

NOTE: This procedure is for "SOLDERED PIN" termination of connector 3190-213 on cable MI-54003.

1. Cut cable to Length on the MI. Note that each connector adds .800" to Length of assembly.
2. Slide boot, back nut (threaded end on last), flat washer, & gasket, onto cable.
3. Remove 0.625" of jacket. DO NOT NICK OUTER BRAID.
4. Slide clamp ferrule over braid and up against jacket. Large ID on first.
5. Fold braids back over front of ferrule. Do not comb out.
6. Trim braids flush with shoulder of ferrule using small scissors.
7. Remove 0.450" of core from end of cable. Apply xersin 2010 flux & dip 2/3 of way in 60/40 solder for 5 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. Apply Xersin 2010 flux to center conductor. Slide on center contact. Solder in place with high power soldering unit in engineering lab. Feed solder into hole in pin.
10. Slide nut, washer, & gasket up to ferrule.
11. Install body over pin & ferrule.
12. Apply **LOCTITE 242 (BLUE)** to threads. Screw back nut in & torque to 50 in-lbs.
13. Shrink boot 1/2" onto connector per SI-104
14. Check pin height per procedure 01012C / UHF /

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| TIMES MICROWAVE SYSTEMS | CODE I.D. NO. 68999 | CAP - 3190-213 |
| | | SHEET - 2 of 2 |