



NOTE:
Maximum soldering temperature is 350° C

Figure 1. VP100CNL Shroud

1. Tools and Materials

These tools and materials are needed to install the VP100CNL Shroud.

Name	Vendor and Model/Part Number
Solder, 80Au/20Sn, washer (preform) 3.76 OD, 3.2 ID, 0.13 thick	Indium Corporation, Indalloy #182; 01-503 Anritsu Co.
Cleaning Fluid	Isopropyl Alcohol
Rosin Flux	#1544- HT, Kester Co.
Stereo Microscope, .07-30X	Model Stereo Zoom 4, Bausch & Lomb

2. Machining Dimensions

Machining dimensions for the shroud mounting hole are shown in Figure 2.

3. Installing the Shroud into the Housing

- a. Flux the shroud and the inner walls of the mounting hole.

NOTE

Flux may not be needed if soldering is done in a reducing atmosphere.

- b. For a thick-wall housing place three to four solder preform washers on the shroud and place the shroud into the housing as shown in Figure 2.
- c. For a thin-wall housing, place one or two solder preform washers over the shroud inside the housing as shown in Figure 3.
- d. Place the housing on 350° C hot plate or furnace to flow the solder.
- e. When the solder starts to melt, push the shroud into the housing.
- f. Remove the housing from the hot plate keeping the shroud firmly pressed to the housing. Allow the assembly to cool.
- g. Clean with alcohol to remove the flux.

NOTE

Visually verify that there is good solder flow (without any pinholes or gaps) between the outer conductor and the wall of the housing. This will ensure that a hermetic seal is created for the shroud assembly.

4. Installing a Substrate on a Carrier into the Housing

- a. Place the substrate into the housing.
- b. Install mounting screws into the substrate and tighten them to the recommended torque for the screw size used, making sure the center pin is properly aligned with the circuit trace.

NOTE

The recommended gap between the substrate and the shroud is 0.05 mm.

- c. Following the instructions included with the V110-1 Stress Relief Contact, install a contact onto the shroud center pin.
- d. Attach the connecting tab to the circuit trace by soldering, parallel gap welding or with silver epoxy.

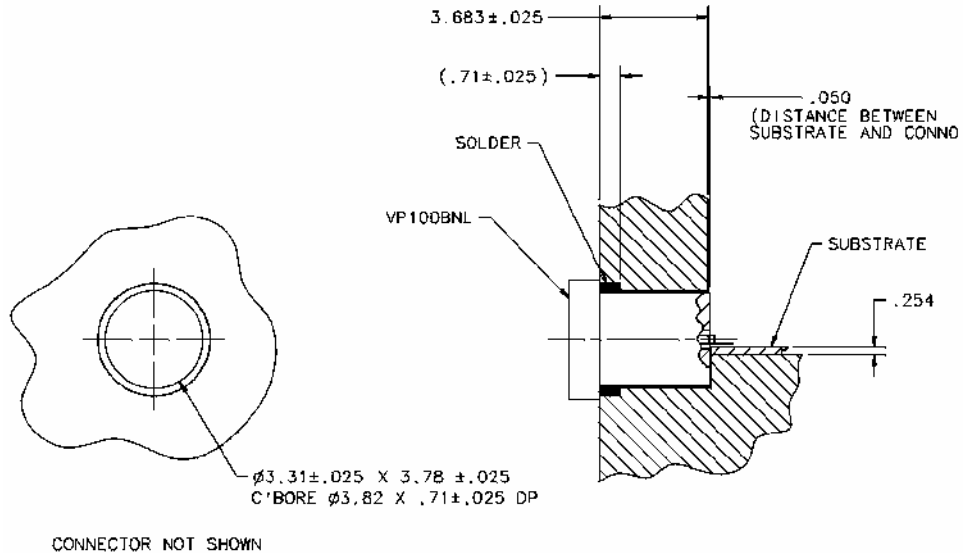


Figure 2. VP100CNL Mounting Hole Dimensions and Assembly Drawing for Thick-wall housing

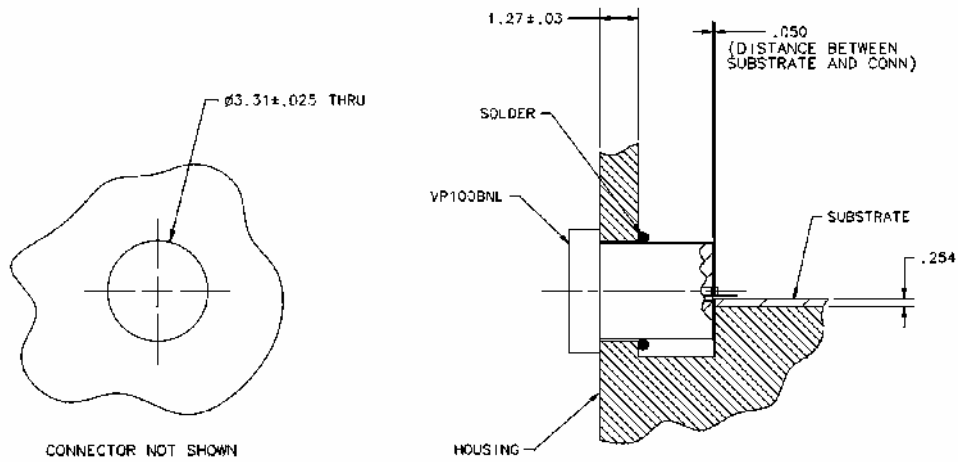


Figure 3. VP100CNL Mounting Hole Dimensions and Assembly Drawing for Thin-wall housing