2.750

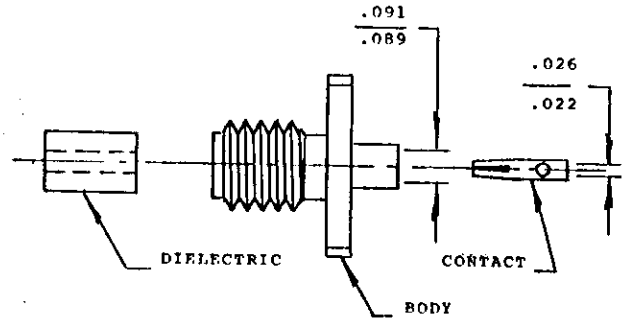
AF 46658

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

MARK LABEL PER PARTS LIST

CONNECTOR TYPE...SMA JACK, CABLED SOLDER ATTACHMENT. 4 HOLE FLANGE MOUNT.
CABLE TYPE..... .085 O.D. SEMI-RIGID.
SPECIAL TOOLS....FIXTURE BASE OSI T-4567
CLAMP INSERT OSI T-4700-2
LOCATOR TOOL OSI T-4569
DIELECTRIC
INSERT TOOL OSI T-4551

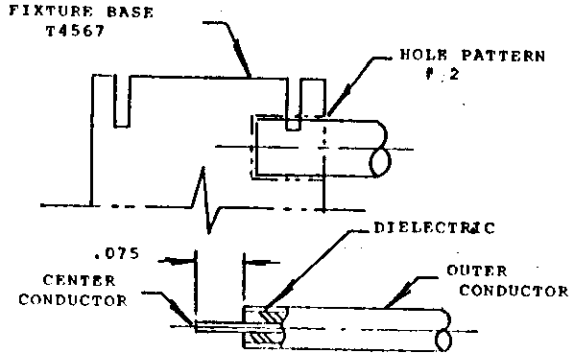
PARTS SUPPLIED



8.000

ASSEMBLY INSTRUCTIONS

1.0 PREPARE CABLE
- 1.1 Secure Fixture Base T-4567 In a Vise.
- 1.2 Clean Approximately ½ Inch at End of Cable Outer Conductor with Fine Grain Abrasive Paper.
- 1.3 Insert Cable in .085 Dia. Hole in Hole Pattern #2 of Fixture Base.
- 1.4 Saw Thru Outer Conductor & Into Dielectric While Rotating Cable. NOTE: Depth of Slot will Protect Center Conductor.
- 1.5 Remove Cable from Fixture Base.
- 1.6 Insert Cutting Blade Into Saw Cut.
- 1.7 Rotate Cable & Carefully Cut Through Dielectric.
- 1.8 Insert Flat End of Blade In Cut & Pry.
- 1.9 Trim Cable Center Conductor to Dimension Shown & Point with a Small File.
- 1.10 Clean Cable End with Alcohol.



300-80-619

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

SYM	DESCRIPTION	DATE	APPR.
-	REL 1055	SEE	

UNLESS OTHERWISE SPECIFIED
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES: TWO PLACE DECIMAL ±.005 THREE PLACE DECIMAL ±.010 ANGULAR ±1°
3. REMOVE ALL BURRS & SHARP EDGES .005
4. CHAMFER 1ST & LAST THREADS 45°
5. ALL DIAMETERS TO BE CONCENTRIC T.I.R.
6. SURFACE ROUGHNESS 63 √ (MIL-STD-10)

DRAWN SEE DATE 4/87
CHECKED DATE
APPROVED DATE

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

SCALE —
CODE IDENT NO. 95077
SIZE B
MATERIAL —
FINISH —
AREA —

REF. MIL-C-39012/83-3001
TITLE CABLE ASSEMBLY INSTRUCTIONS
DRAWING NO. 300-80-619
SHEET 1 of 2

SIZE B
DRAWING NO. 300-80-619

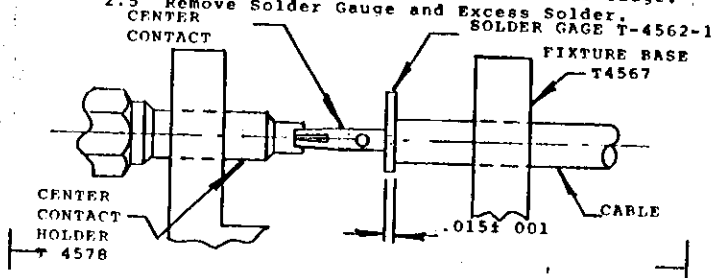
2.750

AF 46658

ASSEMBLY INSTRUCTIONS- CON'D

2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.

