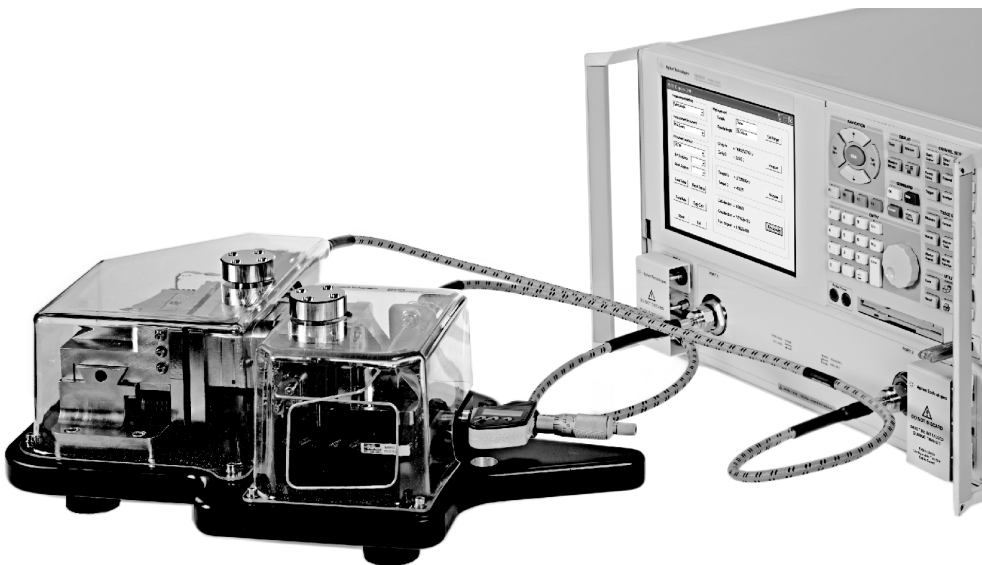


# Keysight Technologies 85072A 10 GHz Split-Cylinder Resonator



User's and Service  
Guide



NOTICE: This document contains references to Agilent Technologies. Agilent's former Test and Measurement business has become Keysight Technologies. For more information, go to **[www.keysight.com](http://www.keysight.com)**.



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## Assistance

Product maintenance agreements and other customer assistance agreements are available for Keysight products.

For any assistance, contact Keysight Technologies. Refer to [page 5-15](#) for a list of Keysight contacts.



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- Click **Search**.
- Click on the hyperlink for the appropriate PDF.
- Print the document.



<b>1. General Information</b>	
Overview of the 10 GHz Split-Cylinder Resonator . . . . .	1-2
Equipment Supplied . . . . .	1-3
Equipment Required but Not Supplied . . . . .	1-3
Incoming Inspection . . . . .	1-3
Recording the Resonator Serial Number . . . . .	1-3
Preparing the Resonator for Use . . . . .	1-4
Unlock the Linear Slide . . . . .	1-4
Remove the PTFE Sample . . . . .	1-6
Check the Cleanliness of the Cylinder Halves . . . . .	1-6
Carrying the Resonator . . . . .	1-6
<b>2. Before Making Measurements</b>	
Verify the Operating Temperature . . . . .	2-2
Protect Against Electrostatic Discharge (ESD) . . . . .	2-2
Install the Software . . . . .	2-2
Allow the Network Analyzer to Warm-Up . . . . .	2-3
Review the Principles of Connector Care . . . . .	2-3
Connect the Resonator to the Network Analyzer . . . . .	2-3
Familiarize Yourself with the Micrometer . . . . .	2-4
<b>3. Making Measurements</b>	
Operator's Check . . . . .	3-2
Performing the Operator's Check with the PNA Series Network Analyzer . . . . .	3-2
Sample Requirements . . . . .	3-7
Measurement Example . . . . .	3-8
Measuring the PTFE with the PNA Series Network Analyzer . . . . .	3-8
<b>4. Specifications</b>	
Electrical Characteristics . . . . .	4-2
Typical Uncertainty . . . . .	4-2
Mechanical Characteristics . . . . .	4-3
Cylinder . . . . .	4-3
Split Cylinder Resonator . . . . .	4-4
Micrometer Characteristics . . . . .	4-6
<b>5. Maintenance and Troubleshooting</b>	
Instrument Markings . . . . .	5-2
Physical Maintenance . . . . .	5-3
Connectors . . . . .	5-3
Cylinders Halves . . . . .	5-3
Protective Covers and Base . . . . .	5-3
Changing the Micrometer SR-44 Battery . . . . .	5-3
Troubleshooting Process . . . . .	5-5
Alignment Procedure . . . . .	5-5
Preparing the Resonator for Shipment . . . . .	5-13
Install the PTFE Sample . . . . .	5-13
Lock the Linear Slide . . . . .	5-13

