



NOTE: This procedure is for "SOLDERED PIN" termination of connector 3190-249 on cable MI-54002.

1. Cut cable to Length on the MI. Note that each connector adds .750"
  2. Remove 1.050" of jacket. DO NOT NICK CABLE BRAIDS.
  3. Tape end of braid down with ¼" wide kapton tape.
  4. Thread on back nut until braided core projects .275".
  5. Fold braids back over front of back nut. Braids must be straightened & positioned equally around back nut. Trim them to .060" from start of threads.
  6. Remove core to .015" from folded braids.
  7. Apply xersin 2010 flux & dip 1/2 of way in 60/40 solder for 3 seconds. Do not touch core with solder. Chamfer end of conductor.
  8. Remove flux from core with GENESOLV. Make sure core is perpendicular with center conductor.
  9. Install teflon spacer onto center conductor.
  10. Apply xersin 2010 flux to center conductor. Install center contact onto cable.  
**Note: This step is critical as it determines conn pin height. Center contact must butt teflon spacer.**
- Note: Check pin height: From folded braids to 1st shoulder from front end of pin = 0.550" ± .010"
11. Solder with Large carbon soldering unit. Careful not to melt cable core.
  12. Apply **LOCTITE 242 (BLUE)** to threads. Thread on body. Torque to 50 in-lbs.
  13. Check conn pin height prior to test. Check Pin Depth per TMS 01012A / SMAM 0.000 TO 0.010 BELOW.
  14. To adjust pin height: Remove conn body. Rotate back nut counter-clockwise to lower pin. Re-install conn body.

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