



Installation Guide

for

SSMP Vertical Mount Connectors

CGB-4P-S-02-VL-00-XX

CGB-4P-S-04-VL-00-XX

CGB-4P-S-06-VL-00-XX

CGB-4P-S-08-VL-00-XX

CGB-4P-S-10-VL-00-XX

Note: "XX" in P/N's represents housing plate thickness (10, 30 or 50). This guideline is applicable to all these P/N's.

SSMP Cable Assemblies

CGC-4R-S-02-2-XX-YY-Z

CGC-4R-S-04-2-XX-YY-Z

CGC-4R-S-06-2-XX-YY-Z

CGC-4R-S-08-2-XX-YY-Z

CGC-4R-S-10-2-XX-YY-Z

Note: "XX" represents end connector (SMA, 2.92mm, 2.4mm, 1.85mm, plug and jack).

"YY" represents cable lengths (inch).

"Z" represents cable phase matching (A, B, C, or D)

This guideline is applicable to all these P/N's.

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i. Revision History

REV	DATE	DESCRIPTION	PREPARED BY	APPROVED BY
NC	06/21/16	INITIAL RELEASE	P. Volkov	



1. Purpose

Provide general guidelines for assembly of Connector to Printed Circuit Board, assembly of Cable Assembly onto Connector and replacement of damaged Cable.

2. Applicable Documents

OL_CGB4PS##VL00XX	Outline and Mounting, SSMP Connector, Male, PCB, Vertical Mount (see note 1)
OL_CGC4RS##2XXYYZ	Outline and Mounting, SSMP Connector, TLL26-5047 cable (see note 2)
J-STD-001	Requirements for Soldered Electrical and Electronic Assemblies

Note 1:

“##” represents number of positions (02, 04, 06, 08, or 10).

“YY” represents housing plate thickness (10, 30 and 50).

Note 2:

“##” represents number of positions (02, 04, 06, 08, or 10).

“XX” represents end connector (SMA, 2.92mm, 2.4mm, 1.85mm, plug and jack).

“YY” represents cable lengths (inch).

“Z” represents cable phase matching (A, B, C, or D).

