

SC5174 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.

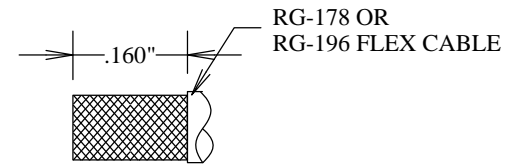
4.0 PLACE CONNECTOR SUB-ASSEMBLY ONTO ACCESS CONTACT/CABLE ASSEMBLY. NOTE: CABLE ACCESS CONTACT MUST ENGAGE CENTER CONTACT OF CONNECTOR. VISUALLY INSPECT BIFURCATED JUNCTION THRU PORT HOLE AT REAR OF CONNECTOR. ENSURE ACCESS CONTACT IS ONLY .005 MAX ABOVE BIFURCATED CONTACT.

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

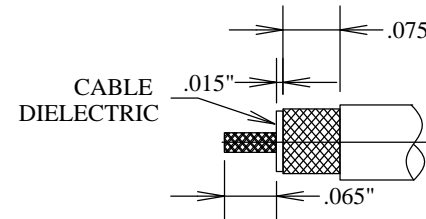
4.2 PLACE PROVIDED HEAT SHRINK SLEEVE OVER CABLE/CONNECTOR JUNCTION; APPLY HEAT.

4.3 INSTALL PORT PLUG WITH C'SINK FACING PORT HOLE. GENTLY PRESS PORT PLUG INTO PLACE WITHIN ± 0.001 OF CONNECTOR END.

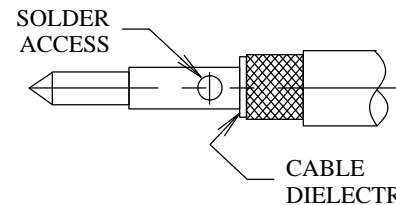
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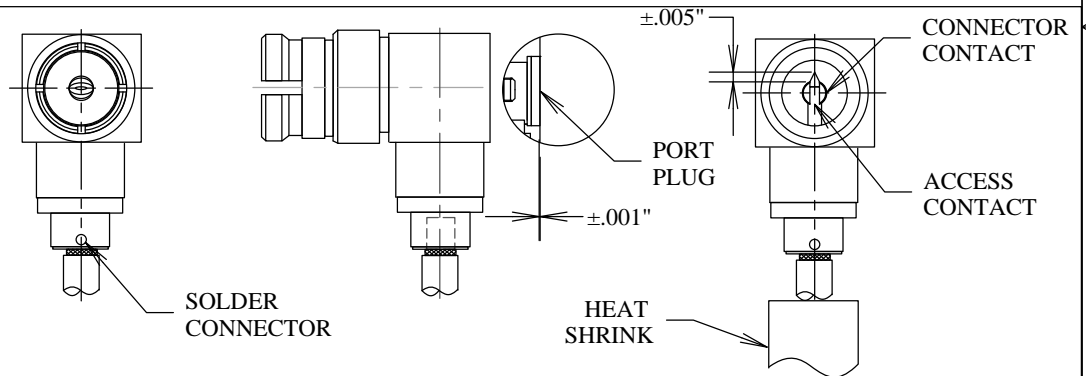
2.



3.



4.



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TITLE

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SIZE	CAGE CODE	DWG NO	REV
A	3FKR5	SC5174 AI	--
SCALE	SHEET		