



ADVANCED TECHNICAL MATERIALS, INC.
 49 Rider Avenue, Patchogue, NY 11772
 Tel: 631 289-0363 Fax: 631 289-0358
<http://www.atmmicrowave.com>

Assembly Instructions NMR-300 Connector

<p>.XXX = ±.005</p>	<p>1.0 PREPARATION OF CABLE:</p> <p>1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER JACKET, INNER CONDUCTOR, & INNER BRAIDS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, OR INNER BRAIDS DURING THIS OPERATION.</p> <p>1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.</p>
	<p>2.0 SOLDERING OF FERRULE TO CABLE OUTER CONDUCTOR:</p> <p>2.1 SLIDE CLAMP NUT ONTO CABLE AS SHOWN BELOW IN STEP 5.0 (ENLARGED VIEW).</p> <p>2.2 TIN INNER BRAIDS OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (CABLE JACKET).</p> <p>2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).</p> <p>2.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.</p>
	<p>3.0 PREPARATION OF CABLE INNER CONDUCTOR:</p> <p>3.1 TRIM DIELECTRIC FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.</p> <p>3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.</p> <p>3.3 INSPECT CABLE PREPARATION.</p>
	<p>4.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:</p> <p>4.1 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST SOLDER FERRULE.</p> <p>4.2 TIN INNER CONDUCTOR OF CABLE. HEAT CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST SHIM.</p> <p>4.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.</p> <p>4.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.</p>
	<p>5.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:</p> <p>5.1 PLACE CABLE / FERRULE SUB-ASSEMBLY INTO THE BACK OF CONNECTOR SUB-ASSEMBLY BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR OR INSULATOR OF CONNECTOR.</p> <p>5.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS. INSPECT INTERFACE DIMENSIONS.</p>
<p>5.0 ENLARGED VIEW OF CABLE ASSEMBLY:</p>	