Instruction Sheets

Anritsu Microwave K Connector®

K101F-R
K101M-R
K101M-085-R
K102F-R
K102M-R
K103F-R
K103M-R
K104F-R
K104M-R
K110-1-R or K110-3-R
K110-2-R
01-104
01-108
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Chinese RoHS Compliance Statement

<table>
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○：表示该有毒有害物质在该部件所有均质材料中的含量均在 SJ/T11363-2006 标准规定的限量要求以下。
×：表示该有毒有害物质至少在该部件的某一均质材料中的含量超出 SJ/T11363-2006 标准规定的限量要求。

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To prevent the risk of personal injury or loss related to equipment malfunction, Anritsu Company uses the following symbols to indicate safety-related information. For your own safety, please read the information carefully before operating the equipment.

Symbols Used in Manuals

Danger

This indicates a risk from a very dangerous condition or procedure that could result in serious injury or death and possible loss related to equipment malfunction. Follow all precautions and procedures to minimize this risk.

Warning

This indicates a risk from a hazardous condition or procedure that could result in light-to-severe injury or loss related to equipment malfunction. Follow all precautions and procedures to minimize this risk.

Caution

This indicates a risk from a hazardous procedure that could result in loss related to equipment malfunction. Follow all precautions and procedures to minimize this risk.

Safety Symbols Used on Equipment and in Manuals

The following safety symbols are used inside or on the equipment near operation locations to provide information about safety items and operation precautions. Ensure that you clearly understand the meanings of the symbols and take the necessary precautions before operating the equipment. Some or all of the following five symbols may or may not be used on all Anritsu equipment. In addition, there may be other labels attached to products that are not shown in the diagrams in this manual.

- This indicates a prohibited operation. The prohibited operation is indicated symbolically in or near the barred circle.

- This indicates a compulsory safety precaution. The required operation is indicated symbolically in or near the circle.

- This indicates a warning or caution. The contents are indicated symbolically in or near the triangle.

- This indicates a note. The contents are described in the box.

- These indicate that the marked part should be recycled.
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K101F-R

Female Connector for K118 Semi-Rigid Coaxial Cable

Tools and Materials

The following tools and materials are needed to install the K101F-R connector on the K118 semirigid coaxial cable. Equivalent tools may be used if recommended tools are not available.

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<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
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<tr>
<td>250 Watt resistance soldering unit with medium tweezers and foot pedal</td>
<td>American Beauty</td>
<td>10504</td>
</tr>
<tr>
<td>Tool kit cable assembly</td>
<td>Anritsu Company</td>
<td>01-118</td>
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<td>0.50 mm diameter solder</td>
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<td>SAC305</td>
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<td>Rosin flux</td>
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<td>Soldering Fixture</td>
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<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
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</table>

Fabrication Instructions

Fabrication instructions for the cable assembly are given below. Refer to Figure 1-1 to identify the connector parts referenced in the procedure.

Figure 1-1. K101F-R Assembly

1. Remove approximately 6.5 mm of the outer conductor from one end of the cable. The outer conductor should be cut square and be free of burrs. A suggested method using the multipurpose tool in the Anritsu 01-118 tool kit follows:
   a. Clamp the multipurpose tool in a vise with the hole facing up.
   b. Insert the end of the semi-rigid cable into the hole as far as it will go.
   c. While pressing the cable against the bottom of the hole and rotating it, cut a deep groove around the circumference of the outer conductor using a razor blade or saw.
   d. Break off the outer conductor and remove it from the cable.
2. Remove the exposed teflon insulation and trim it flush with the outer conductor, taking care not to cut into the center conductor.

3. Cut and trim and deburr the exposed center conductor to 1.27 mm ± 0.15 mm. The “F” gauging hole in the 01-118 tool kit may be used to measure this distance. Be careful not to nick or otherwise damage the center conductor.

4. File the center conductor to a smooth point that tapers approximately 0.5 mm back from the point.

5. Slide the assembly nut onto the cable.

6. Clean the end of the cable with a solvent-dampened swab to remove any oils due to handling.

| Caution | Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon). These compounds may soften or dissolve the PPO/Teflon bead material. |

7. Slide the sleeve onto the cable, as shown in Figure 1-1, and place the solder ring against it.

8. Set the resistance soldering unit from 50% to 60% and grasp the sleeve, applying pressure to keep the sleeve bottomed out on the cable, and solder it square with the cable. Fixture 01-107F is recommended to hold parts while soldering.

9. Inspect the connection to ensure that there are no solder gaps (Figure 1-3) and that the sleeve assembly is square with the cable.

10. Clean any flux residue from the Teflon interface on the inside of the connector housing. A small piece of cotton, dampened in solvent and held by tweezers, works best for this cleaning operation.

11. Inspect the inside of the connector to ensure that the solder seam has no gaps. A 30X microscope is best for this inspection. There should be no evidence of solder on the sleeve inner diameter.

Figure 1-2. 01-107M and 01-107F Soldering Fixtures

Figure 1-3. Examples of Good and Bad Solder Connections
12. Press the center-pin/bead assembly into the sleeve, whereupon, spring-fingers on the pin will connect with the cable center conductor. A recommended method using the 01-118 tool kit’s multipurpose tool (Figure 1-4 on page 1-3) follows:

   a. Slide the assembly-barrel from the tool kit over the sleeve, and screw it into the assembly nut until it is hand-tight.
   
   b. Place the long end of the center-pin/bead assembly into the hole on the female end of the multipurpose tool.
   
   c. Connect the coupling nut on the multipurpose tool with the assembly-barrel and tighten to press the center-pin/bead assembly into the sleeve.
   
   d. Loosen the coupling nut, and remove the multipurpose tool from the end of the cable.
   
   e. Unscrew the assembly-barrel from the assembly nut, and replace it with the outer-conductor barrel from the K101F-R parts bag.
   
   f. Torque the outer-conductor barrel to 1.8 N·m. The 01-105 torquing Tool Kit may be used for this purpose.

13. For best performance, purge residue solvent by placing the completed cable assembly in an oven and baking at 65 °C for eight hours minimum.

**Caution** If solvent is allowed to remain, it may cause increased transmission loss.

<table>
<thead>
<tr>
<th>Index</th>
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<td>B14850</td>
<td>Multipurpose Tool</td>
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<tr>
<td>2</td>
<td>B14850</td>
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<td>3</td>
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<td>Cable Bending Fixture</td>
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<td>6</td>
<td>–</td>
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Figure 1-4. 01-118 Cable Assembly Tool Kit

**Cable Bending Instructions**

Bending instructions for the cable assembly are given below. Bending should not be attempted until connectors are installed on both ends.