Install the Shipment Security Screw .....	5-13
Returning a Resonator to Keysight Technologies .....	5-14
Contacting Keysight .....	5-15

<b>6. Replaceable Parts</b>	
Introduction .....	6-2

<b>7. Replacement Procedures</b>	
Replacing Parts in the Resonator .....	7-2
Replacing the 3.5 mm Connectors .....	7-2
Replacing the Clear Plastic Covers .....	7-3
Replacing the Coupling Adjustment Knobs .....	7-4

# **1 General Information**

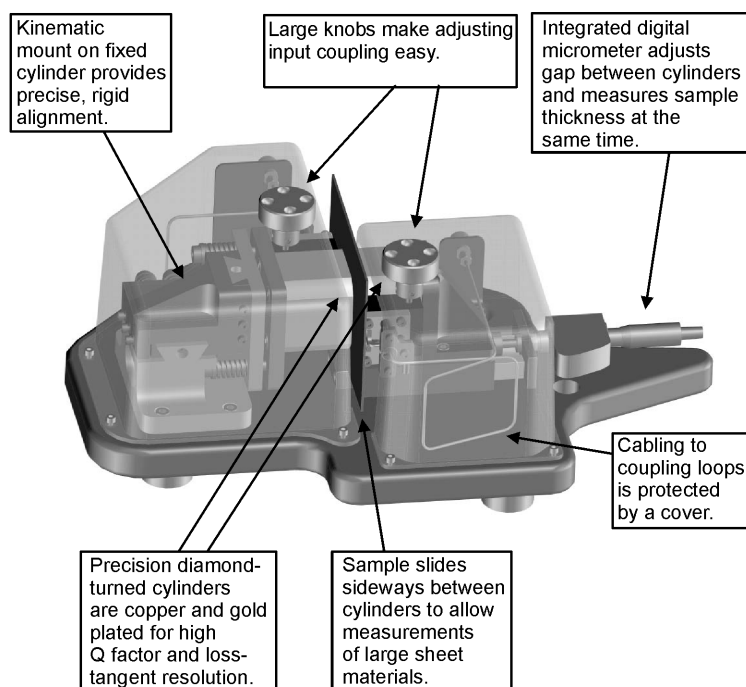
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## Overview of the 10 GHz Split-Cylinder Resonator

The Keysight 85072A 10 GHz Split-Cylinder Resonant Cavity offers fast and easy measurements of complex permittivity and loss tangent - critical design parameters for manufacturers of thin film, un-clad substrate, and low-loss sheet materials used for high-speed printed-circuit boards. These measurements comply with IPC test method TM-650 2.5.5.13.

The split cylinder resonator is a cylindrical resonant cavity separated into two halves. Both half-cylinders are diamond turned for the best possible surface finish. One half-cylinder is fixed and the other half-cylinder is movable. These features allow for a high Q cavity and the best loss tangent resolution. The sample is loaded in a gap between the two cylinder halves. The side mounting of the cylinders allows for large samples to be measured. An integrated digital micrometer measures the sample thickness at the time of the measurement.

Electrical coupling into the cavity is adjustable. Large coupling adjustment knobs are on the top of the fixture, while the coupling loops and cabling are located under protective covers. Measurements can be made at modes from ~ 5 GHz to ~ 28 GHz. For more technical information, go to [www.keysight.com](http://www.keysight.com) and search for Keysight pub number 5989-6182EN, "Technical Overview of the 85072A 10 GHz Split Cylinder Resonator".



85072\_001\_101

## Equipment Supplied

- 85072A 10 GHz Split-Cylinder Resonant Cavity
- PTFE sample
- 2 mm and 3mm ball-end hex keys
- Feeler gauge

## Equipment Required but Not Supplied

The following items are required for making measurements, but are *not* included with the resonator.

- 85071E Materials Measurement Software with Option 300 Resonant Cavity Software (To get ordering information of this software, see [“Contacting Keysight” on page 5-15.](#))
- N4419AK20 3.5 mm male-to-female cables or equivalent, quantity 2
- Any PNA, PNA-X, or PNA-L Network Analyzer or equivalent (If analyzer frequency range exceeds 40 GHz, add 85130-60010 adapters, quantity 2)
- ESD protection devices
- Connector cleaning supplies

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## Incoming Inspection

Check the contents of the shipping container. If any part of the resonator appears damaged, or if the shipment is incomplete, refer to [“Contacting Keysight” on page 5-15.](#) Keysight will arrange for repair or replacement of incomplete or damaged shipments without waiting for a settlement from the transportation company. Refer to [“Returning a Resonator to Keysight Technologies” on page 5-14](#) for instructions.

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**IMPORTANT** Save the original inner-box and foam along with the original or comparable outer-box and foam for reuse to ensure shipment safety.

