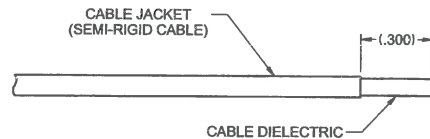


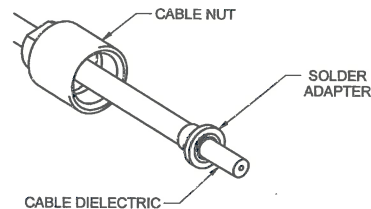
STEP 1

- 1.1 TRIM CABLE JACKET APPROXIMATELY .300 INCH FROM END OF CABLE,



STEP 3

- 3.1 INSTALL CABLE NUT PRIOR TO INSTALLING SOLDER ADAPTER.
3.2 SLIDE CABLE ADAPTER OVER CABLE DIELECTRIC AND ONTO CABLE JACKET.



STEP 4

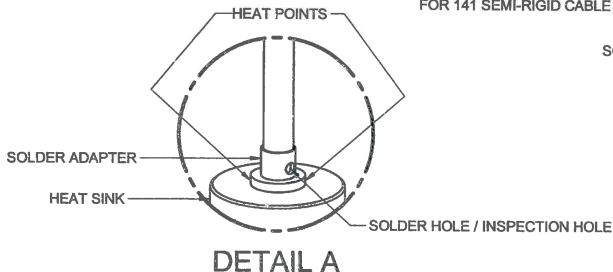
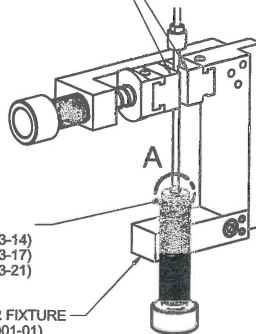
NOTE: IF USING NON SMI FIXTURING SKIP TO 4.2

- 4.1 USING SMI SOLDER FIXTURE PLACE THE CABLE SUBASSEMBLY INTO THE HEAT SINK WITH THE ADAPTER AND CABLE JACKET AGAINST THE FACE OF THE HEAT SINK.
4.2 USING RESISTANT SOLDERING UNIT, SOLDER THE ADAPTER TO CABLE. PLACE RESISTANT SOLDER TWEEZERS ON BOTH SIDES OF THE LARGE DIAMETER OF THE ADAPTER AND HOLD DOWN AGAINST SURFACE OF THE HEAT SINK. FEED SOLDER THRU SOLDER HOLE UNTIL SOLDER FLOWS 360° AROUND SOLDER ADAPTER. MINIMAL FILLET IS DESIRED. REMOVE SOLDERED ASSEMBLY FROM HEAT SINK AND FIXTURE.

CABLE CLAMPS
FOR 047 SEMI-RIGID CABLE (T-5002-09)
FOR 086 SEMI-RIGID CABLE (T-5002-07)
FOR 141 SEMI-RIGID CABLE (T-5002-08)

HEAT SINK
FOR 047 SEMI-RIGID CABLE (T-5003-14)
FOR 086 SEMI-RIGID CABLE (T-5003-17)
FOR 141 SEMI-RIGID CABLE (T-5003-21)

SOLDER FIXTURE
(T-5001-01)

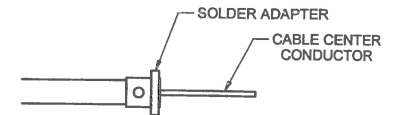


REV.	ECN	CHANGE DESCRIPTION	REV BY	DATE	APPR
A		RELEASE		4/15/14	B.C.

STEP 5

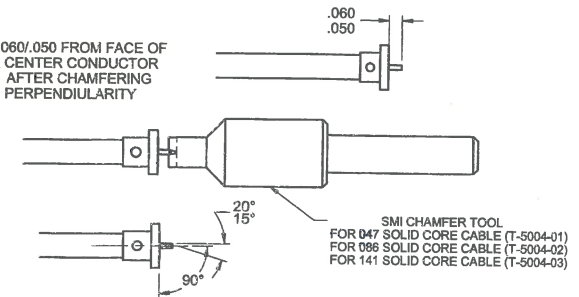
- 5.1 AFTER SOLDERING THE ADAPTER IN PLACE CAREFULLY BEND CABLE DIELECTRIC BACK AND FORTH AT VERY SMALL ANGLES WHILE PUSHING DIELECTRIC INTO FACE OF SOLDER ADAPTER TO STABILIZE THE CABLE DIELECTRIC. TRIM THE DIELECTRIC FLUSH WITH SOLDER ADAPTER.

(CAUTION: DO NOT KNICK OR CUT CABLE CENTER CONDUCTOR).



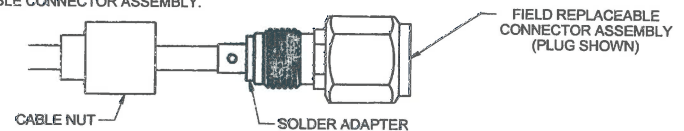
STEP 6

- 6.1 TRIM CABLE CENTER CONDUCTOR TO .060/.050 FROM FACE OF SOLDER ADAPTER. EVENLY CHAMFER CENTER CONDUCTOR APPROXIMATELY 20°/15° ALL AROUND. AFTER CHAMFERING VISUALLY VERIFY STRAIGHTNESS AND PERPENDICULARITY OF CENTER CONDUCTOR.



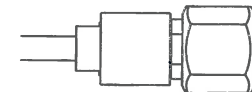
STEP 7


- 7.1 CAREFULLY INSERT CABLE CENTER CONDUCTOR INTO THE SOCKET CONTACT OF THE FIELD REPLACEABLE CONNECTOR ASSEMBLY.



STEP 8

- 8.1 USING 7/32" OPEN ENDED WRENCH TO HOLD FIELD REPLACEABLE CONNECTOR ASSEMBLY TIGHTEN CABLE NUT ONTO FIELD REPLACEABLE CONNECTOR ASSEMBLY USING A 1/4" OPEN ENDED WRENCH. (CAUTION: DO NOT TURN FIELD REPLACEABLE CONNECTOR ASSEMBLY WHILE TIGHTENING CABLE NUT).



FROM NO. 66049		 SOUTHWEST MICROWAVE		Southwest Microwave, Inc. 9055 South McKerny Street Tempe, Arizona 85284-2846 Telephone (480) 783-0201 Fax (480) 783-0360	
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DRN T.CLARE	DATE 04/15/2014	TITLE CABLE TERMINATION INSTRUCTIONS FOR Ø.047, Ø.086 AND Ø.141 SEMI-RIGID CABLE TO FIELD REPLACEABLE CONNECTOR			
CHK	DATE				
ENG B. Cloutier	DATE 4/15/14	SCALE N/A DWG. NO. 91S61502			
MFG ENG	DATE				
		SHEET 1 of 1		REV. A	