1. Center the cable assembly in the 6.35 mm radius bending fixture supplied with the 01-118 tool kit.
2. Clamp the bending fixture into a vise, and tighten only enough to prevent it from slipping.
3. Bend the cable to the shape of the bending fixture.

**Caution** Always use the bending fixture for bending the cable. Do not bend the cable unless connectors are installed on both ends.
**K101M-R**

**Male Connector for K118 Semi-Rigid Coaxial Cable**

**Tools and Materials**
The following tools and materials are needed to install the K101M-R connector on the K118 (3.0 mm) semirigid coaxial cable. Equivalent tools may be used if recommended tools are not available.

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>250 Watt resistance soldering unit with medium tweezers and foot pedal</td>
<td>American Beauty</td>
<td>10504</td>
</tr>
<tr>
<td>Regular tweezer for resistance solderer</td>
<td>American Beauty</td>
<td>10541</td>
</tr>
<tr>
<td>Tool kit cable assembly</td>
<td>Anritsu Company</td>
<td>01-118</td>
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<tr>
<td>0.50 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305</td>
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<td>Rosin flux</td>
<td>Kester Company</td>
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<td>Isopropyl alcohol cleaning fluid</td>
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<tr>
<td>Soldering Fixture</td>
<td>Anritsu Company</td>
<td>01-107M</td>
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</table>

**Fabrication Instructions**

Fabrication instructions for the cable assembly are given below. Refer to Figure 2-1 to identify the connector parts referenced in the procedure.

1. Remove approximately 6.5 mm of the outer conductor from one end of the cable. The outer conductor should be cut square and be free of burrs. A suggested method using the multipurpose tool in the Anritsu 01-118 tool kit (Figure 2-2 on page 2-2) follows:
   a. Clamp the multipurpose tool in a vise with the hole facing up.
   b. Insert the end of the semi-rigid cable into the hole as far as it will go.
   c. While pressing the cable against the bottom of the hole and rotating it, cut a deep groove around the circumference of the outer conductor using a razor blade or saw.
   d. Break off the outer conductor and remove it from the cable.

---

**Figure 2-1. K101M-R Assembly**

- Coupling Nut
- Sealing Gasket
- Center Pin
- Bead
- Coaxial Cable
- Snap Ring
- Bead
- Sleeve Assembly
- Center Pin
2. Trim the Teflon away from the center conductor, taking care not to cut into the center conductor. The trimming of the Teflon must be flush with the outer conductor to properly install the center pin later in this procedure.

3. Cut, trim, and deburr the exposed center conductor to 2.286 mm ± 0.15 mm. The end of the 01-118 multipurpose tool marked “M” can be used to measure this distance. Be careful not to nick or otherwise damage the center conductor.

4. Clamp the cable, and, using a soldering iron, tin the exposed center conductor.

5. Set the Resistance Soldering Unit to 20% to 30% with the regular tweezer.

6. Heat the center pin and slide it onto the center conductor, locating it flush with the Teflon dielectric. Avoid getting solder on the outside of the pin.

7. Clean the center pin with a solvent-dampened swab to remove all flux residue.

8. Clean the end of the cable with a solvent dampened swab to remove any oils due to handling.

9. Apply a small amount of flux to the end of the cable.

10. Orient the sleeve assembly so that the smaller end is positioned over the end of the cable.

11. Slide the sleeve assembly onto the cable until it reaches the bottom limit of the sleeve. When properly positioned, the center pin will protrude as shown in Figure 2-1, and the sleeve will cover approximately 3.5 mm of the cable. Check pin extension.

12. Install the 01-107M Soldering Fixture onto the end of the cable. This will hold the sleeve assembly secure and will also keep it square while it is being soldered onto the cable.
13. Set the Resistance Soldering Unit to 50% to 60% with the medium tweezer.

14. Grasp the sleeve assembly with the soldering tongs and apply solder to the back end of the sleeve to solder it to the cable. Ensure that the sleeve assembly does not move on the cable during this operation.

15. Inspect the connection to ensure that there are no solder gaps and that the sleeve assembly is square with the cable.

16. Remove the 01-107M Soldering Fixture.

17. Clean any residue flux from the Teflon interface located on the inside of the connector housing. A small piece of cotton, dampened in solvent and held by tweezers, works best for this cleaning operation.

18. Inspect the inside of the connector to ensure that the solder seam has no gaps. A 30X microscope is best for this inspection. Also, ensure that the pin extension is 1.524 ± 0.15 mm.

19. Spread the snap-ring and slip it onto the groove of the sleeve assembly.

20. Place the sealing gasket over the large end of the sleeve assembly. It should fit snugly against the shoulder of the sleeve assembly.

21. Using the snap-ring pliers—or other suitable pliers—compress the snap-ring and slip the assembly into the coupling nut. When the assembly is positioned properly, the snap-ring will “click” into place as it fits into the groove inside the coupling nut.

22. Carefully slide the bead over the center pin, and press it into the end of the sleeve assembly. The multipurpose tool in the 01-118 tool kit should be used to press the bead into place. The center pin should not be pushed back during this operation.

23. Inspect the cable assembly to ensure the following:
   a. That the support bead is flush with or slightly recessed from the end of the sleeve assembly.
   b. That the center pin extends out from the bead as shown in Figure 2-1.
24. For best performance, purge residue solvent by placing the completed cable assembly in an oven and baking at 65 °C for eight hours minimum.

| Caution         | If solvent is allowed to remain, it may cause increased transmission loss. |

**Cable Bending Instructions**

Bending instructions for the cable assembly are given below. Bending should not be attempted until connectors are installed on both ends.

1. Center the cable assembly in the 6.35 mm radius bending fixture supplied with the 01-118 tool kit.
2. Clamp the bending fixture into a vise, and tighten only enough to prevent it from slipping.
3. Bend the cable to the shape of the bending fixture.

| Caution         | Always use the bending fixture for bending the cable. Do not bend the cable unless connectors are installed on both ends. |
K101M-085-R

Male Connector for V085 Semi-Rigid Coaxial Cable

Tools and Materials
The following tools and materials are needed to install the K101M-085-R connector on the V085 (2.18 mm outer diameter) semirigid coaxial cable. Equivalent tools may be used if recommended tools are not available.

