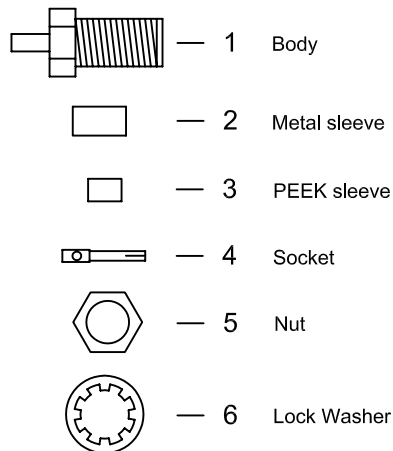
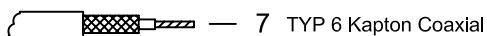


Parts list

P.N. 111028



P.N. 100720



Tools list

Available at www.accuglassproducts.com

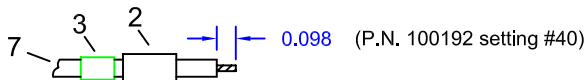
- P.N. 110797 Flux
- P.N. 110796 Solder UHV
- P.N. 110800 High temperature soldering iron
- P.N. 111029 Hex crimp tool
- P.N. 100192 Wire stripper

Optional

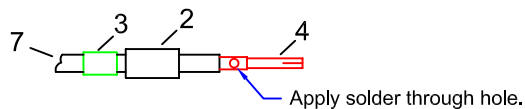
- P.N. 110804 Butane refill

Cable Prep.

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

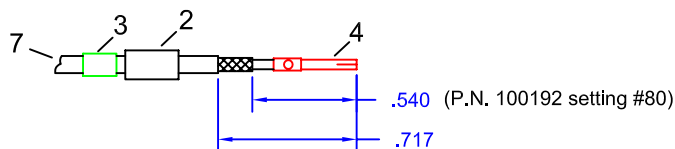


4. Slide gold Socket (#4) onto wire to check fit. Remove Socket.
* Caution: Back of Socket *MUST* rest tightly to kapton insulation. This helps to stabilize the Socket from side to side movement.
5. Dip exposed conductor into flux P.N. 110797
Slide Socket (#4) onto conductor.
6. Solder using UHV compatible solder P.N. 110796 and High temperature soldering iron P.N. 110800.



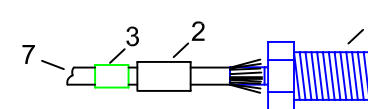
* Caution: If solder overfills hole, connector installation can not continue. Reheat and scrape off excess solder with razor blade.

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

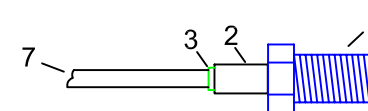


Connector installation

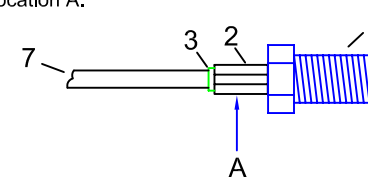
8. Unbraid and flare out shielding. Slide body (#1) onto cable until Socket stops it.



9. Slide Metal sleeve (#2) up to Body (#1) to cover the shielding. Slide PEEK sleeve (#3) under Metal sleeve (#2) until it stops.



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



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

Notes



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

Material

Title

SMA-S (female)

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

Drawn By	M.Wilson	DWG NO.	A111028	Date	4-8-08
Approved			SHEET		