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## Recording the Resonator Serial Number

Record the resonator serial number in [Table 1-1.](#)

**Table 1-1 Serial Number Record for the Resonator**

Resonator Serial Number

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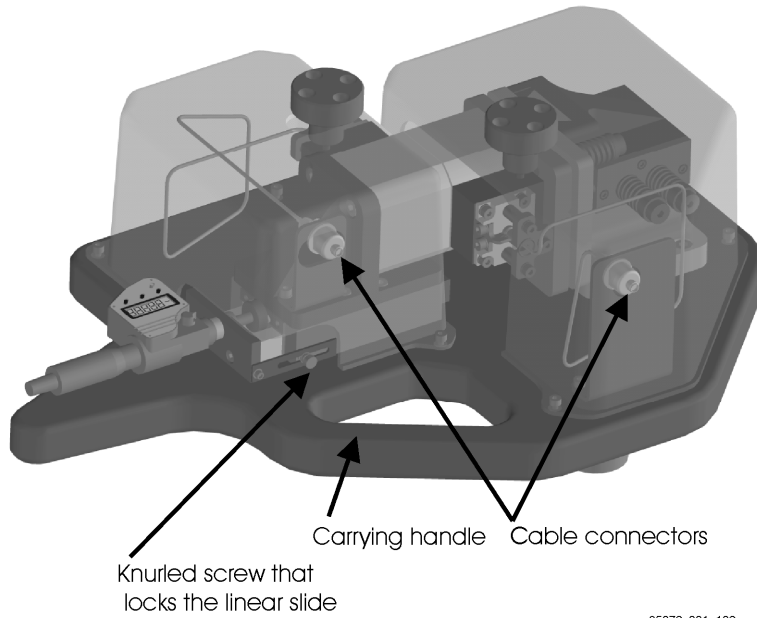
## **Preparing the Resonator for Use**

### **Unlock the Linear Slide**

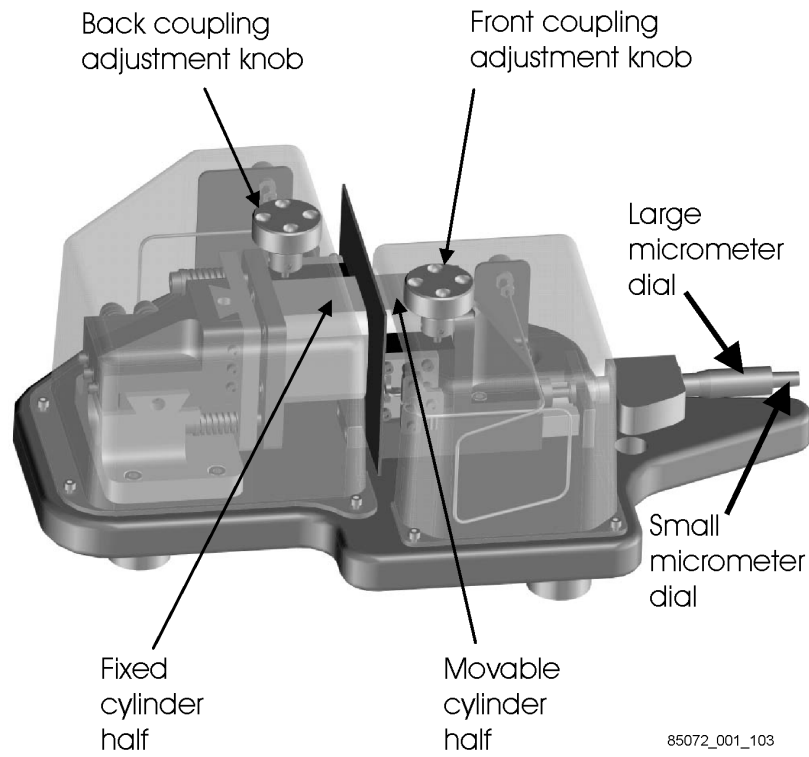
The resonator is shipped with the linear slide locked to prevent the movable cylinder-half from moving. To unlock it, locate the small, knurled screw on the stage (see the following graphic) and turn it counterclockwise until the linear slide moves easily when the micrometer is adjusted.



**Figure 1-1 Resonator Features (Back View)**



**Figure 1-2 Resonator Features (Front View)**



## **Remove the PTFE Sample**

The resonator is shipped with a rectangular PTFE sample held between the two cylinder halves. The PTFE prevents the mating surfaces of the cylinder halves from accidentally hitting together. Turn the micrometer's large dial (see [Figure 1-2 on page 1-5](#)) counterclockwise to loosen the cylinder halves, and then remove the PTFE sample.

## **Check the Cleanliness of the Cylinder Halves**

Inspect the mating surfaces and the inside of the cylinder halves for dust and debris. For cleaning instructions, refer to ["Cylinders Halves" on page 5-3](#).