Table 3-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
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<td>American Beauty</td>
<td>10504</td>
</tr>
<tr>
<td>Regular tweezer for resistance solderer</td>
<td>American Beauty</td>
<td>10541</td>
</tr>
<tr>
<td>Tool kit cable assembly</td>
<td>Anritsu Company</td>
<td>SC5296</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305</td>
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<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
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<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
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</tr>
<tr>
<td>Soldering Fixture</td>
<td>Anritsu Company</td>
<td>01-107M</td>
</tr>
</tbody>
</table>

Fabrication Instructions
Fabrication instructions for the cable assembly are given below. Refer to Figure 3-1 to identify the connector parts referenced in the procedure.

Figure 3-1. K101M-085-R Assembly

1. Remove approximately 6.5 mm of the outer conductor from one end of the cable. The outer conductor should be cut square and be free of burrs. A suggested method using the multipurpose tool in the Anritsu SC5296 tool kit (Figure 3-2 on page 3-2) follows:
   a. Clamp the multipurpose tool in a vise with the hole facing up.
   b. Insert the end of the semi-rigid cable into the hole as far as it will go.
   c. While pressing the cable against the bottom of the hole and rotating it, cut a deep groove around the circumference of the outer conductor using a razor blade or saw.
   d. Break off the outer conductor and remove it from the cable.
2. Trim the Teflon away from the center conductor, taking care not to cut into the center conductor. The trimming of the Teflon must be flush with the outer conductor to properly install the center pin later in this procedure.

3. Cut, trim, and deburr the exposed center conductor to 2.3 mm ± 0.15 mm. The end of the SC5296 multipurpose tool marked “M” can be used to measure this distance. Be careful not to nick or otherwise damage the center conductor.

4. Clamp the cable, and, using a soldering iron, tin the exposed center conductor.

5. Set the Resistance Soldering Unit to 20% to 30% with the regular tweezer.

6. Heat the center pin and slide it onto the center conductor, locating it flush with the Teflon dielectric. Avoid getting solder on the outside of the pin.

7. Clean the center pin with a solvent-dampened swab to remove all flux residue.

Caution
Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon). These compounds may soften or dissolve the PPO/Teflon bead material.

8. Clean the end of the cable with a solvent dampened swab to remove any oils due to handling.

9. Apply a small amount of flux to the end of the cable.

10. Orient the sleeve assembly so that the smaller end is positioned over the end of the cable.

11. Slide the sleeve assembly onto the cable until it reaches the bottom limit of the sleeve. When properly positioned, the center pin will protrude as shown in Figure 3-1, and the sleeve will cover approximately 4.76 mm of the cable. Check pin extension.

12. Install the 01-107M Soldering Fixture onto the end of the cable. This will hold the sleeve assembly secure and will also keep it square while it is being soldered onto the cable.

13. Set the Resistance Soldering Unit to 50% to 60% with the medium tweezer.
14. Grasp the sleeve assembly with the soldering tongs and apply solder to the back end of the sleeve to solder it to the cable. Ensure that the sleeve assembly does not move on the cable during this operation.

15. Inspect the connection to ensure that there are no solder gaps and that the sleeve assembly is square with the cable.

16. Remove the 01-107M Soldering Fixture.

17. Clean any residue flux from the Teflon interface located on the inside of the connector housing. A small piece of cotton, dampened in solvent and held by tweezers, works best for this cleaning operation.

18. Inspect the inside of the connector to ensure that the solder seam has no gaps. A 30X microscope is best for this inspection. Also, ensure that the pin extension is 1.524 ± 0.15 mm.

19. Spread the snap-ring and slip it onto the groove of the sleeve assembly.

20. Place the sealing gasket over the large end of the sleeve assembly. It should fit snugly against the shoulder of the sleeve assembly.

21. Using the snap-ring pliers—or other suitable pliers—compress the snap-ring and slip the assembly into the coupling nut. When the assembly is positioned properly, the snap-ring will “click” into place as it fits into the groove inside the coupling nut.

22. Carefully slide the bead over the center pin, and press it into the end of the sleeve assembly. The multipurpose tool in the SC5296 tool kit should be used to press the bead into place. The center pin should not be pushed back during this operation.

23. Inspect the cable assembly to ensure the following:
   a. That the support bead is flush with or slightly recessed from the end of the sleeve assembly.
   b. That the center pin extends out from the bead as shown in Figure 3-1. For best performance, purge residue solvent by placing the completed cable assembly in an oven and baking at 65 °C for eight hours minimum.

Caution  If solvent is allowed to remain, it may cause increased transmission loss.

Cable Bending Instructions

Bending instructions for the cable assembly are given below. Bending should not be attempted until connectors are installed on both ends.

1. Use any suitable mandrel with a minimum radius of 6.35 mm for a bending fixture.

2. Hold the cable securely against the mandrel while bending the cable to shape.

Caution  Always use a suitable mandrel for bending the cable. Do not bend the cable unless connectors are installed on both ends.
K102F-R

Microstrip to K Female Sparkplug Mount Connector

Tools and Materials

The following tools and materials are needed to install the K102F-R Sparkplug Mount Connector in a mounting hole on a housing. Equivalent tools may be used if the recommended tools are not available.

Table 4-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thermolyne micro hot plate</td>
<td>Baxter Scientific Products</td>
<td>H2155</td>
</tr>
<tr>
<td>Step drill kit</td>
<td>Anritsu Company</td>
<td>01-104 or 01-108</td>
</tr>
<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
</tr>
<tr>
<td>Glass bead holding fixture</td>
<td>Anritsu Company</td>
<td>01-103</td>
</tr>
<tr>
<td>Glass bead</td>
<td>Advanced Technology Group Inc.</td>
<td>K100/K100B</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305 or AuSn</td>
</tr>
<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
</tr>
<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
<td>any</td>
</tr>
</tbody>
</table>

Machining Dimensions

Machining dimensions for the mounting hole required for installation of the microstrip to K female sparkplug mount connector are provided in Figure 4-1 below.

For machining instructions, refer to the 01-104 or 01-108 instruction sheet.

Caution

The four holes shown in Note 2 of Figure 4-1 must be concentric within ± 0.038 mm. If they are not, connector performance will be degraded. To make this required concentricity easier to achieve, custom made drill-bit kits, Models 01-104 and 01-108, are available from Anritsu.

Notes:

1. All dimensions are in mm (millimeters).
2. The concentricity of the 1.676, 1.981 and 5.664 holes to the 0.711 hole is critical and must be held within ± 0.038 mm.
3. With the Model 01-104 and 01-108 Step Drill Kits, all of the required concentric holes can be machined at the same time using a single bit. Use the 01-108 kit if the K110 series Stress Relief contact is going to be used.
4. The numbers in parentheses apply when the K110 series Stress Relief Contact is used.

