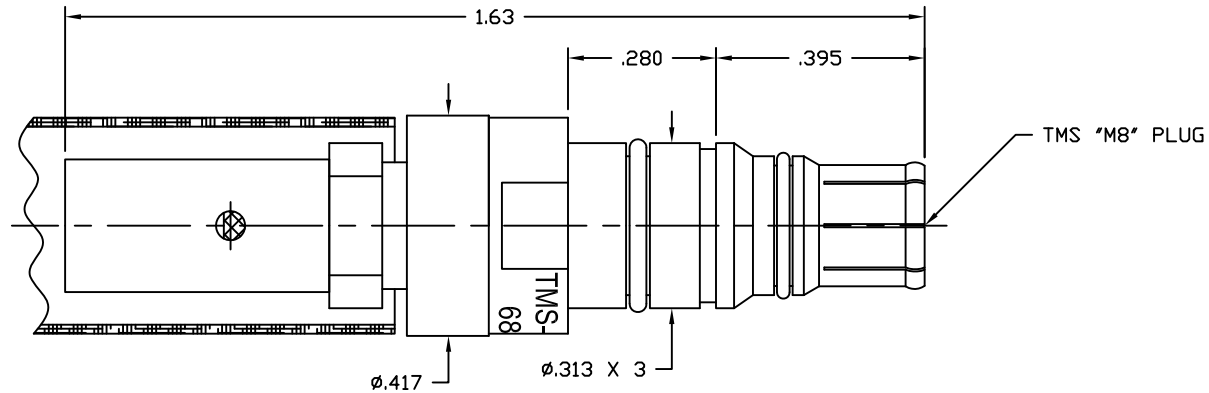


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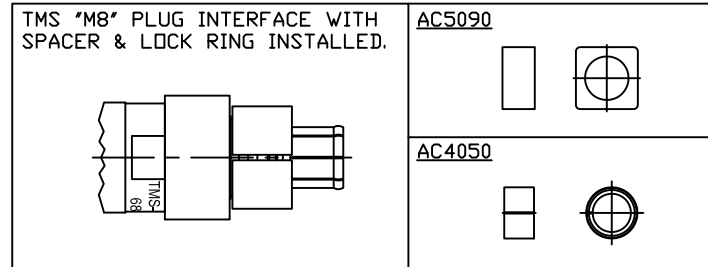
SD18790

SYM	REVISION DESCRIPTION	DFTM	DATE	APPD	DATE
A	RELEASED FOR PRODUCTION	D. J. H.	1/12/17	J. D. B.	1/17/17



NOTES:

- LOCK RING AC4050 IS SUPPLIED WITH THE CONNECTOR AND IS NECESSARY TO HOLD THE CONTACT IN THE MULTI-PORT CONNECTOR SHELL. THE RING IS SUPPLIED INSTALLED WITH SPACER AC5090. REMOVE RING AND SPACER BEFORE INSTALLING IN SHELL. DISCARD SPACER (AC5090).
- INSTALLATION TOOL IN-2964 (AC4319) OR IN-2478 (AC4034) IS REQUIRED FOR ASSEMBLY AND REMOVAL OF THE CONNECTOR IN THE MULTI-PORT CONNECTOR SHELL.



SHRINK BOOT	MIL-DTL-23053/4, CLASS 3 (BLACK)	NONE	013176
DIELECTRICS	TEFLON, ASTM D1710	NONE	
CRIMP SLEEVE	BRASS, ASTM B16	GOLD PLATE, MIL-DTL-45204	W.O. NUMBER
TRANSFER BODY	BRASS, ASTM B16	TRI-METAL PLATE	MATERIAL: SEE TABLE
R.F. BODY	BERYLLIUM COPPER, ASTM B196	GOLD PLATE, MIL-DTL-45204	
CONTACT	BERYLLIUM COPPER, ASTM B196	GOLD PLATE, MIL-DTL-45204	
PART NAME	MATERIAL & SPEC. NUMBER	FINISH & SPEC. NUMBER	

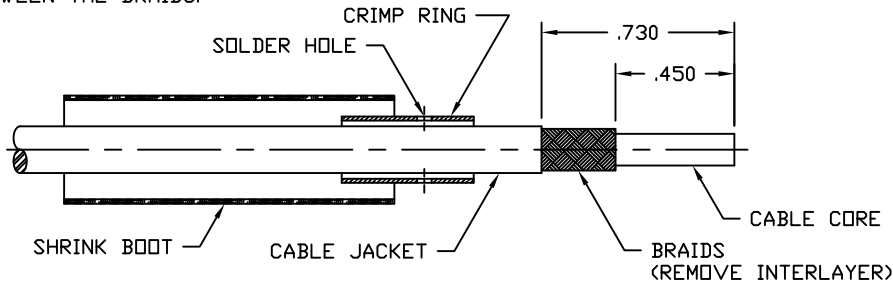
DRAFTSMAN	Dan Hong	1/12/17
CHECKER	John D. Bloomfield	1/17/17
APPROVED	John D. Bloomfield	1/17/17
UNLESS OTHERWISE SPECIFIED		
ALL DIMENSIONS ARE IN INCHES		
MACHINED SURFACES FINISH N/A RMS MAX.		
REMOVE ALL BURRS .005 MAX. BREAK		
MACHINE CORNERS .005 MAX. FILLET R.		
TOLERANCES ON DECIMALS		
.XX ± .03 .XXX ± .005		
ANGLES ± 1° FRACTIONS ± 1/32		
DO NOT SCALE DRAWING		