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## **Carrying the Resonator**

The resonator has a carrying handle built into the base (see [Figure 1-1 on page 1-5](#)). Before using this handle to move the resonator, close the cylinder halves together by following steps 1 and 2 in ["Performing the Operator's Check with the PNA Series Network Analyzer" on page 3-2](#), then lock the linear slide by tightening the knurled screw.

## **2 Before Making Measurements**

## Verify the Operating Temperature

Ensure the operating temperature meets the following requirements.

- Split cylinder resonator: 0 °C to +60 °C
- Micrometer: +5 °C to +40 °C

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<b>NOTE</b>	Some network analyzer performance parameters are specified for 25 °C. Refer to the Help system in the analyzer for the complete specifications.
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<b>NOTE</b>	Samples of this product have been type-tested in accordance with the Keysight Environmental Test Manual and verified to be robust against the environmental stresses of storage, transportation and end-use; those stresses include but are not limited to temperature, humidity, shock, vibration, altitude and power-line conditions. Test methods are aligned with IEC 60068-2 and levels are similar to MIL-PRF-28800F Class 3.
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## Protect Against Electrostatic Discharge (ESD)

Protection against ESD is essential while connecting cables to the network analyzer. Refer to the Help system in the analyzer for complete instructions. Refer to [Table 6-2 on page 6-3](#) for ESD supplies ordering information.

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## Install the Software

Refer to the Installation Guide that is included with your 85071E Materials Measurement Software with Option 300 Resonant Cavity Software for complete instructions. Refer to [Table 6-2 on page 6-3](#) for ordering information.

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## Allow the Network Analyzer to Warm-Up

To achieve the maximum system stability, allow the analyzer to warm-up for at least 90 minutes.

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## Review the Principles of Connector Care

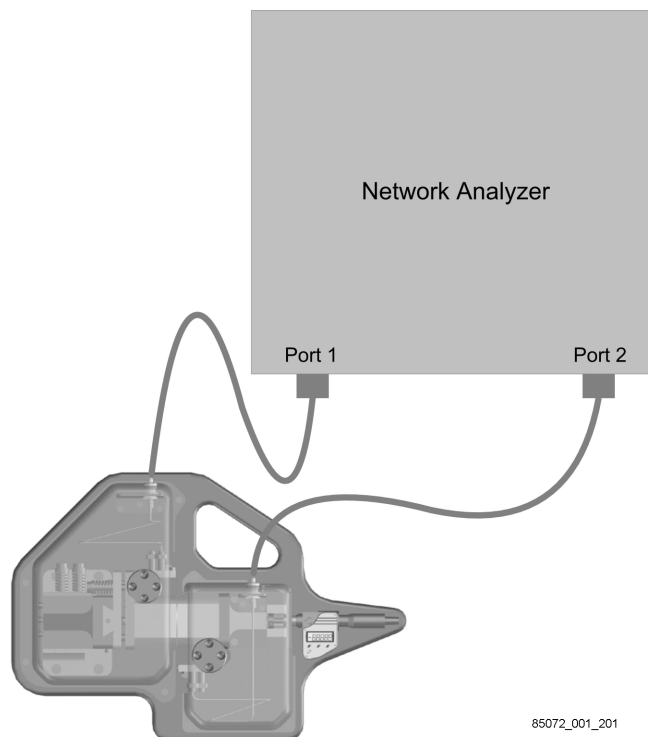
Proper connector care and connection techniques are critical for accurate and repeatable measurements. Refer to the Help system in the analyzer for complete information.

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## Connect the Resonator to the Network Analyzer

As shown in [Figure 1-1](#), connect the resonator between ports 1 and 2 of the network analyzer with two N4419AK20 flexible cables or equivalent.

**Figure 2-1     Resonator Connections to Network Analyzer**



## **Familiarize Yourself with the Micrometer**

If you need help in learning to use the micrometer, go to [www.mitutoyo.com](http://www.mitutoyo.com).

## **3 Making Measurements**

## Operator's Check

The Operator's Check tests the  $F_s$  (resonant frequency) and  $Q$  of the resonator's cavity with the half cylinders closed and no sample installed. It is recommended for verifying the performance of the resonator before making sample measurements.

Perform the Operator's Check:

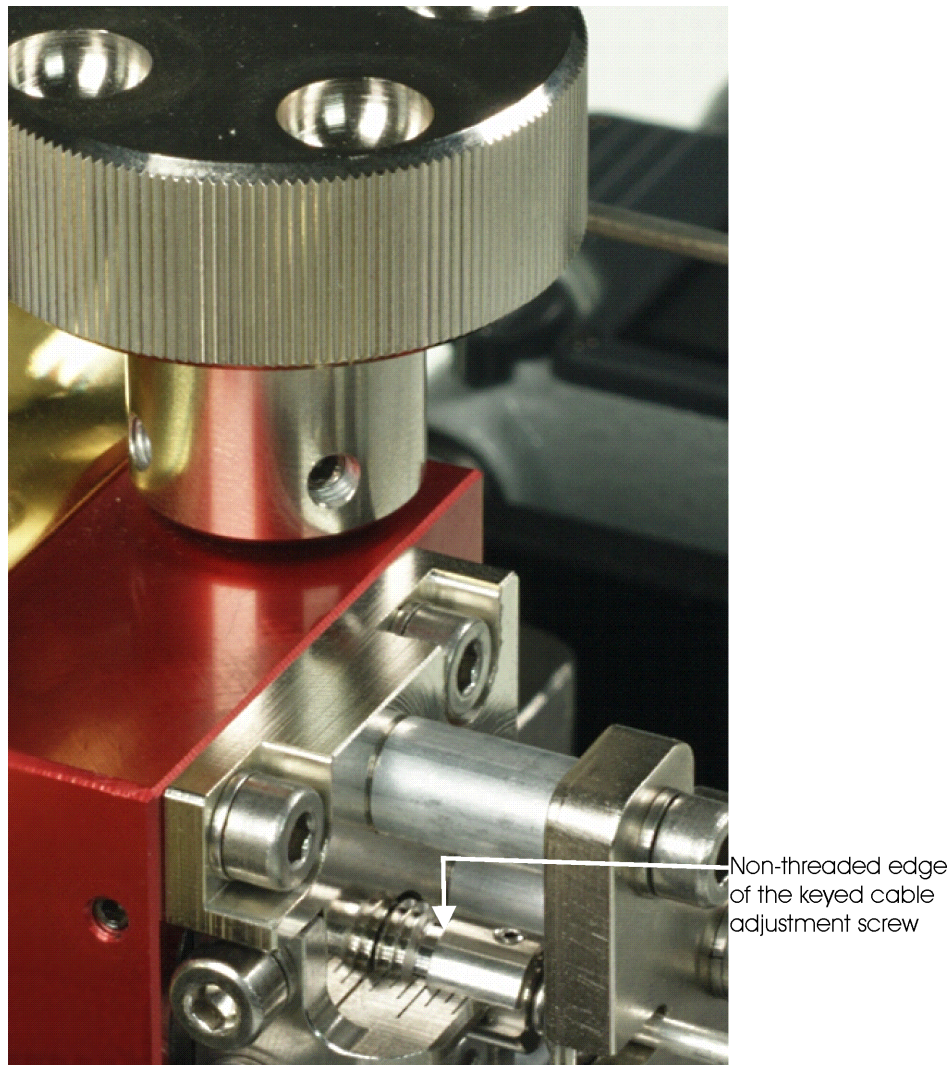
- daily
- when the operating temperature changes by 1 °C or more
- after transporting the resonator

### Performing the Operator's Check with the PNA Series Network Analyzer

1. Verify that the linear slide is unlocked by loosening the knurled screw on the back of the slide. Refer to [Figure 1-1 on page 1-5](#).
2. Turn the micrometer's large dial (see [Figure 1-1 on page 1-5](#)) clockwise to carefully move the cylinder halves *loosely* together. It is very important not to overtighten the halves together when using the large dial.
3. Turn the micrometer's small dial (see [Figure 1-1 on page 1-5](#)) clockwise to further move the cylinder halves together. When the halves are fully closed together, the small dial will continue to turn while making a clicking sound, but will not allow you to overtighten the halves.
4. Zero the micrometer by pressing its middle button.
5. Turn the front coupling adjustment knob (see [Figure 1-1 on page 1-5](#)) to adjust its coupling loop so that the non-threaded edge of the keyed cable adjustment screw is at the center mark of the scale. This center mark is the longest mark on the scale. See [Figure 3-1 on page 3-3](#).