* Dimension is 0.152 (Pin Radius)
+ Substrate thickness
+ Solder thickness
* 0.038 (only if K110 series sliding contact is used)

Figure 4-1. K102F-R Machining Dimensions for the Sparkplug Connector Mounting Holes
Fabrication Instructions

Fabrication instructions for the connector assembly are given below. Refer to Figure 4-2 to identify the connector parts referenced in the procedure.

1. Install the microstrip into the housing (see Figure 4-3 for dimensional tolerances around the glass bead).
2. Set the hot plate to 235 °C ± 10 °C for SAC305, or 310 °C ± 10 °C for AuSn solder.
3. Apply flux to the glass bead and insert it, long-end first, into the 01-103 Glass Bead Holding Fixture (Figure 4-3).

4. Using the holding fixture to handle the bead, screw the bead into the mounting hole opening until the center conductor protrudes through the backside interface and contacts the microstrip.
5. Insert a length of solder into the soldering access hole and cut it flush with the top of the hole.
6. Place the device on the hot plate and leave it there for approximately 15 seconds after the solder melts.
7. Remove the device from the hot plate and allow it to cool.
8. If a sliding contact is not used, bond or solder the center conductor to the microstrip. Use a minimum amount of solder. If a sliding contact is used, refer to the sliding contact instruction sheet.
9. Remove the glass support bead holding fixture, and clean the device to remove any flux residue.

Caution

Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon.). These compounds may soften or dissolve the PPO/Teflon bead material in the center pin support bead.

10. Screw the sparkplug assembly into the tapped mounting hole and torque to 1.7 N·m to 2.0 N·m using the 01-105A torquing tool kit.
K102M-R

Microstrip to K Male Sparkplug Launcher Connector

Tools and Materials

The following tools and materials are needed to install the K102M-R Sparkplug Launcher Connector in a mounting hole on a housing. Equivalent tools may be used if the recommended tools are not available.

Table 5-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thermolyne micro hot plate</td>
<td>Baxter Scientific Products</td>
<td>H2155</td>
</tr>
<tr>
<td>Step drill kit</td>
<td>Anritsu Company</td>
<td>01-104 or 01-108</td>
</tr>
<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
</tr>
<tr>
<td>Glass bead holding fixture</td>
<td>Anritsu Company</td>
<td>01-103</td>
</tr>
<tr>
<td>Glass bead</td>
<td>Advanced Technology Group Inc.</td>
<td>K100/K100B</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305 or AuSn</td>
</tr>
<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
</tr>
<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
<td>any</td>
</tr>
</tbody>
</table>

Machining Dimensions

Machining dimensions for the mounting hole required for installation of the microstrip to K male sparkplug launcher connector are provided in Figure 5-1 below.

For machining instructions, refer to the 01-104 or 01-108 instruction sheet.

Caution

The four holes shown in Note 2 of Figure 5-1 must be concentric within ± 0.038 mm. If they are not, connector performance will be degraded. To make this required concentricity easier to achieve, custom made drill-bit kits, Models 01-104 and 01-108, are available from Anritsu.

Notes:
1. All dimensions are in mm (millimeters).
2. The concentricity of the 1.676, 1.981 and 5.664 holes to the 0.711 hole is critical and must be held within ± 0.038 mm.
3. With the Model 01-104 and 01-108 Step Drill Kits, all of the required concentric holes can be machined at the same time using a single bit. Use the 01-108 kit if the K110 series Stress Relief contact is going to be used.
4. The numbers in parentheses apply when the K110 series Stress Relief Contact is used.
   * Dimension is 0.152 (Pin Radius)
   + Substrate thickness
   + Solder thickness
   + 0.038 (only if K110 series sliding contact is used)

Figure 5-1. K102M-R Machining Dimensions for the Sparkplug Launcher Mounting Holes
Fabrication Instructions

Fabrication instructions for the connector assembly are given below. Refer to Figure 5-2 to identify the connector parts referenced in the procedure.

---

1. Install the microstrip into the housing (see Figure 5-3 for dimensional tolerances around the glass bead).
2. Set the hot plate to 235 °C ± 10 °C for SAC305, or 310 °C ± 10 °C for AuSn solder.
3. Flux the glass bead and insert it, long-end first, into the 01-103 Glass Bead Holding Fixture (Figure 5-3).
4. Using the holding fixture to handle the bead, screw the bead into the mounting hole opening until the center conductor protrudes through the backside interface and contacts the microstrip.
5. Insert a length of solder into the soldering access hole and cut it flush with the top of the hole.
6. Place the device on the hot plate and leave it there for approximately 15 seconds after the solder melts.
7. Remove the device from the hot plate and allow it to cool.
8. If a sliding contact is not used, bond or solder the center conductor to the microstrip. Use a minimum amount of solder. If a sliding contact is used, refer to the sliding contact instruction sheet.
9. Remove the glass support bead holding fixture and clean the device to remove any flux residue.
10. Screw the sparkplug assembly into the tapped mounting hole and torque to 1.7 N· m to 2.0 N· m using the 01-105A torquing tool kit.

---

Caution
Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon.). These compounds may soften or dissolve the PPO/Teflon bead material in the center pin support bead.

---

Figure 5-2. K102M-R Assembly (*Glass Bead not supplied)

Figure 5-3. K102M-R Glass Bead Assembly
K103F-R

Microstrip to K Female Flange Mount Connector

Tools and Materials

The following tools and materials are needed to install the K103F-R Flange Mount Connector in a mounting hole on a housing. Equivalent tools may be used if the recommended tools are not available.

Table 6-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thermolyne micro hot plate</td>
<td>Baxter Scientific Products</td>
<td>H2155</td>
</tr>
<tr>
<td>Step drill kit</td>
<td>Anritsu Company</td>
<td>01-104 or 01-108</td>
</tr>
<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
</tr>
<tr>
<td>Glass bead holding fixture</td>
<td>Anritsu Company</td>
<td>01-106</td>
</tr>
<tr>
<td>Glass bead</td>
<td>Advanced Technology Group Inc.</td>
<td>K100/K100B</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305 or AuSn</td>
</tr>
<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
</tr>
<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
<td>any</td>
</tr>
</tbody>
</table>

Machining Dimensions

Machining dimensions for the mounting hole required for installation of the microstrip to K female flange mount connector are provided in Figure 6-1 below.

For machining instructions, refer to the 01-104 or 01-108 instruction sheet.

