-90		
DIMENSIONS ARE IN INCHES TOLERANCES		
DECIMALS	FRACTIONAL	ANGULAR
.X ±.030		.° ±1°0'
.XX ±.015	± 1/64	.°X' ±15'
.XXX +.005		
DRAWN	DATE	
LRH	08/00	
SIZE	FSCM NO.	
A	OHMO1	

Σ SRI CONNECTOR GAGE CO.
751 NORTH DRIVE
MELBOURNE FL. 32934

TITLE
ASSEMBLY INSTRUCTIONS
2.9mm PLUG TO
.141 LOW LOSS
SEMI-RIGID CABLE

SHEET 1 USED ON 24-000-1004-90