**Figure 3-1 Keyed Cable Adjustment Screw and Feeler Gage**



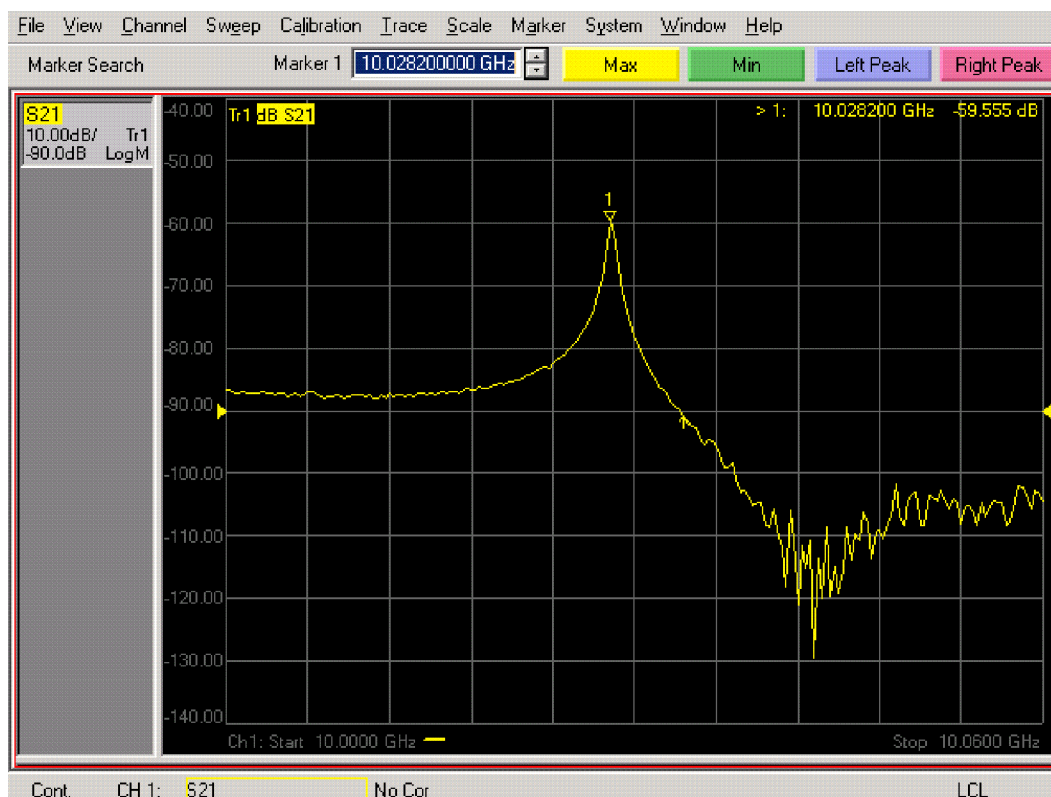
6. Repeat the previous step for the back coupling adjustment knob.
7. If not already done, start the PNA application by clicking on the Network Analyzer icon on the PNA display.
8. Make the following PNA settings. Refer to the Help system in the analyzer for complete information.
  - Measurement:  $S_{21}$
  - Start frequency: 10 GHz
  - Stop frequency: 10.06 GHz
  - Scale: Autoscale

## Operator's Check

**IMPORTANT** When instructed to adjust both coupling adjustment knobs, always rotate them together **SLOWLY** at the same time. Also, rotate them in the same direction and at the same speed so that the coupling loops are always at the same depth inside the cavity. Clockwise rotation increases coupling, and counter clockwise rotation decreases it.

- The PNA should display a trace with a resonant peak. Adjust both of the coupling adjustment knobs so that the peak measures between -55 to -65 dB. See [Figure 3-2 on page 3-4](#).

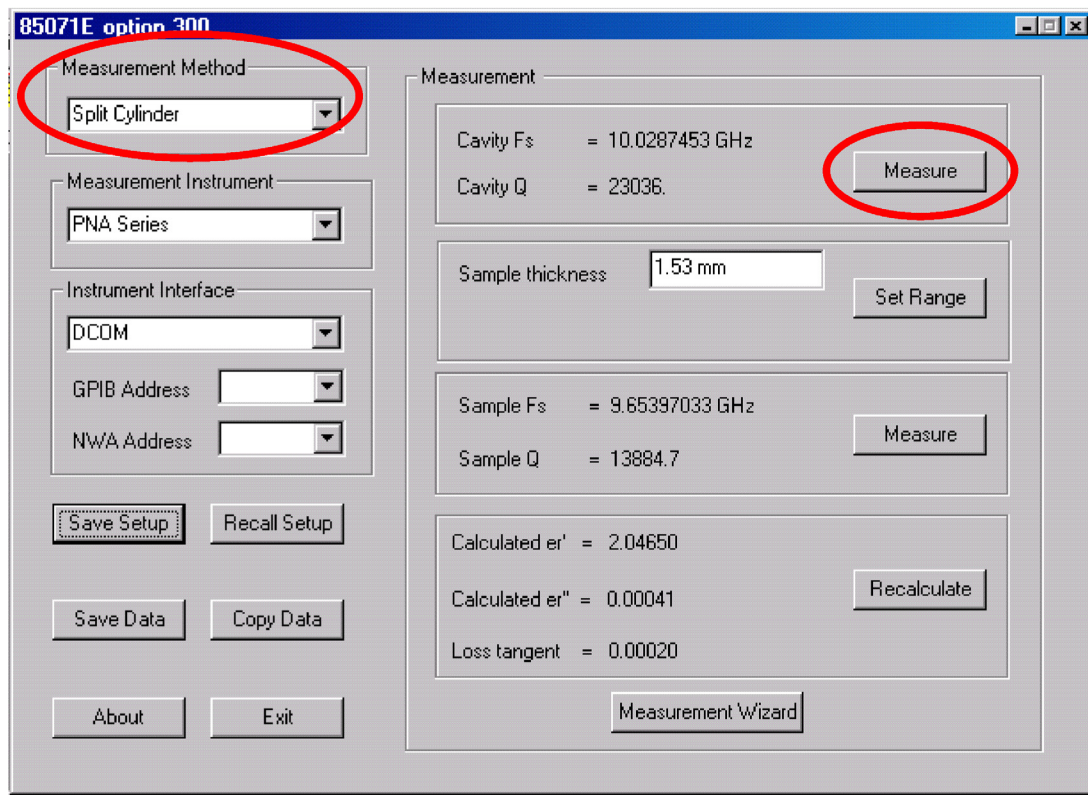
**Figure 3-2 Measurement Trace for the Operator's Check**