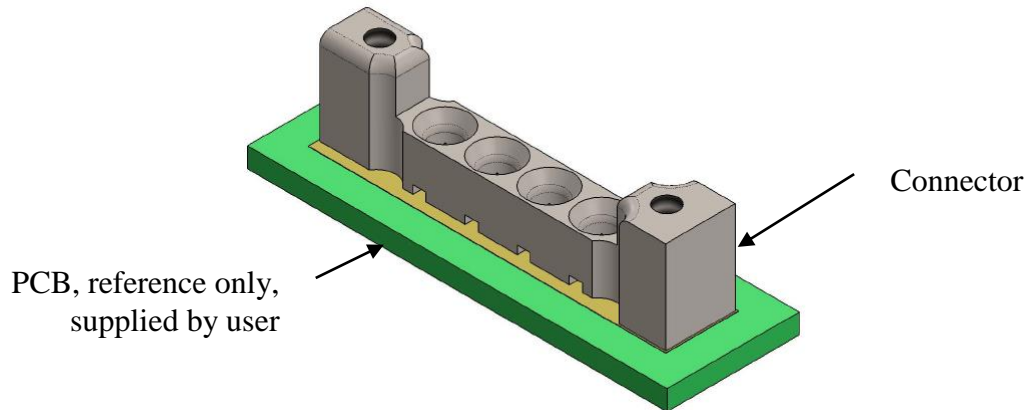


Figure 1: Connector, 4 position, top view

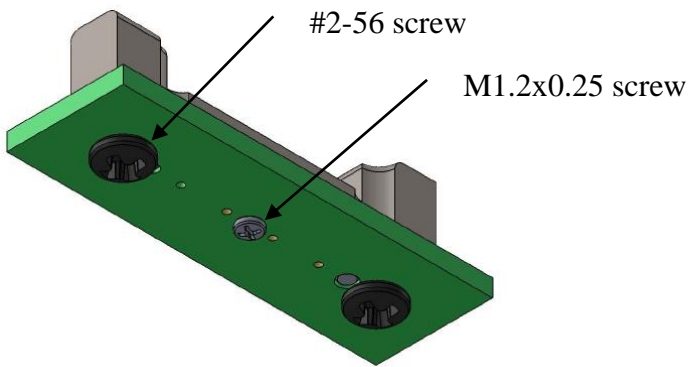


Figure 2: Connector, 4 position, bottom view

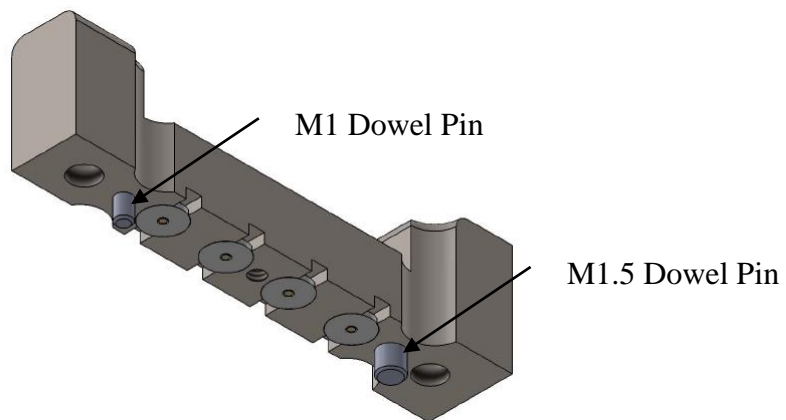


Figure 3: Connector, 4 position, mating interface

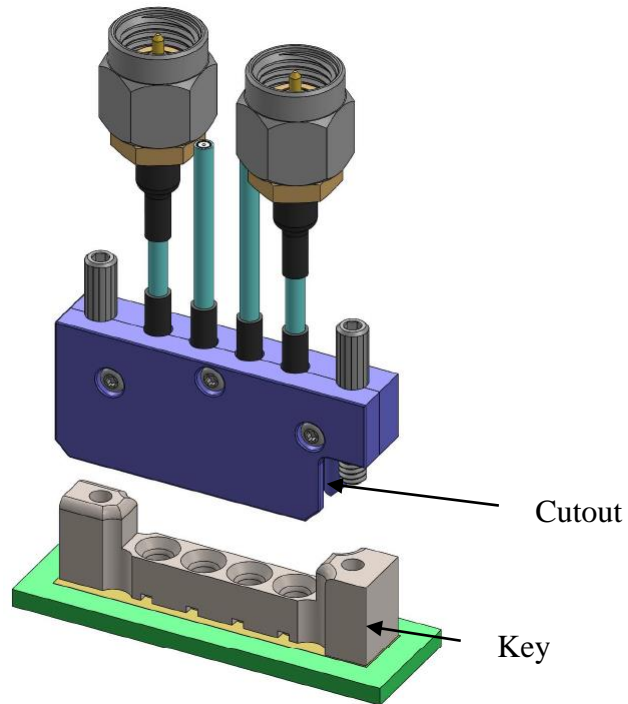


Figure 4: Cable Assembly onto Connector - Alignment

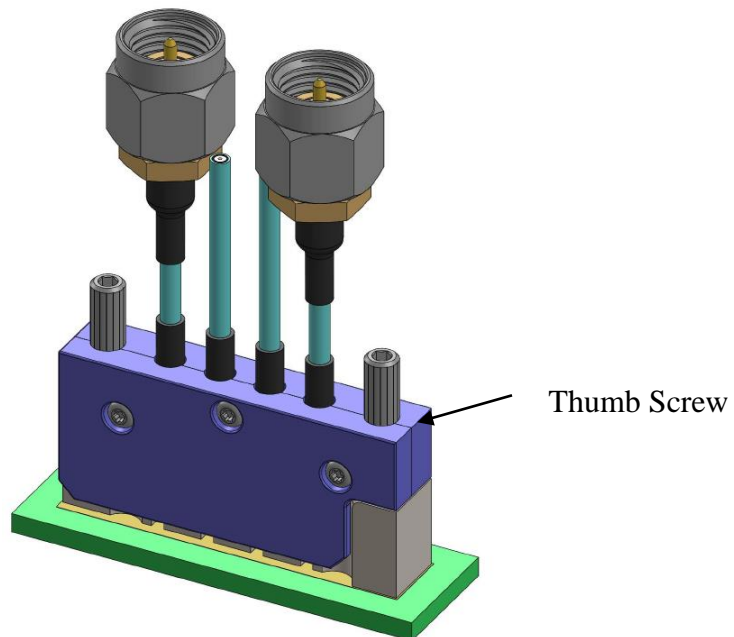


Figure 5: Cable Assembly onto Connector – Fully Assembled

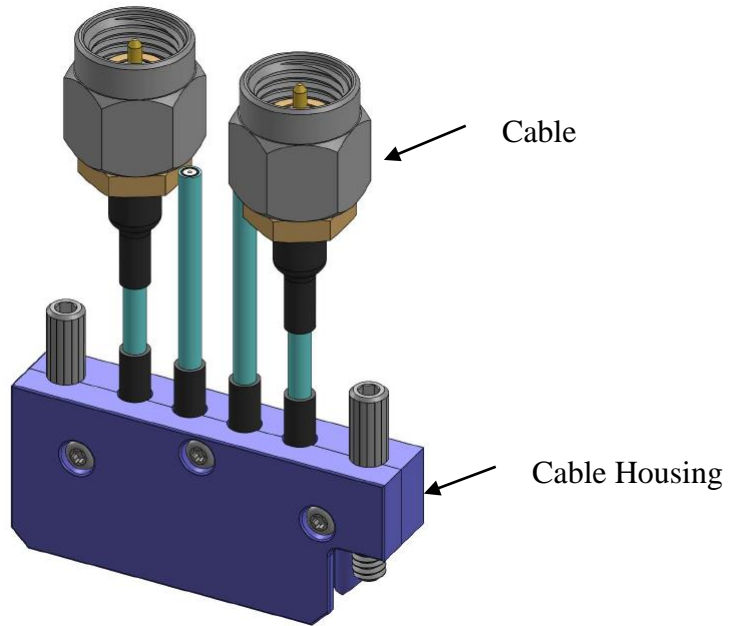


Figure 6: Cable Assembly, 4 Position, top view

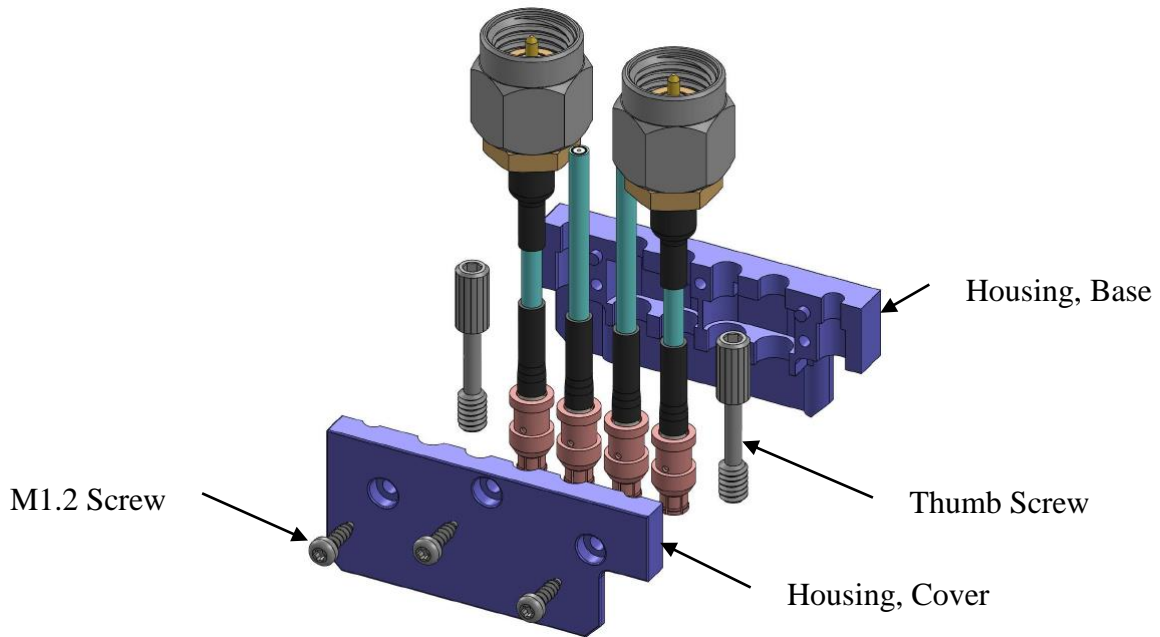


Figure 7: Cable Assembly, 4 Position, exploded view

3. Configuration

- 3.1. See Figures 1, 2 and 3 for representative views to illustrate Connector and hardware configuration. Views are of 4 position Connector.
- 3.2. See Figures 4 and 5 for representative view to illustrate assembly of Connector and Cable Assembly. View is of 4 position Connector and Cable Assembly
- 3.3. See Figures 6 and 7 for representative view to illustrate Cable Assembly. Views are of 4 position Cable Assembly

4. Assembly Procedure for soldering Connector to PCB Board.

- 4.1. Reference Figures 1, 2 and 3.
- 4.2. Assembled Connector uses the following items:

Item	Qty	CIT PN
Connector	1	CGB-4P-S-##-VL-00-XX (see note)
#2-56 x 1.56 PH Screw	2	C6341-1
M1.2x0.25x0.12 PH screw	1 (2 and 4 position) 3 (6, 8 and 10 position)	C6341-3

Note:

- “##” represents number of positions (02, 04, 06, 08, or 10).
- “XX” represents housing plate thickness (10, 30 and 50).