Caution

The three holes shown in Note 2 of Figure 6-1 must be concentric within ± 0.038 mm. If they are not, connector performance will be degraded. To make this required concentricity easier to achieve, custom made drill-bit kits, Models 01-104 and 01-108, are available from Anritsu.

Notes:

1. All dimensions are in mm (millimeters).
2. The concentricity of the 1.876 and 1.981 holes to the 0.711 hole is critical and must be held within ± 0.038 mm.
3. With the Model 01-104 and 01-108 Step Drill Kits, all of the required concentric holes can be machined at the same time using a single bit. Use the 01-108 kit if the K110 series Stress Relief contact is going to be used.
4. The numbers in parentheses apply when the K110 series Stress Relief Contact is used.
5. For K103F-R and K103M-R two-hole flange mount connectors, the horizontal orientation of the flange mounting-screw holes is shown for information only. In practice, the mounting hole pattern may be rotated as needed to any position (except for vertical to avoid the solder access hole).

* Dimension is 0.152 (Pin Radius)
+ Substrate thickness
+ Solder thickness
+ 0.038 (only if K110 series sliding contact is used)

Figure 6-1. K103F-R Machining Dimensions for the Flange Mount Connector Mounting Holes
Fabrication Instructions

Fabrication instructions for the cable assembly are given below. Refer to Figure 6-2 to identify the connector parts referenced in the procedure.

1. Install the microstrip into the housing (see Figure 6-3 for dimensional tolerances around the glass bead).
2. Set the hot plate to 235 °C ± 10 °C for SAC305, or 310 °C ± 10 °C for AuSn solder.
3. Flux the glass bead and insert it, long-end first, into the 01-106 Glass Bead Holding Fixture (Figure 6-3).
4. Using the holding fixture to handle the bead, slide the bead into the mounting hole opening until the center conductor protrudes through the backside interface and contacts the microstrip.
5. Secure the holding fixture in place by using the spring clip furnished with the fixture (Figure 6-3). Position the spring clip so as not to obstruct the solder access hole in the housing. Ensure that the glass bead is centered and that it is making good contact with the microstrip.
6. Insert a length of solder into the soldering access hole and cut it flush with the top of the hole.
7. Place the device on the hot plate and leave it there for approximately 15 seconds after the solder melts.
8. Remove the device from the hot plate and allow it to cool.
9. If a sliding contact is not used, bond or solder the center conductor to the microstrip. Use a minimum amount of solder. If a sliding contact is used, refer to the sliding contact instruction sheet.
10. Remove the glass support bead holding fixture and clean the device to remove any flux residue.

Caution
Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon.). These compounds may soften or dissolve the PPO/Teflon bead material in the center pin support bead.

11. Install the K103F-R flanged connector onto the housing. Make sure that center conductor mates properly with the glass bead center pin. Secure the connector with two 2-56 or two 2.2 mm screws (if a metric thread is used). When tightening the screws, use care to keep the flange parallel to the housing.
K103M-R

Microstrip to K Male Flange Mount Connector

Tools and Materials

The following tools and materials are needed to install the K103M-R Flange Mount Connector in a mounting hole on a housing. Equivalent tools may be used if the recommended tools are not available.

Table 7-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
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<th>Model/Part Number</th>
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<tbody>
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<tr>
<td>Step drill kit</td>
<td>Anritsu Company</td>
<td>01-104 or 01-108</td>
</tr>
<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
</tr>
<tr>
<td>Glass bead holding fixture</td>
<td>Anritsu Company</td>
<td>01-106</td>
</tr>
<tr>
<td>Glass bead</td>
<td>Advanced Technology Group Inc.</td>
<td>K100/K100B</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305 or AuSn</td>
</tr>
<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
</tr>
<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
<td>any</td>
</tr>
</tbody>
</table>

Machining Dimensions

Machining dimensions for the mounting hole required for installation of the microstrip to K male flange mount connector are provided in Figure 7-1 below.

For machining instructions, refer to the 01-104 or 01-108 instruction sheet.

Caution

The three holes shown in Note 2 of Figure 7-1 must be concentric within ± 0.038 mm. If they are not, connector performance will be degraded. To make this required concentricity easier to achieve, custom made drill-bit kits, Models 01-104 and 01-108, are available from Anritsu.

Figure 7-1. K103M-R Machining Dimensions for the Flange Mount Connector Mounting Holes
Fabrication Instructions

Fabrication instructions for the cable assembly are given below. Refer to Figure 7-2 to identify the connector parts referenced in the procedure.

1. Install the microstrip into the housing (see Figure 7-3 for dimensional tolerances around the glass bead).
2. Set the hot plate to 235 °C ± 10 °C for SAC305, or 310 °C ± 10 °C for AuSn solder.
3. Flux the glass bead and insert it, long-end first, into the 01-103 Glass Bead Holding Fixture (Figure 7-3).
4. Using the holding fixture to handle the bead, slide the bead into the mounting hole opening until the center conductor protrudes through the backside interface and contacts the microstrip.
5. Secure the holding fixture in place by using the spring clip furnished with the fixture (Figure 7-3). Position the spring clip so as not to obstruct the solder access hole in the housing. Ensure that the glass bead is centered and that it is making good contact with the microstrip.
6. Insert a length of solder into the soldering access hole and cut it flush with the top of the hole.
7. Place the device on the hot plate and leave it there for approximately 15 seconds after the solder melts.
8. Remove the device from the hot plate and allow it to cool.
9. If a sliding contact is not used, bond or solder the center conductor to the microstrip. Use a minimum amount of solder. If a sliding contact is used, refer to the sliding contact instruction sheet.
10. Remove the glass support bead holding fixture and clean the device to remove any flux residue.

Caution
Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon.). These compounds may soften or dissolve the PPO/Teflon bead material in the center pin support bead.

11. Install the K103M-R flanged connector onto the housing. Make sure that center conductor mates properly with the glass bead center pin. Secure the connector with two 2-56 or two 2.2 mm screws (if a metric thread is used). When tightening the screws, use care to keep the flange parallel to the housing.
K104F-R

Microstrip to K Female Flange Mount Connector

Tools and Materials

The following tools and materials are needed to install the K104F-R Flange Mount Connector in a mounting hole on a housing. Equivalent tools may be used if the recommended tools are not available.

