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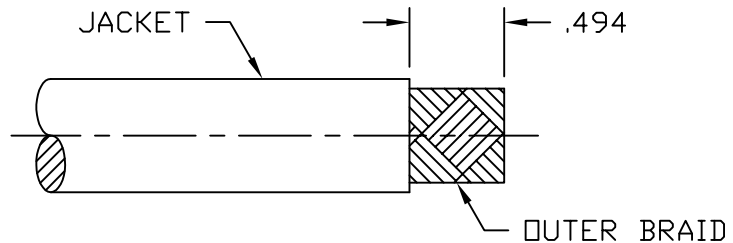
SYM	REVISION DESCRIPTION	DFTM	DATE	APPD	DATE
-	RELEASED FOR PRODUCTION	R. A.	8/1/94	R. A.	8/1/94
A	CHANGED PER CDC #29562	D. J. H.	10/16/08	J. D. B.	1/23/09
B	CHANGED PER CDC #39374	N. N. N.	5/29/15	J. D. B.	6/3/15
C	CHANGED PER CDC #44848	D. J. H.	7/7/16	J. D. B.	7/11/16

USE FOR CABLE LMR-600.

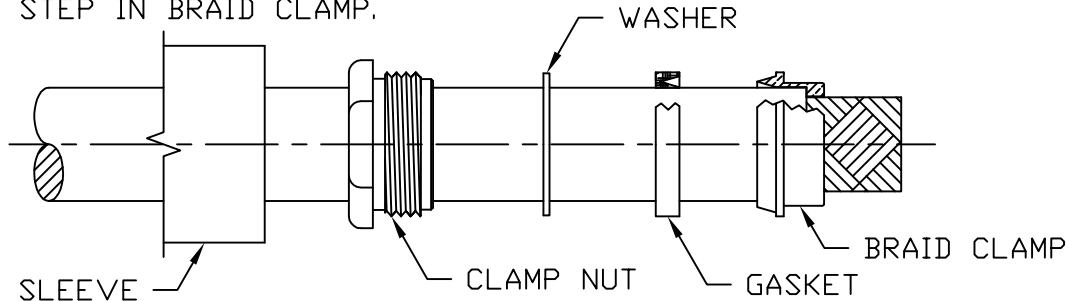
NOTE EACH CONNECTOR ADDS .900" TO CABLE LENGTH.

1. FLUSH CUT END OF CABLE USING A FINE SAW BLADE. CUT CABLE SO THAT END REMAINS ROUND AND FACE OF CABLE IS PERPENDICULAR TO ITS LENGTH. TRIM JACKET BACK .494" TO EXPOSE OUTER BRAID. DO NOT NICK OUTER BRAID.

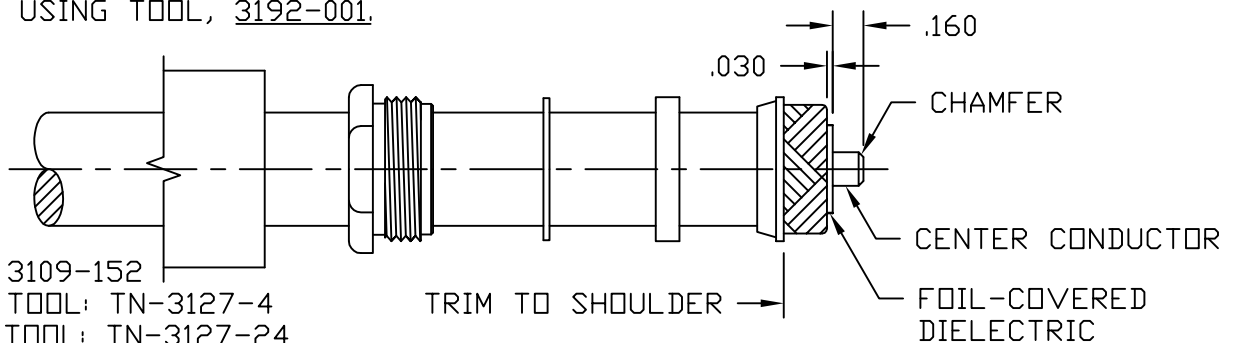
SCHLEUNIGER STRIPPER SETTINGS
(ADJUST DIAMETER AS REQUIRED)
S1=L1=.494 D1=.490 01t99



2. SLIDE SHRINK SLEEVE ONTO CABLE. INSTALL CLAMP NUT, WASHER, GASKET (GROOVE AS SHOWN), AND BRAID CLAMP ONTO CABLE. NOTE THAT CABLE JACKET MUST BOTTOM ON STEP IN BRAID CLAMP.



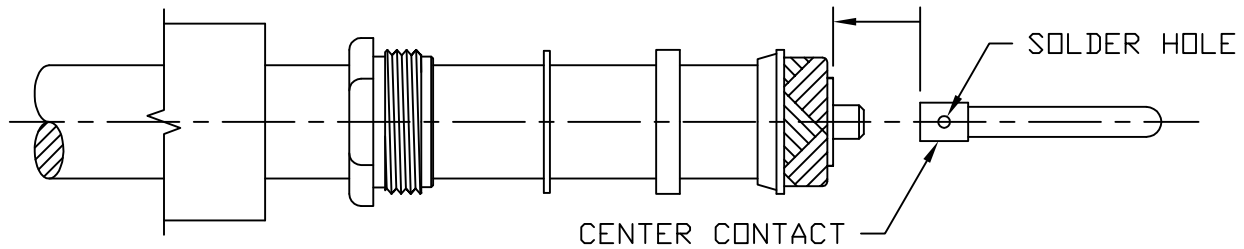
3. FLARE OUT BRAID TO EXPOSE FOIL-COVERED DIELECTRIC. FOLD THE BRAID BACK ONTO BRAID CLAMP. TRIM BRAID TO SHOULDER. TRIM DIELECTRIC TO .030" FROM BRAID USING TRIM TOOL, TN-3127-4. BE CAREFUL TO NOT NICK CENTER CONDUCTOR. TRIM CENTER CONDUCTOR TO .160" FROM DIELECTRIC USING TRIM TOOL, TN-3127-24. DIP SOLDER THE CENTER CONDUCTOR IN 60/40 SOLDER PER S1345. DEBURR CENTER CONDUCTOR USING TOOL, 3192-001.