- 4.3. Tools and Equipment Required:
 - Solder Mask Stencil
 - Solder Reflow Oven
 - Driver, Phillips Style, Size #0
 - Driver, Phillips Style, Size #1
- 4.4. Use solder mask stencil and apply solder paste to board. (Mask stencil defined in Outline drawing specified in Section 2.)
- 4.5. Place Connector on board. Align pins and verify connector is flat to the board.
- 4.6. Solder connector to board with reflow process.
- 4.7. Inspect solder connection to industry standard.
- 4.8. Add hardware to backside of board. Assemble and hand tighten screws. Start from center and with each additional screw alternate from side to side.

4.9. Torque each screw alternating from the center out to following values. (Note: suggestion only, torque value may vary depending on PCB matl.)

Screw	Torque
M1.2x0.25	5.2 in-oz
#2-56	22.4 in-oz

4.10. Soldered Connector to board is complete.

5. Assembly Procedure of Cable Assembly to Connector.

5.1. Reference Figures 4 and 5.

5.2. Assembled Connector uses the following items:

Item	Qty	CIT PN
Cable Assembly	1	CGC-4R-S-##-2-XX-YY-Z (see note)

Note:

- “##” represents number of positions (02, 04, 06, 08, or 10).
- “XX” represents end connector (SMA, 2.92mm, 2.4mm, 1.85mm, plug and jack).
- “YY” represents cable lengths (inch).
- “Z” represents cable phase matching (A, B, C, or D).

5.3. Tools and Equipment Required:

Driver, Hex Style, Size 0.050

5.4. Prior to assembly, identify cutout on Cable Assembly housing and key (enlarged section) on Connector.

5.5. Orient Cable Assembly above Connector and align cutout on Cable Assembly cutout to key on Connector.

5.6. Press Cable Assembly into Connector until fully seated.

5.7. Hand tighten Thumb Screws. Torque to 22.4 in-oz, if required

5.8. Assembled Cable Assembly to Connector is complete.

6. Procedure for replacing damaged cable in Cable Assembly

6.1. Reference Figures 6 and 7.

6.2. Assembled Connector uses the following items:

Item	Qty	CIT PN
Cable	Replaced in pairs	1-XX-R6-047-G-Y-ZZ (see note 1)
Cable Housing	1	CGC4RSXX000000 (see note 2)

Note 1:

"XX" represents end connector (SMA, 2.92mm, 2.4mm, 1.85mm, plug and jack).

"Y" represents cable phase matching (A, B, C, or D).

"ZZ" represents cable lengths (inch).

Note 2:

"XX" represents number of positions (02, 04, 06, 08, or 10).

6.3. Tools and Equipment Required:

Driver, Hex Style, Size 0.050

Driver, Torx Style, Size T3

6.4. During service, cable or connector may get damaged and require replacement.

6.5. Cables are phase matched in pairs, therefore identify the matched pair with the damaged cable.

6.6. Identify the pair to be replaced by marking or label.

6.7. Place Cable Assembly with Base Housing against flat surface.

6.8. Remove M1.2 Screws and store.

6.9. With Base Housing held firmly against surface, remove Cover Housing minimizing disturbance of Cables seated in Base Housing.

6.10. Remove damaged Cable pair.

6.11. Align new Cables, orienting Cable connector groove into slot of Base Housing.

6.12. Place and align Cover Housing onto Base Housing. Verify Cables are not pinched and can move freely.

6.13. Assemble M1.2 screws into Base Housing. Rotate screw counter clockwise until screw thread is seated into existing threads of Base Housing. Hand tighten screws starting from the center and alternating from side to side with each additional screw.

6.14. Hand tighten screws. Start from center and each additional screw alternate from side to side.

6.15. Torque each screw alternating from the center out to 2.6 in-oz, if required.

6.16. Replaced cable is complete.