

DRAWING No.

9800-7054-6200

Approved

DC

Drawn

RMS

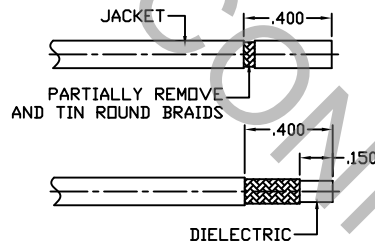
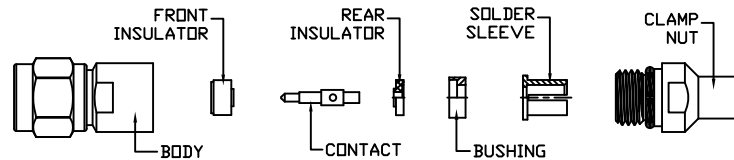
REV.	DCN NUMBER	DATE	APP.
AA	13-1107	1/23/13	DC

CABLE ASSEMBLY INSTRUCTIONS

CONNECTOR TYPE: SMA PLUG
SOLDER CLAMP ATTACHMENT

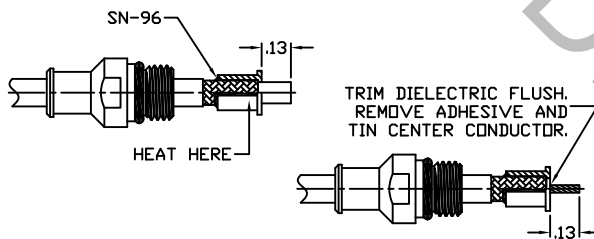
CABLE TYPE: T7-00054 LOW LOSS

PARTS SUPPLIED



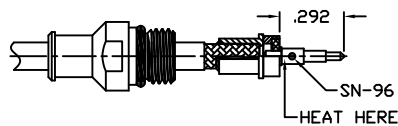
STEP 1: CABLE PREPARATION

TRIM THE CABLE JACKET TO THE DIMENSION SHOWN AND PARTIALLY REMOVE. DIP THE ROUND BRAID IN SN-63 SOLDER PBT (DO NOT USE FLUX OR ALCOHOL). REMOVE THE STRIPPED JACKET FROM THE BRAIDS. STRIP ROUND BRAID TO THE DIELECTIC TO THE DIMENSIONS SHOWN.



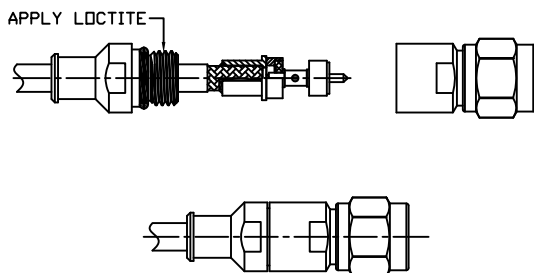
STEP 2: SOLDER SLEEVE ATTACHMENT

INSTALL THE SHRINK TUBING AND REAR NUT ONTO THE PREPARED CABLE. RE-FORM THE END OF THE CABLE AND GENTLY SLIDE THE SOLDER SLEEVE ONTO THE CABLE BRAID. SOLDER INTO POSITION USING SN-63 (DO NOT USE FLUX), TRIM CABLE DIELECTRIC FLUSH TO EXPOSE THE CENTER CONDUCTOR BEING CAREFUL NOT TO NICK THE CENTER CONDUCTOR. SCRAPE OFF ANY EXCESS ADHESIVE AND TIN THE CENTER CONDUCTOR.



STEP 3: CONTACT ATTACHMENT

PLACE THE INSULATOR INTO THE BUSHING AS SHOWN. PRETIN THE CONTACT. HEAT THE CONTACT AND SOLDER THE CONTACT FLUSH AGAINST THE INSULATOR TO THE DIMENSION SHOWN. INSPECT CONTACT HEIGHT AS SHOWN.



STEP 4: CONNECTOR ASSEMBLY

ASSEMBLE THE FRONT INSULATOR ONTO THE CONTACT AS SHOWN. INSTALL THE PREPARED CABLE INTO THE BODY ASSEMBLY AND THREAD THE CLAMP NUT INTO THE BODY ASSEMBLY FINGER TIGHT. APPLY THREAD LOCKER AND TORQUE TO 30 - 35 INCH POUNDS USING 5/16" WRENCHES.

STEP 5: GAGE & INSPECT

SMA MP	SMA MD
.000/-0.010	.000/-0.010

dynamwave
CABLE INCORPORATED

DWG. No.

9800-7054-6200