Table 8-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
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<tbody>
<tr>
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<td>Baxter Scientific Products</td>
<td>H2155</td>
</tr>
<tr>
<td>Step drill kit</td>
<td>Anritsu Company</td>
<td>01-104 or 01-108</td>
</tr>
<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
</tr>
<tr>
<td>Glass bead holding fixture</td>
<td>Anritsu Company</td>
<td>01-106</td>
</tr>
<tr>
<td>Glass bead</td>
<td>Advanced Technology Group Inc.</td>
<td>K100/K100B</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305 or AuSn</td>
</tr>
<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
</tr>
<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
<td>any</td>
</tr>
</tbody>
</table>

Machining Dimensions

Machining dimensions for the mounting hole required for installation of the microstrip to K female flange mount connector are provided in Figure 8-1 below.

For machining instructions, refer to the 01-104 or 01-108 instruction sheet.

Caution

The three holes shown in Note 2 of Figure 8-1 must be concentric within ± 0.038 mm. If they are not, connector performance will be degraded. To make this required concentricity easier to achieve, custom made drill-bit kits, Models 01-104 and 01-108, are available from Anritsu.

Figure 8-1. K104F-R Machining Dimensions for the Flange Mount Connector Mounting Holes

Notes:
1. All dimensions are in mm (millimeters).
2. The concentricity of the 1.676 and 1.981 holes to the 0.711 hole is critical and must be held within ± 0.038 mm.
3. With the Model 01-104 and 01-108 Step Drill Kits, all of the required concentric holes can be machined at the same time using a single bit. Use the 01-108 kit if the K110 series Stress Relief contact is going to be used.
4. The numbers in parentheses apply when the K110 series Stress Relief Contact is used.

* Dimension is 0.152 (Pin Radius)
+ Substrate thickness
+ Solder thickness
+ 0.038 (only if K110 series sliding contact is used)
Fabrication Instructions

Fabrication instructions for the cable assembly are given below. Refer to Figure 8-2 to identify the connector parts referenced in the procedure.

1. Install the microstrip into the housing (see Figure 8-3 for dimensional tolerances around the glass bead).
2. Set the hot plate to 235 °C ± 10 °C for SAC305, or 310 °C ± 10 °C for AuSn solder.
3. Flux the glass bead and insert it, long-end first, into the 01-103 Glass Bead Holding Fixture (Figure 8-3).
4. Using the holding fixture to handle the bead, slide the bead into the mounting hole opening until the center conductor protrudes through the backside interface and contacts the microstrip.
5. Secure the holding fixture in place by using the spring clip furnished with the fixture (Figure 8-3). Position the spring clip so as not to obstruct the solder access hole in the housing. Ensure that the glass bead is centered and that it is making good contact with the microstrip.
6. Insert a length of solder into the soldering access hole and cut it flush with the top of the hole.
7. Place the device on the hot plate and leave it there for approximately 15 seconds after the solder melts.
8. Remove the device from the hot plate and allow it to cool.
9. If a sliding contact is not used, bond or solder the center conductor to the microstrip. Use a minimum amount of solder. If a sliding contact is used, refer to the sliding contact instruction sheet.
10. Remove the glass support bead holding fixture and clean the device to remove any flux residue.

Caution
Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon.). These compounds may soften or dissolve the PPO/Teflon bead material in the center pin support bead.

11. Install the K104F-R flanged connector onto the housing. Make sure that center conductor mates properly with the glass bead center pin. Secure the connector with four 2-56 or four 2.2 mm screws (if a metric thread is used). When tightening the screws, use care to keep the flange parallel to the housing.
K104M-R Microstrip to K Male Flange Mount Connector

Tools and Materials
The following tools and materials are needed to install the K104M-R Flange Mount Connector in a mounting hole on a housing. Equivalent tools may be used if the recommended tools are not available.

Table 9-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thermolyne micro hot plate</td>
<td>Baxter Scientific Products</td>
<td>H2155</td>
</tr>
<tr>
<td>Step drill kit</td>
<td>Anritsu Company</td>
<td>01-104 or 01-108</td>
</tr>
<tr>
<td>Connector torquing tool kit</td>
<td>Anritsu Company</td>
<td>01-105A</td>
</tr>
<tr>
<td>Glass bead holding fixture</td>
<td>Anritsu Company</td>
<td>01-106</td>
</tr>
<tr>
<td>Glass bead</td>
<td>Advanced Technology Group Inc.</td>
<td>K100/K100B</td>
</tr>
<tr>
<td>0.50 mm to 0.65 mm diameter solder</td>
<td>Kester Company</td>
<td>SAC305 or AuSn</td>
</tr>
<tr>
<td>Rosin flux</td>
<td>Kester Company</td>
<td>135</td>
</tr>
<tr>
<td>Isopropyl alcohol cleaning fluid</td>
<td>any</td>
<td>any</td>
</tr>
</tbody>
</table>

Machining Dimensions
Machining dimensions for the mounting hole required for installation of the microstrip to K male flange mount connector are provided in Figure 9-1 below.

For machining instructions, refer to the 01-104 or 01-108 instruction sheet.

Caution
The three holes shown in Note 2 of Figure 9-1 must be concentric within ± 0.038 mm. If they are not, connector performance will be degraded. To make this required concentricity easier to achieve, custom made drill-bit kits, Models 01-104 and 01-108, are available from Anritsu.

Notes:
1. All dimensions are in mm (millimeters).
2. The concentricity of the 1.676 and 1.981 holes to the 0.711 hole is critical and must be held within ± 0.038 mm.
3. With the Model 01-104 and 01-108 Step Drill Kits, all of the required concentric holes can be machined at the same time using a single bit. Use the 01-108 kit if the K110 series Stress Relief contact is going to be used.
4. The numbers in parentheses apply when the K110 series Stress Relief Contact is used.

* Dimension is 0.152 (Pin Radius)
+ Substrate thickness
  + Solder thickness
  + 0.038 (only if K110 series sliding contact is used)
Fabrication Instructions

Fabrication instructions for the cable assembly are given below. Refer to Figure 9-2 to identify the connector parts referenced in the procedure.

1. Install the microstrip into the housing (see Figure 9-3 for dimensional tolerances around the glass bead).
2. Set the hot plate to 235 °C ± 10 °C for SAC305, or 310 °C ± 10 °C for AuSn solder.
3. Flux the glass bead and insert it, long-end first, into the 01-106 Glass Bead Holding Fixture (Figure 9-3).
4. Using the holding fixture to handle the bead, slide the bead into the mounting hole opening until the center conductor protrudes through the backside interface and contacts the microstrip.
5. Secure the holding fixture in place by using the spring clip furnished with the fixture (Figure 9-3). Position the spring clip so as not to obstruct the solder access hole in the housing. Ensure that the glass bead is centered and that it is making good contact with the microstrip.
6. Insert a length of solder into the soldering access hole and cut it flush with the top of the hole.
7. Place the device on the hot plate and leave it there for approximately 15 seconds after the solder melts.
8. Remove the device from the hot plate and allow it to cool.
9. If a sliding contact is not used, bond or solder the center conductor to the microstrip. Use a minimum amount of solder. If a sliding contact is used, refer to the sliding contact instruction sheet.
10. Remove the glass support bead holding fixture and clean the device to remove any flux residue.

