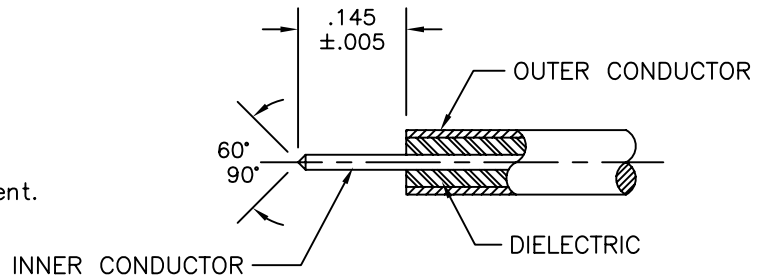


1.

1.0 PREPARATION OF CABLE:

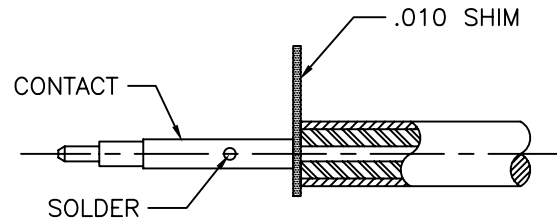
- 1.1 Trim cable to dimensions shown.
- 1.2 File blunt end of cable inner conductor to a 60°/90° Cone.
- 1.3 Remove burrs and sharp edges from outer conductor with scotch brite.
- 1.4. Dip prepared end of cable into flux, then into solder pot approx. 1/2 inch. Forming a thin coat of tin on the outer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



2.

2.0 SOLDERING OF CENTER CONTACT TO INNER CABLE CONDUCTOR.

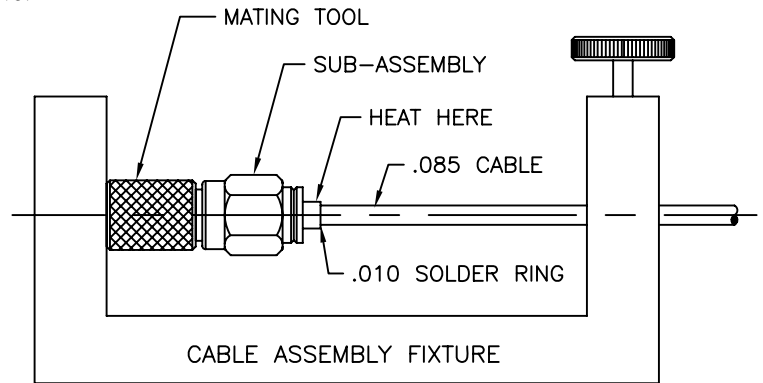
- 2.1 Place shim on center conductor resting firmly against Cable Dielectric.
- 2.2 Heat center contact and slide it over inner conductor to rest firmly against shim.
- 2.3 Solder contact as shown using 60/40.
- 2.4 Remove excess solder and clean with solvent.



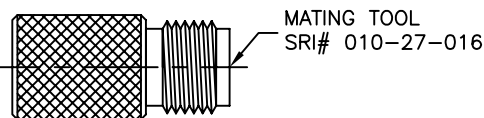
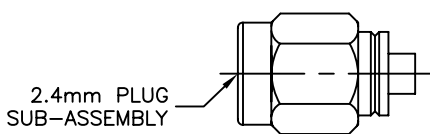
3.

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  
26-000-1085-40

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

DIMENSIONS ARE IN INCHES TOLERANCES		
DECIMALS	FRACTIONAL	ANGULAR
.X ±.030	± 1/64	.X° ±1°0'
.XX ±.015		.X°X' ±15'
.XXX +.005		

TITLE  
ASSEMBLY INSTRUCTIONS  
2.4mm PLUG TO  
.085 SEMI-RIGID CABLE

DRAWN LRH DATE 08/00

SIZE A FSCM NO.  $\square$ HMO1

SHEET 1 USED ON 26-000-1085-40