TIMES MICROWAVE SYSTEMS		
TITLE: CONNECTOR ASSEMBLY FLS-50117M8P-117S FOR CABLE SFT-142		
DWG. SIZE	B	DRWG. NO. SD18790
CODE IDENT.	68999	SCALE: NONE SHEET: 1 of 2

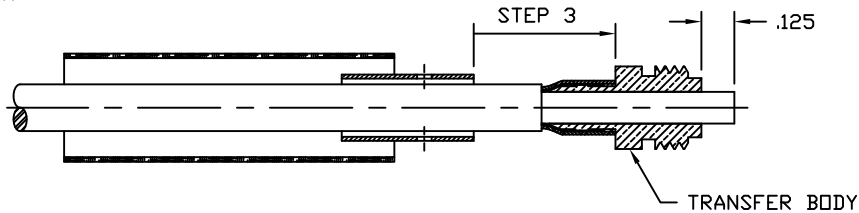
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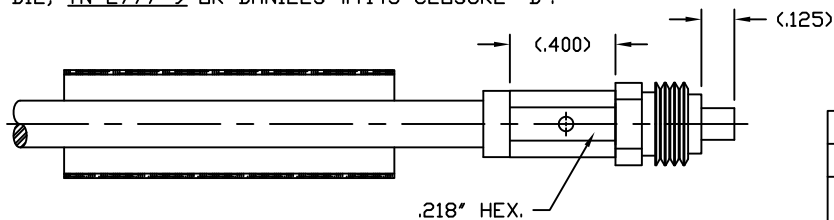
- NOTE THAT THE CONNECTOR ADDS .677" TO THE LENGTH OF THE CABLE. SLIDE THE SHRINK BOOT AND CRIMP RING ONTO THE CABLE. THE SOLDER HOLE ON THE CRIMP RING SHOULD BE CLOSEST TO THE END OF THE CABLE. TRIM THE JACKET AND BRAIDS TO THE DIMENSIONS SHOWN BELOW AND REMOVE THE TAPE BETWEEN THE BRAIDS.



- SLIDE THE TRANSFER BODY OVER THE CABLE CORE AND UNDER THE BRAID UNTIL THERE IS .125" OF CORE PROTRUDING OUT THE FRONT OF THE TRANSFER BODY.



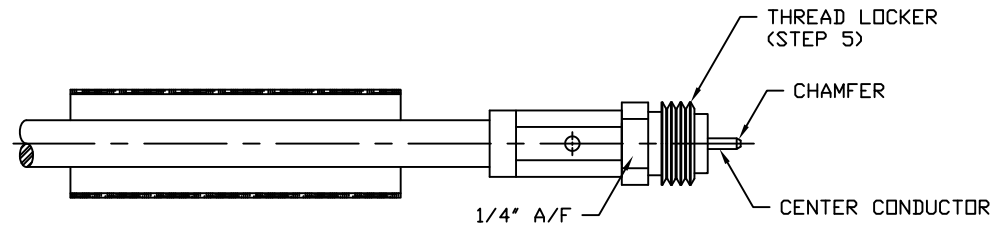
- SLIDE CRIMP RING OVER BRAIDS AND AGAINST TRANSFER BODY SHOULDER. IF NEEDED, TRIM AWAY ANY EXCESS BRAIDS. CHECK FOR .125" PROJECTION. CRIMP THE SLEEVE NEXT TO THE TRANSFER BODY WRENCH FLATS USING .218" HEX DIE, IN-2777-9 OR DANIELS #Y143 CLOSURE "B".



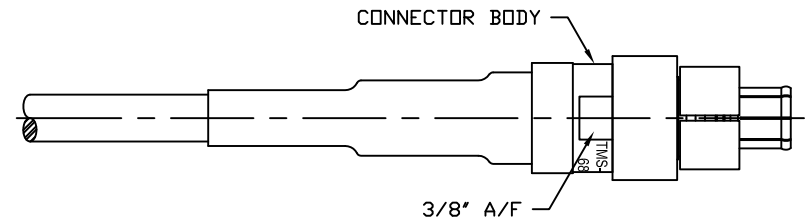
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SYM	REVISION DESCRIPTION	DFTM	DATE	APPD	DATE
A	RELEASED FOR PRODUCTION	D. J. H.	1/12/17	J. D. B.	1/17/17

- TRIM THE CABLE CORE FLUSH WITH THE END OF THE TRANSFER BODY BEING CAREFUL NOT TO NICK THE CABLE CENTER CONDUCTOR. CHAMFER THE END OF THE CENTER CONDUCTOR.



- APPLY THREAD LOCKER TO THE THREADS OF THE TRANSFER BODY AND SCREW ON THE CONNECTOR BODY. TORQUE CONNECTOR BODY AND TRANSFER BODY TO 20 INCH-POUNDS. A 1/4" AND 3/8" WRENCH ARE REQUIRED. SHRINK THE BOOT AS SHOWN.



013176
W.O. NUMBER
MATERIAL:

DRAFTSMAN	Dan Hong	1/12/17
CHECKER	John D. Bloomfield	1/17/17
APPROVED	John D. Bloomfield	1/17/17

UNLESS OTHERWISE SPECIFIED
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TIMES MICROWAVE SYSTEMS		
TITLE: CONNECTOR ASSEMBLY FLS-50117M8P-117S FOR CABLE SFT-142		
DWG. SIZE	B	DRWG. NO. SD18790
CODE IDENT.	68999	SCALE: NONE SHEET: 2 of 2
REV. A		