Caution

Avoid cleaning fluids containing halogenated and aromatic hydrocarbons (Freon). These compounds may soften or dissolve the PPO/Teflon bead material in the center pin support bead.

11. Install the K104M-R flanged connector onto the housing. Make sure that center conductor mates properly with the glass bead center pin. Secure the connector with four 2-56 or four 2.2 mm screws (if a metric thread is used). When tightening the screws, use care to keep the flange parallel to the housing.
K110-1-R or K110-3-R

Sliding Contacts for Alumina and Duroid Microstrip

Tools and Materials

The following tools and materials are recommended to install the K110-1-R or K110-3-R Sliding Contacts on the pin of a glass bead. Equivalent tools may be used if the recommended tools are not available.

Table 10-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Parallel-Gap Welder and Pulse Bonder</td>
<td>Hughes</td>
<td>WCW550 with VTA-90 Head</td>
</tr>
<tr>
<td>Step drill and tap set</td>
<td>Anritsu Company</td>
<td>01-108</td>
</tr>
<tr>
<td>Jewelers screwdriver</td>
<td>any</td>
<td>any</td>
</tr>
<tr>
<td>Tweezers</td>
<td>any</td>
<td>any</td>
</tr>
<tr>
<td>Solder</td>
<td>Indium Corporation</td>
<td>#183 (88Au 12Ge)</td>
</tr>
</tbody>
</table>

Machining Dimensions

The following list provides references to the mounting hole dimensions required for installation of the K Connector assemblies when using K110-1-R or K110-3-R sliding contacts. The dimensions shown in parentheses in the figures should be followed when sliding contacts are used.

- **K102F-R**: Figure 4-1 on page 4-1
- **K102M-R**: Figure 5-1 on page 5-1
- **K103F-R**: Figure 6-1 on page 6-1
- **K103M-R**: Figure 7-1 on page 7-1
- **K104F-R**: Figure 8-1 on page 8-1
- **K104M-R**: Figure 9-1 on page 9-1

The precision step drill listed in Table 10-1 makes it easier to achieve concentricity of the respective three or four holes required for the K102F-R, K102M-R, K103F-R, K103M-R, K104F-R, and K104M-R installation.

Fabrication Instructions

The sliding contacts slip over the pin of the glass bead and mate with the microcircuit as shown in Figure 10-1 on page 10-2. The following is the recommended procedure for installing the sliding contacts and mating them with the microcircuit.

2. Check that the center pin in the glass bead is level with the top of the microcircuit ±0.051 mm. If necessary, bend the pin to achieve this degree of levelness.
3. Using the tweezers:
   a. Remove one of the K110-1-R or K110-3-R Sliding Contacts from the package.
   b. With the sleeve-end facing the pin on the glass bead, lay the K110-1-R or K110-3-R on the microcircuit near the bead.
4. Using the tip of the jewelers screwdriver, gently press the K110-1-R or K110-3-R tab both down onto the microcircuit and in toward the glass bead.
5. Position the sleeve as shown in Figure 10-1.

6. For optimum RF performance, position the sliding contacts dynamically on the center pin as follows:
   a. Ensure that the tab makes good electrical contact with the microcircuit.
   b. Measure the SWR (return loss) of the connection.
   c. Slide the sliding contact in and out in small increments until the RF performance is optimized.

7. If the sleeve on the K110-1-R or K110-3-R should become slightly malformed during the above operation, reform it using the tweezers. However, ensure that it still makes firm contact with the bead pin.

8. Attach the tab on the K110-1-R or K110-3-R to the microcircuit by any of the following three methods:
   a. Soldering: For thin-film microcircuits, use Indium solder #183 to prevent the leaching of gold from the microcircuit. For other types, use any acceptable solder.
   b. TC Bonding: Use ultrasonic or pulse bonding. Ensure that the tab firmly contacts the microcircuit for best RF performance.
   c. Parallel-Gap Welding: Use a tip that is approximately the same size as the tab (0.203 mm). Optimize the voltage, duration, and weight for a strong weld.

Caution Use a minimum amount of solder to prevent the sleeve from becoming soldered to the pin.

Figure 10-1. K110-1-R or K110-3-R Sliding Contact Assembly
K110-2-R

Sliding Contact for Stripline

Tools and Materials

The following tools and materials are recommended to install the K110-2-R Sliding Contacts on the pin of a glass bead. Equivalent tools may be used if the recommended tools are not available.

Table 11-1. Tools and Materials

<table>
<thead>
<tr>
<th>Description</th>
<th>Vendor</th>
<th>Model/Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Parallel-Gap Welder and Pulse Bonder</td>
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<td>any</td>
</tr>
<tr>
<td>Solder</td>
<td>Indium Corporation</td>
<td>#183 (88Au 12Ge)</td>
</tr>
</tbody>
</table>

Machining Dimensions

The following list provides references to the mounting hole dimensions required for installation of the K Connector assemblies when using K110-2-R sliding contacts. The dimensions shown in parentheses in the figures should be followed when sliding contacts are used.

- **K102F-R**: Figure 4-1 on page 4-1
- **K102M-R**: Figure 5-1 on page 5-1
- **K103F-R**: Figure 6-1 on page 6-1
- **K103M-R**: Figure 7-1 on page 7-1
- **K104F-R**: Figure 8-1 on page 8-1
- **K104M-R**: Figure 9-1 on page 9-1

The precision step drill listed in Table 11-1 makes it easier to achieve concentricity of the respective three or four holes required for the K102F-R, K102M-R, K103F-R, K103M-R, K104F-R, and K104M-R installation.

Fabrication Instructions

The sliding contacts slip over the pin of the glass bead and mate with the microcircuit as shown in Figure 11-1 on page 11-2. The following is the recommended procedure for installing the sliding contacts and mating them with the microcircuit.


2. Check that the center pin in the glass bead is level with the top of the microcircuit ± 0.051 mm. If necessary, bend the pin to achieve this degree of levelness.

