

SC5172 ASSEMBLY INSTRUCTIONS

1.0 TRIM CABLE PER STRIPPING DIMENSIONS.

1.1 TIN OUTER BRAID WITH SOLDER POT OR EQUIVALENT.

2.0 TRIM TINNED BRAID TO EXPOSE CENTER CONDUCTOR AND CABLE DIELECTRIC AS ILLUSTRATED. BE CAREFUL NOT TO NICK CABLE CENTER CONDUCTOR.

2.1 PRE-TIN CENTER CONDUCTOR OF CABLE WITH SOLDER POT OR EQUIVALENT METHOD.

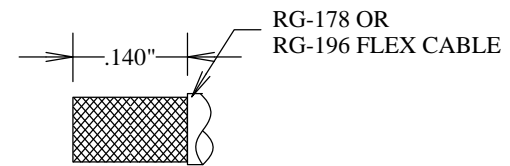
3.0 PLACE CENTER CONTACT INTO LOCATOR/HOLDING TOOL, HEAT CENTER CONTACT AND PUSH OVER CENTER CONDUCTOR OF CABLE UNTIL IT FIRMLY RESTS AGAINST EXPOSED CABLE DIELECTRIC. SOLDER CONTACT INTO POSITION.

4.0 PLACE CONNECTOR SUB-ASSEMBLY ONTO CONTACT/CABLE ASSEMBLY.
NOTE: CONTACT MUST BE FLUSH TO BELOW REFERENCE PLANE OF OUTER CONDUCTOR

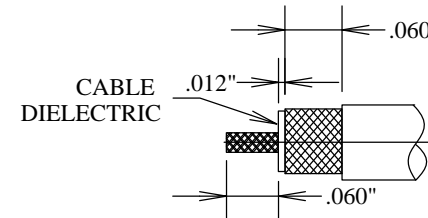
4.1 SOLDER CONNECTOR TO CABLE. MAX SOLDERING TEMPERATURE IS 550°F. CLEAN SOLDER JOINT OF EXCESS SOLDER AND FLUX.

4.2 PLACE PROVIDED HEAT SHRINK SLEEVE OVER CABLE/CONNECTOR JUNCTION; APPLY HEAT.

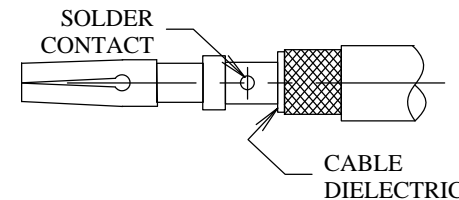
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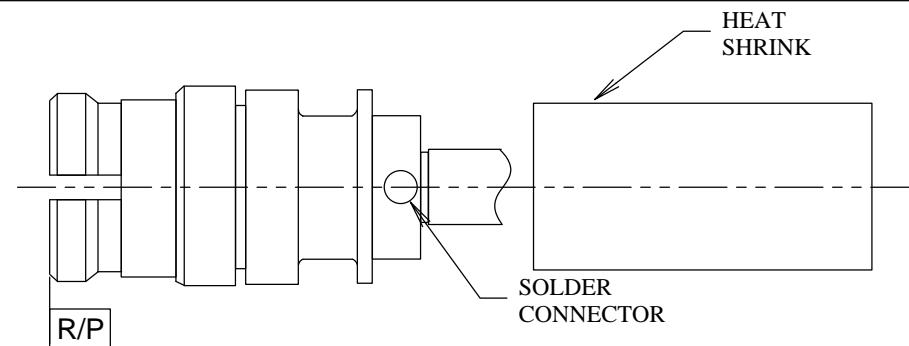
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4.



FAIRVIEW MICROWAVE INC.

ALLEN, TX 75013 WWW.FAIRVIEWMICROWAVE.COM

TITLE

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INSTRUCTIONS**

SIZE	CAGE CODE	DWG NO	REV
A	3FKR5	SC5172 AI	--

SCALE	SHEET
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