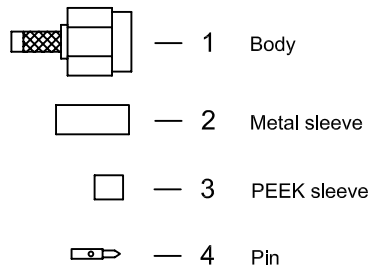
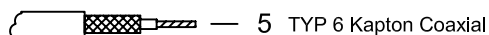


Parts list

P.N. 111027



P.N. 100720



Tools list

Available at www.accuglassproducts.com

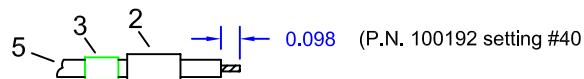
- P.N. 110797 Flux
- P.N. 110796 Solder UHV
- P.N. 110800 High temperature soldering iron
- P.N. 111029 Hex crimp tool
- P.N. 100192 Wire stripper

Optional

- P.N. 110804 Butane refill

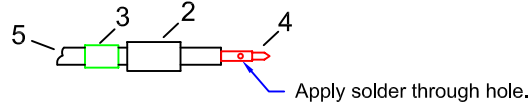
Cable Prep.

- Slide PEEK sleeve (#3) onto wire, will be moved into position in step 9
- Slide Metal sleeve (#2) onto wire, will be moved into position in step 9
- Prepare cable to the following specifications.



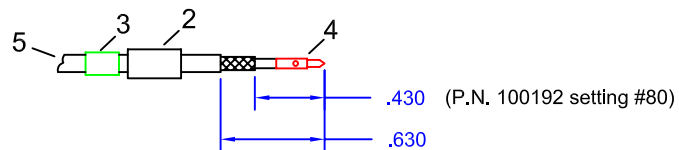
- Slide gold Pin (#4) onto wire to check fit. Remove Pin.
* Caution; Back of Pin *MUST* rest tightly to kapton insulation. This helps to stabilize the pin from side to side movement.
- Dip exposed conductor into flux P.N. 110797
Slide Pin (#4) onto conductor.

- Solder using UHV compatible solder P.N. 110796 and High temperature soldering iron P.N. 110800.



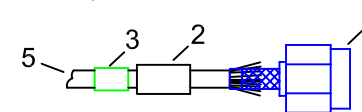
- * Caution; If solder overfills hole, connector installation can not continue. Reheat and scrape off excess solder with razor blade.

- Prepare the rest of the cable to the following specifications.

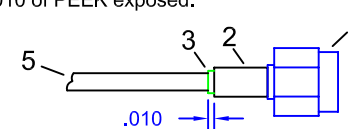


Connector installation

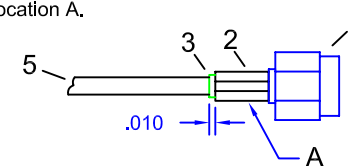
- Unbraid and flare out shielding. Slide body (#1) onto cable until Pin stops it.



- Slide Metal sleeve (#2) up to Body (#1) to cover the shielding. Slide PEEK sleeve (#3) under Metal sleeve (#2). Leave about .010 of PEEK exposed.



- Use Hex crimp tool P.N. 111029 size .128 to crimp location A.



- Test cable for continuity.
- Clean with ultrasonic bath of Isopropyl Alcohol for 5 minutes min.



Accu-Glass Products Inc.
700 Arroyo Ave.
San Fernando, CA. 91340
TEL. 818-365-4215
FAX. 818-365-7074

Notes

Material

Title

SMA-P (male)

Tolerances unless otherwise specified
Decimal Angular
.xx= +/- .005 +/- 1°
.xxx= +/- .002

Drawn By	M.Wilson	DWG NO.	A111027	Date	4-10-08
Approved			SHEET		