3. Install the K110-2-R Sliding Contact using either of the following two methods:
Method 1:

a. Install the lower stripline board.

b. Using the tweezers, place the K110-2-R onto the center pin and position as shown below in Figure 11-1, left.

c. Using a jewelers screwdriver, gently push the sliding contact onto the center pin.

d. Press the tab onto the stripline. Solder bond or epoxy, if desired.

e. Install the top stripline. The finished assembly should resemble Figure 11-1 below, right.

---

Method 2:

a. Using the tweezers, place the K110-2-R onto the center pin of the bead and position it as shown below in Figure 11-2, left. Gently tilt the tab on the K110-2-R upward, then install the bottom stripline into the cavity, sliding it under the tab.

b. Press the tab onto the stripline. Solder bond or epoxy, if desired.

c. Install the top stripline. The finished assembly should resemble Figure 11-2 below, right.
Introduction
This drill and tap set is used to precisely machine the concentric holes needed for mounting K Connectors® in housings. The finishing step drill is made of high-speed steel and is designed for use on aluminum and brass housings.

Kit Contents
- Drill Part No: B-14094
- Tap Part No: 783-255

Machining Dimensions
The following list provides references to the machining dimensions required for installation of the applicable K Connector assembly:
- **K102F-R**: Figure 4-1 on page 4-1
- **K102M-R**: Figure 5-1 on page 5-1
- **K103F-R**: Figure 6-1 on page 6-1
- **K103M-R**: Figure 7-1 on page 7-1
- **K104F-R**: Figure 8-1 on page 8-1
- **K104M-R**: Figure 9-1 on page 9-1
Machining Instructions

The drill bit in this kit simultaneously machines the concentric holes needed to install the K102F/M Sparkplug connector, and the K103F/M and K104F/M Flange Mount Connectors. When the 01-104 drill bit is used in the manner described below, it should provide reliable performance for thousands of operations.

<table>
<thead>
<tr>
<th>Caution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Do not use a drill press for the following steps. The precise tolerances needed require a milling machine.</td>
</tr>
<tr>
<td>Handle the drill bit with care: It has a 0.711 mm diameter tip.</td>
</tr>
</tbody>
</table>

1. Place the material to be machined into the vise of the mill.
2. Drill a 5.0 mm deep pilot hole using a 1.75 mm drill bit.
3. Install the step drill bit directly into the collet of the mill.
   Do not use a drill chuck to hold the bit.
4. Set the drilling speed for 1500 to 2000 rpm and the feed rate for 0.006 mm per revolution.
5. Drill the holes using full-flood coolant and a steady, even feed.
   Periodically withdraw the drill bit and clear away the chips to make the drilling easier. This will also make the drill bit less likely to break.
6. For K102F–R and K102M-R Sparkplug Connectors:
   a. Drill all holes as specified in the steps above, and in the applicable drawing.
   b. Tap the sparkplug hole using the tap supplied with the 01-104 kit.
7. For K103F–R and K103M–R two-hole Flange Mount Connectors:
   a. Drill all three holes as specified in the steps above, and in the applicable drawing.
   b. Tap the two mounting holes as specified in the same drawing.
8. For K104F–R and K104M–R four-hole Flange Mount Connectors:
   a. Drill all five holes as specified in the steps above, and in the applicable drawing.
   b. Tap the four mounting holes as specified in the same drawing.

Caution: Do not use a drill press for the following steps. The precise tolerances needed require a milling machine.
Handle the drill bit with care: It has a 0.711 mm diameter tip.

Note: For K103F–R and K103M–R two-hole flange mount connectors, the horizontal orientation of the flange mounting-screw holes is shown for information only (see Figure 6-1 on page 6-1 and Figure 7-1 on page 7-1). In practice, the mounting hole pattern may be rotated as needed to any position (except for vertical to avoid the solder access hole).
01-108

Finishing Step Drill and Tap Kit (Sliding Contacts)

Introduction
This drill and tap set is used to precisely machine the concentric holes needed for mounting K Connectors® in housings. The finishing step drill is made of high-speed steel. It is designed for use on aluminum and brass housings.

Kit Contents
- Drill Part No: 55300
- Tap Part No: 783-569

Machining Dimensions
The following list provides references to the machining dimensions required for installation of the applicable K Connector assembly:
- **K102F-R**: Figure 4-1 on page 4-1
- **K102M-R**: Figure 5-1 on page 5-1
- **K103F-R**: Figure 6-1 on page 6-1
- **K103M-R**: Figure 7-1 on page 7-1
- **K104F-R**: Figure 8-1 on page 8-1
- **K104M-R**: Figure 9-1 on page 9-1
Finishing Step Drill and Tap Kit (Sliding Contacts)  01-108

Machining Instructions

The drill bit in this kit (Figure 13-1) simultaneously finishes concentric holes needed to install the K102F/M Sparkplug, and the K103F/M and K104F/M Flange Mount Connectors. When the 01-308 drill bit is used in the manner described below, it should provide reliable performance for thousands of operations.

<table>
<thead>
<tr>
<th>Caution</th>
<th>Do not use a drill press for the following steps. The precise tolerances needed require a milling machine.</th>
</tr>
</thead>
</table>

1. Place the material to be machined into the vise of the mill.
2. Drill pilot holes to within 0.127 mm of each specified hole diameter.
3. Install the step drill bit directly into the collet of the mill.
   Do not use a drill chuck to hold the bit.
4. Set the drilling speed for 1500 to 2000 rpm and the feed rate for 0.006 mm per revolution.
5. Drill the holes using full-flood coolant and a steady, even feed.
   Periodically withdraw the drill bit and clear away the chips to make the drilling easier. This will also make the drill bit less likely to break.
6. For K102F–R and K102M–R Sparkplug Connectors:
   a. Drill all holes as specified in the steps above, and in the applicable drawing.
   b. Tap the hole using the tap supplied with the 01-108 kit.
7. For K103F–R and K103M–R two-hole Flange Mount Connectors:
   a. Drill all three holes as specified in the steps above, and in the applicable drawing.
   b. Tap the two mounting holes as specified in the same drawing.
8. For K104F–R and K104M–R four-hole Flange Mount Connectors:
   a. Drill all five holes as specified in the steps above, and in the applicable drawing.
   b. Tap the four mounting holes as specified in the same drawing.

Caution: Do not use a drill press for the following steps. The precise tolerances needed require a milling machine.

Note: For K103F–R and K103M–R flange mount connectors, the horizontal orientation of the two flange mounting-screw holes are shown for information only (see Figure 6-1 on page 6-1 and Figure 7-1 on page 7-1). In practice, the mounting hole pattern may be rotated as needed to any position (except for vertical to avoid the solder access hole).