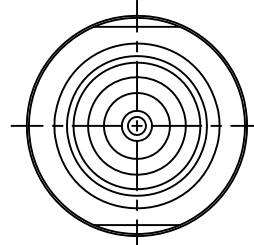
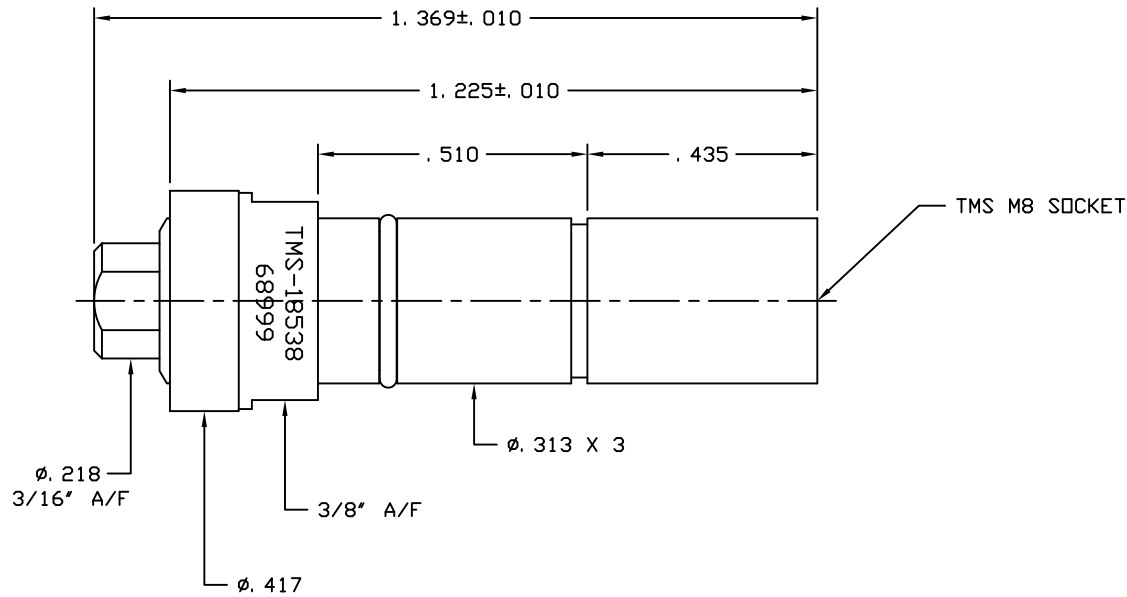


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SYM	REVISION DESCRIPTION	DFTM	DATE	APPD	DATE
A	RELEASED FOR PRODUCTION	J. D. B.	3/15/94	J. D. B.	3/15/94
B	CHANGED PER CDC #17166	J. D. B.	4/11/94	J. D. B.	4/11/94
C	CHANGED PER CDC #18639	J. D. B.	3/27/96	J. D. B.	3/28/96
D	CHANGED PER CDC #19839	J. D. B.	3/8/99	J. D. B.	3/8/99
E	CHANGED PER CDC #19894	J. D. B.	4/19/99	J. D. B.	5/3/99
F	CHANGED PER CDC #23940	J. D. B.	9/29/04	J. D. B.	9/29/04
G	CHANGED PER CDC #25296	D. J. H.	1/25/06	J. D. B.	1/25/06
H	CHANGED PER CDC #24700	D. R. W.	11/13/06	J. D. B.	11/13/06
J	CHANGED PER CDC #39742	N. N. N.	4/16/14	J. D. B.	4/16/14

SD18538

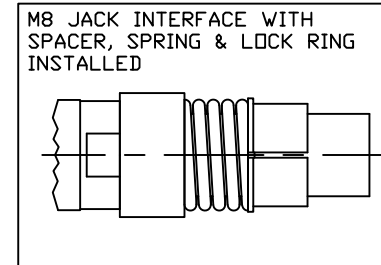


NOTES:

1. SPRING AC4048 AND LOCK RING AC4049 ARE SUPPLIED WITH THE CONNECTOR AND ARE NECESSARY TO HOLD THE CONTACT IN THE MULTIPOINT CONNECTOR SHELL. THE SPRING AND THE RING ARE SUPPLIED INSTALLED WITH SPACER AC5090 UNDERNEATH THE SPRING. REMOVE RING, SPRING AND SPACER BEFORE INSTALLING IN SHELL. DISCARD SPACER (AC5090).

2. INSTALLATION TOOL IN-2964 (AC4319) OR IN-2478 (AC4034) IS REQUIRED FOR ASSEMBLY AND REMOVAL OF THE CONNECTOR IN THE MULTIPOINT CONNECTOR SHELL.