85072\_001\_307

- On the PNA toolbar, click View > Minimize Application.
- Start the 85071E Materials Measurement Software application by clicking the 85071E Cavity icon on the PNA display.
- On the 85071E Option 300 dialog box, use the Measurement Method drop-down menu to select **Split Cylinder**. See [Figure 3-3 on page 3-5](#).

Figure 3-3 85071E Option 300 Menu



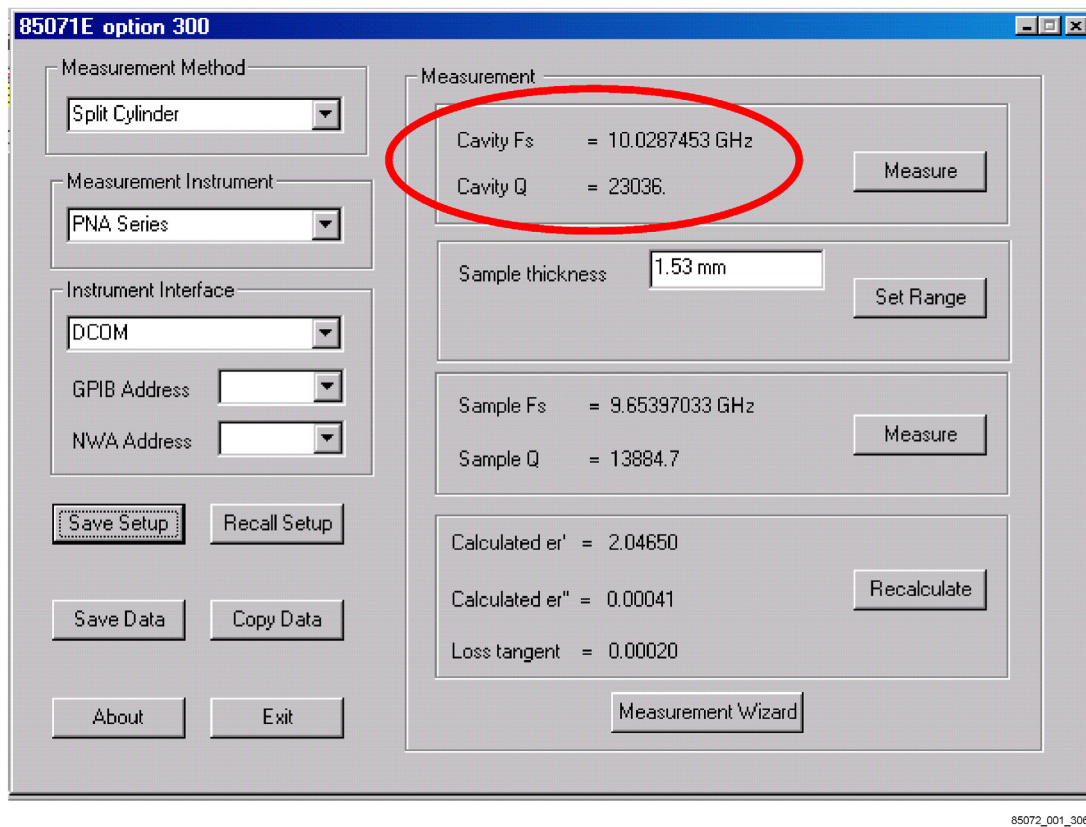
85072\_001\_302

13. Locate the menu section titled "Measurement" and click the top **Measure** button. See [Figure 3-3 on page 3-5](#).
14. Follow the prompts to complete the measurement. At the prompt, "Adjust the coupling to center the bar below," stop rotating the coupling adjustment knobs when the arrow graphic disappears. **Reminder:** *when using the two coupling adjustment knobs, rotate both knobs together SLOWLY at the same time. Also, rotate them in the same direction and at the same speed so that the coupling loops are always at the same depth inside the cavity. Clockwise rotation increases coupling, and counter clockwise rotation decreases it.*
15. Find the empty cavity  $F_s$  (resonant frequency) and Q measurement results in the 85071E Option 300 dialog box, at the top of the section titled "Measurement." See [Figure 3-4 on page 3-6](#). To pass the Operator's Check, you must get the following results:
  - $F_s$  (resonant frequency) between 10 GHz and 10.06 GHz
  - Cavity  $Q \geq 20,000$

## Operator's Check

- Maximum  $S_{21}$  peak value at  $\sim 10$  GHz between -55 dB and -65 dB

**Figure 3-4 Measurement Results for Operator's Check**



If the resonator fails the Operator's Check, refer to [Chapter 5](#) for troubleshooting information.