FLUX PEN: 3109-152
.030" TRIM TOOL: TN-3127-4
.160" TRIM TOOL: TN-3127-24
DEBURR TOOL: 3192-001

TIMES MICROWAVE SYSTEMS		DIMENSION TOLERANCES (INCHES) UNLESS OTHERWISE SPECIFIED .XX ± .03 .XXX ± .015 FRACTIONS ± 1/16		CONNECTOR ASSEMBLY PROCEDURE "UHF" PLUG, CLAMP FOR LMR-600 CABLE	
DFTM. R. A.	DATE 8/1/94	CHKD. R. A.	DATE 8/1/94	APPD. R. A.	DATE 8/1/94
				SH	1 of 2
				CAP3190-213	
				REV	C

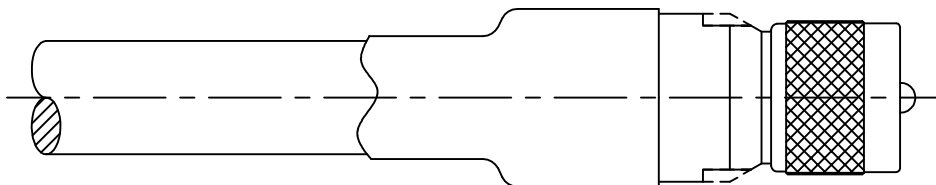
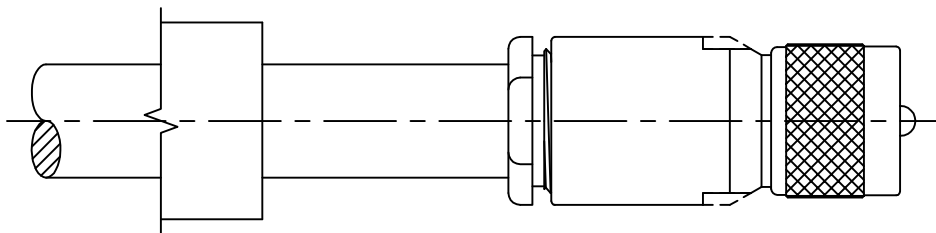
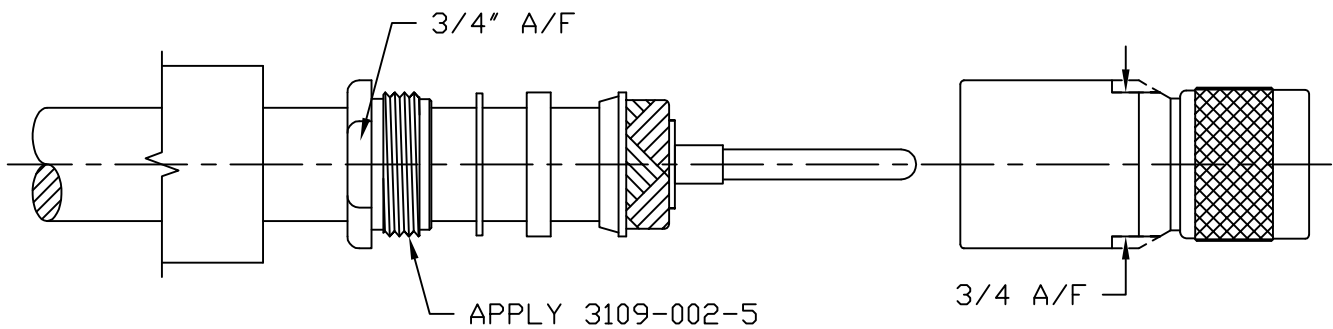
4. USING FLUX PEN, 3109-152, APPLY FLUX TO CENTER CONDUCTOR. INSTALL CENTER CONTACT ONTO CENTER CONDUCTOR AND AGAINST DIELECTRIC. SOLDER CONTACT TO CONDUCTOR BY FEEDING $\phi.025$ 63/37 SOLDER WIRE, 3109-013-2, THROUGH SOLDER HOLE. BE CAREFUL TO NOT DAMAGE CABLE DIELECTRIC BY OVERHEATING CONDUCTOR. GIVE CONTACT A LIGHT PULL TO MAKE SURE IT HAS BEEN SOLDERED PROPERLY. REMOVE ANY EXCESS SOLDER. CLEAN PER S1313.



63/37 SOLDER WIRE: 3109-013-2

5. ASSEMBLE GASKET ONTO BRAID CLAMP SO CLAMP FITS INTO GROOVE OF GASKET. INSTALL CONNECTOR BODY OVER CONTACT AND ONTO CABLE. APPLY THREAD LOCKER 3109-002-5 TO THREADS OF CLAMP NUT AND THREAD INTO CONNECTOR BODY. TORQUE TO 120-130 IN-LBS.

LOCATE SHRINK SLEEVE PER MI AND SHRINK IN POSITION.



THREAD LOCKER 3109-002-5
(2) 3/4" WRENCHES

DIMENSION TOLERANCES (INCHES) UNLESS OTHERWISE SPECIFIED .XX ± .03 .XXX ± .015 FRACTIONS ± 1/16

TIMES MICROWAVE SYSTEMS

2 of 2 CAP3190-213 C