

18 GHZ ITA INSTALLATION AND ASSEMBLY

COAXIAL CONTACT, ITA, 18 GHZ, SMA ADAPTER • PART # 610 102 107

COAXIAL MODULE, ITA, 18 GHZ, 8 POSITION • PART # 510 108 176

TOOLS REQUIRED

Part # 910 121 165 or 5/16" Nut Driver
3/32 Allen Wrench

INSTRUCTIONS

1. Insert contact into the wiring side of the module, refer to **Figure 1-A**.
2. Add lock washer.
3. Tighten nut with a 5/16" nut driver, part # 910 121 165
4. Place o-ring into groove of contact as shown in **Figure 1-B**.

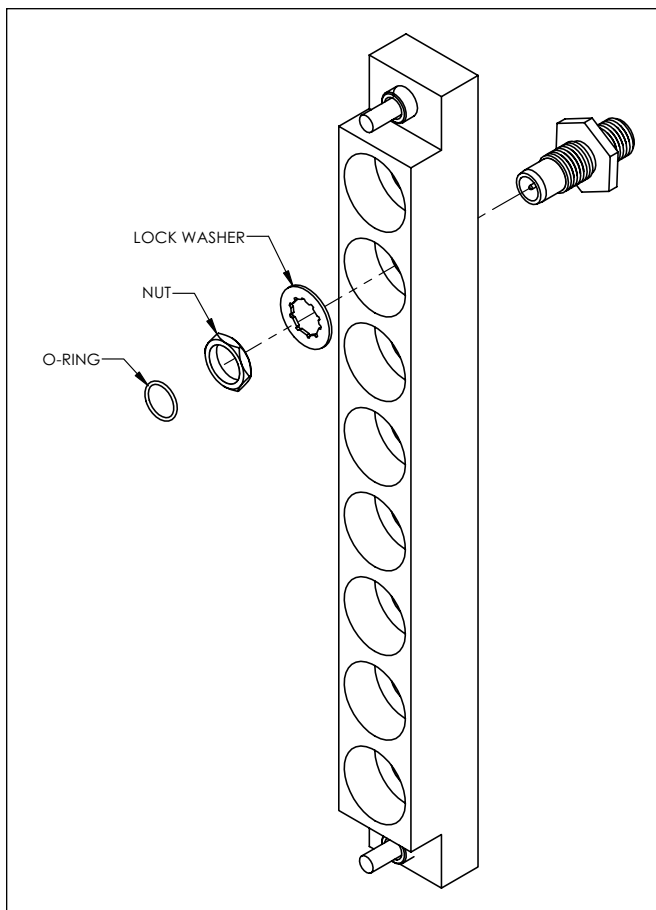


Figure 1-A. The 18 GHz contacts accept an SMA plug.

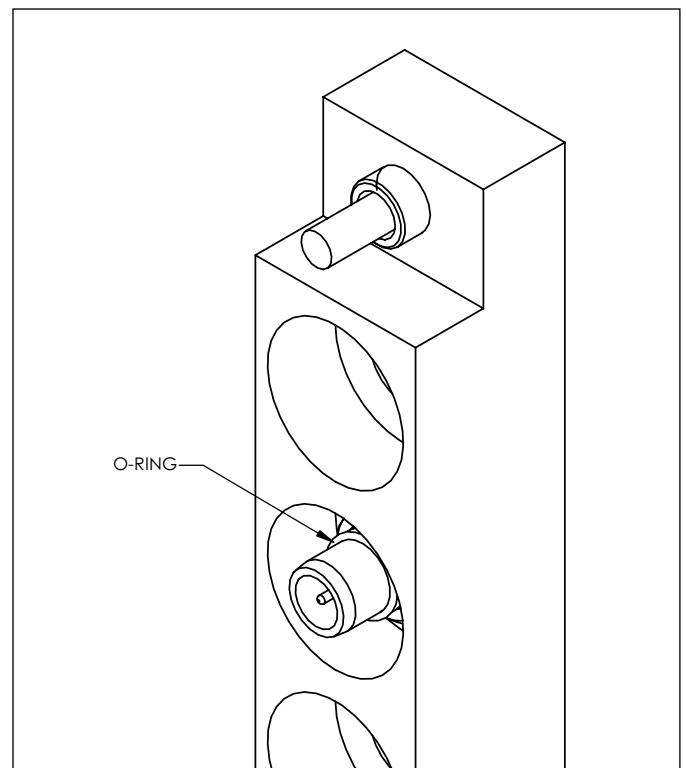


Figure 1-B. The o-ring provides a bulkhead seal during receiver and ITA engagement.

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$\frac{3}{32}$ Allen wrench

INSTRUCTIONS

1. Place the module in the ITA until the upper and lower module screws touch the mating holes in the inner frame (install modules such that Pin 1 is located at the top of the ITA frame).
2. Using a $\frac{3}{32}$ Allen wrench, tighten the top screw 1 to 2 full revolutions, while pushing lightly against the face of the module.
3. Maintain this pressure while tightening the bottom screw 1 to 2 full revolutions.
4. Repeat this sequence until the module is seated. Torque the screw until it is 8 to 10 inch pounds (clamping load 350 to 400 pounds).
5. To remove, loosen the top screw 1 to 2 full revolutions. Loosen bottom screw 1 to 2 full revolutions.
6. Repeat this sequence until the module is separated from the Receiver or ITA.