3. GOLD PLATE PER MIL-DTL-45204 IS .000050 THICK MINIMUM.



AC5090	
AC4048	
AC4049	

DRAFTSMAN	John D. Bloomfield	3/9/94
CHECKER	John D. Bloomfield	3/15/94
APPROVED	John D. Bloomfield	3/15/94

UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE IN INCHES
 MACHINED SURFACES FINISH N/A RMS MAX.
 REMOVE ALL BURRS .005 MAX. BREAK
 MACHINE CORNERS .005 MAX. FILLET R.
 TOLERANCES ON DECIMALS
 .XX ± .03 .XXX ± .005
 ANGLES ± 1° FRACTIONS ± 1/32

TIMES MICROWAVE SYSTEMS		
TITLE: CONNECTOR ASSEMBLY CC-50086M8J-117S FOR CABLE RG-405 (M17/133)		
DWG. SIZE	B	DRWG. NO. SD18538
CODE IDENT.	68999	SHEET: 1 of 2

011650
W.O. NUMBER
MATERIAL:
SEE TABLE

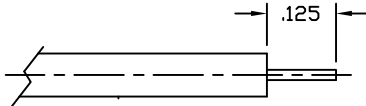
DIELECTRICS	TEFLON, ASTM D1710	NONE
TRANSFER BODY	BERYLLIUM COPPER, ASTM B196	GOLD PLATE, MIL-DTL-45204
BODY	BERYLLIUM COPPER, ASTM B196	GOLD PLATE, MIL-DTL-45204
CONTACTS	BERYLLIUM COPPER, ASTM B196	GOLD PLATE, MIL-DTL-45204
PART NAME	MATERIAL & SPEC. NUMBER	FINISH & SPEC. NUMBER

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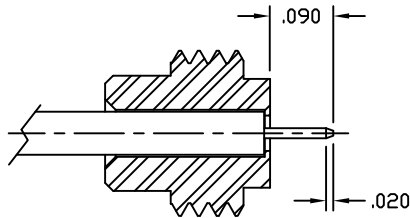
STEP 1. PREPARE THE CABLE

Cut the cable to the required length. Note that the connector adds .93" to the length of the cable. Make one sample first-piece (to be used for lab analysis), consisting of 6" cable, terminated on one end only. Expose the cable center conductor to the strip dimension. Do not nick the center conductor and make sure the outer conductor remains round and the face is perpendicular to cable.



STEP 2. SOLDER THE TRANSFER BODY

Apply 3109-152 Pen Flux to cable. Slide on the transfer body until it bottoms against the cable outer conductor. Solder the transfer body in position using an induction soldering machine or equivalent. Remove excess flux using spray degreaser and small brush. Trim the conductor to .090" and chamfer the end of the conductor to a .020" chamfer.

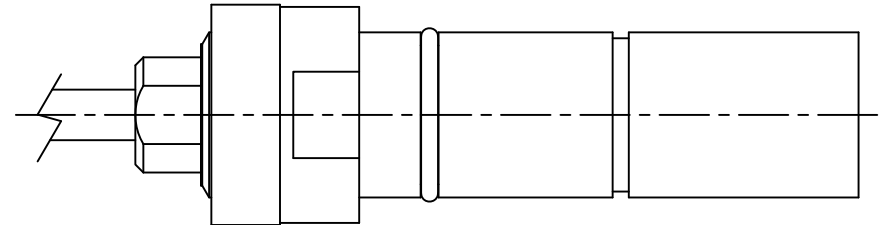


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J	CHANGED PER CDC #39742	N. N. N.	4/16/14	J. D. B.	4/16/14

SD18538

STEP 3. INSTALL THE CONNECTOR BODY.

Make sure the prepared end is free of dirt and chips per SI-313. Check that the conductor is straight. Apply a light coat of Loctite 620 to the threads of the transfer body. Screw on the connector body and tighten it to 25 in-lbs. Visually inspect solder joints per SI 308. Submit completed sample first-piece to Quality for lab analysis.



011650
W.O. NUMBER
MATERIAL:
SEE TABLE

DRAFTSMAN	John D. Bloomfield	3/9/94
CHECKER	John D. Bloomfield	3/15/94
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UNLESS OTHERWISE SPECIFIED		
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REMOVE ALL BURRS .005 MAX. BREAK		
MACHINE CORNERS .005 MAX. FILLET R.		
TOLERANCES ON DECIMALS		
.XX ± .03	.XXX ± .005	
ANGLES ± 1°	FRACTIONS ± 1/32	
DO NOT SCALE DRAWING		

TIMES MICROWAVE SYSTEMS		
TITLE:		
CONNECTOR ASSEMBLY CC-50086M8J-117S FOR CABLE RG-405 (M17/133)		
DWG. SIZE	B	DRWG. NO. SD18538
CODE IDENT.	68999	SCALE: NONE SHEET: 2 of 2