2.1 Tin Inner Conductor of Cable.
2.2 Tin and Fill Solder Hole of Contact.
2.3 Place Solder Gauge on Inner Conductor, Flush with End of Outer Conductor.
2.4 Place Center Contact In Holder, Heat Center Contact and push it over Inner Conductor of Cable to Rest Firmly Against Solder Gauge.
2.5 Remove Solder Gauge and Excess Solder.



3.0 SOLDER CABLE TO HOUSING

3.1 Slide Housing on End of Cable Sub-Assembly
3.2 Apply a Thin Film of Non-Corrosive Flux to Approximately ½ Inch of Cable Outer Conductor
3.3 Position Housing over Cable as Shown.
3.4 Bottom Cable on Locator Tool T-4569.
3.5 Secure Cable By Tightening Clamp Screw.
3.6 Tighten Locator Tool Against Prepared Cable.
3.7 Slide Housing on Cable & Bottom on Locator Tool.
3.8 Apply Heat & Pressure to the Rear of the Housing. Pressure is Required to Hold Housing Bottomed on Locator Tool During Soldering.
3.9 Add Sufficient Solder to Assure Good Pentration.
3.10 Remove Heat, Hold Pressure using a Non-Heat Sinking Tool Such as a Small Screw Driver, & Allow the Solder Joint to Cool. Do not Artificially Cool with any Liquid. Do not Disturb the Setup Until the Solder Joint is Cool or Just warm Enought to Touch.
3.11 Remove Cable Assembly from Fixture Base & Clean Soldered Area with Alcohol To Remove Any Residual Flux.

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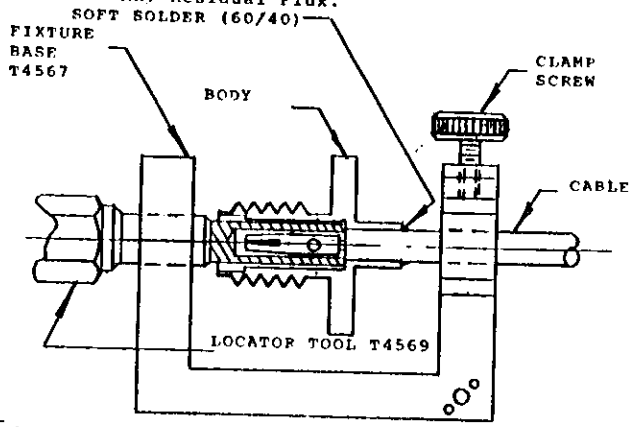
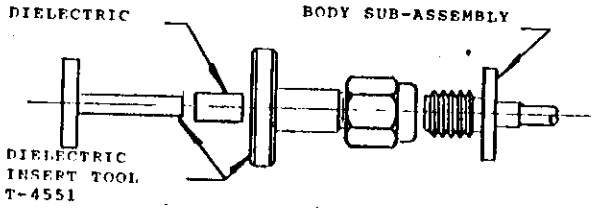


4.0 PRESSING OF DIELECTRIC BUSHING INTO HOUSING SUB-ASSEMBLY

4.1 Thread Insert Tool ONto Housing Sub-Assembly.
4.2 Insert Dielectric Into Insert Tool Housing.
4.3 Place Insert Tool Plunger Into Position & Press Until Flange Bottoms On Tool Housing.
4.4 Assembly Is Now Complete.



300-80-619

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

SYM | DESCRIPTION | DATE | APPR.
1 | KEL-1089 | SEE

UNLESS OTHERWISE SPECIFIED
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES: THREE PLACE DECIMALS ±.005 TWO PLACE DECIMALS ±.015 ANGULAR ±.25°
3. REMOVE ALL BURRS & SHARP EDGES
4. CHAMFER 1ST & LAST THREADS 45°
5. ALL DIAMETERS TO BE CONCENTRIC T.I.R.
6. SURFACE ROUGHNESS 63 √ (MIL-STD-101)

DRAWN GEE DATE 6-5-87
CHECKED DATE
APPROVED DATE

SOLITRON/MICROWAVE
PORT SALERNO, FLORIDA

MATERIAL
FINISH
AREA
SCALE
CODE IDENT NO. 95077
SIZE B
REF. MIL-C-39012/83-3001
TITLE CABLE ASSEMBLY INSTRUCTIONS
DRAWING NO. 300-80-619
SHEET 2 of 2

SIZE B
DRAWING NO. 300-80-619

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ENG. FILE COPY