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**NOTE** Reference materials can be purchased from N.I.S.T.

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## Sample Requirements

Ensure the sample meets the following requirements:

- non-magnetic ( $\mu_r^* = 1 - j0$ )
- free of traces
- free of copper clad
- free of sticky residue or dust (if necessary, use a lint-free cloth moistened with alcohol to clean samples, and allow them to dry)
- non-abrasive (cylinder mating surfaces must NOT be scratched)
- homogeneous and isotropic
- flat parallel sides
- minimum diameter: 56 mm, ideally 60 mm or more for easier handling
- uniform thickness: 0.05 mm to 5 mm, typically 1 mm
- suggested values for 1 mm thick sample are:
  - real part of permittivity < 100
  - loss tangent < 0.01

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<b>NOTE</b>	Actual values of permittivity and loss tangent that can be measured with the split cylinder resonator are dependent on thickness.
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## Measurement Example

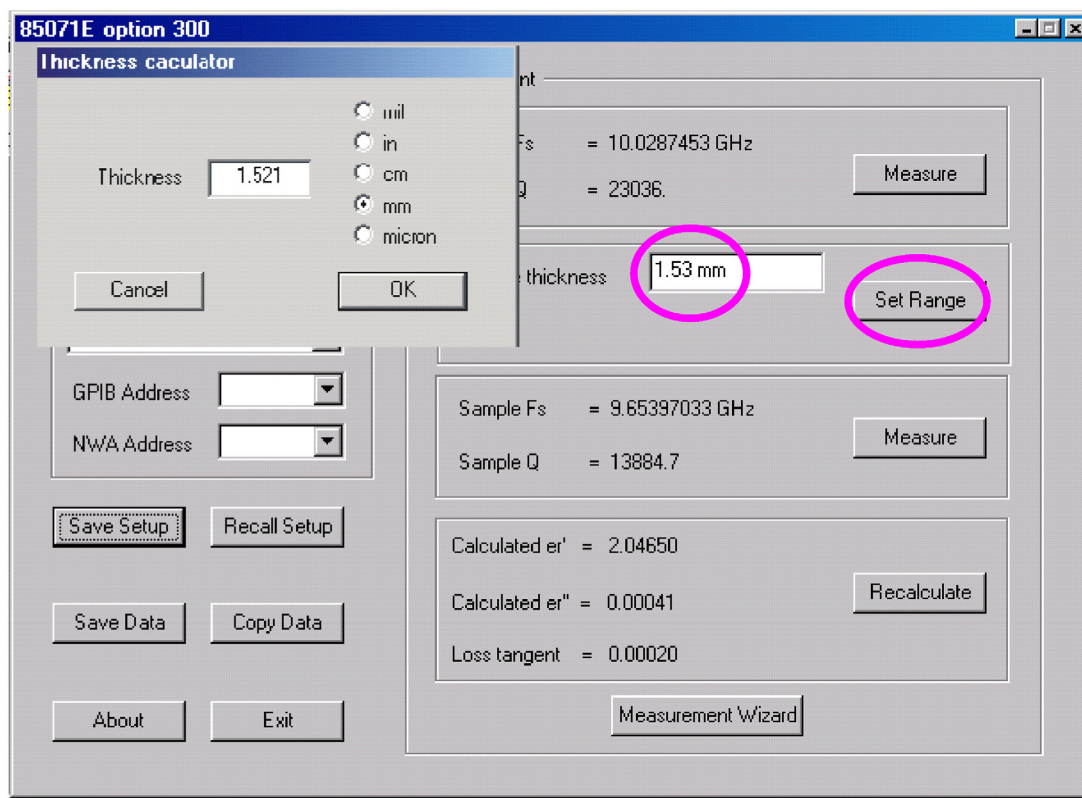
### Measuring the PTFE with the PNA Series Network Analyzer

1. If not already done, complete the steps in the Operator's Check to measure the  $F_s$  (resonant frequency) and  $Q$  of the empty cavity. See "Operator's Check" on page 3-2.
2. Clean the PTFE sample with a lint-free cloth and compressed air. If necessary, use anhydrous isopropyl alcohol (>92% pure) to lightly dampen the lint-free cloth, allowing 5 minutes for the alcohol to evaporate from the PTFE after cleaning.

**NOTE** The PTFE sample must be cleaned before it is measured so that contaminants don't affect measurement results or damage the cylinder faces.

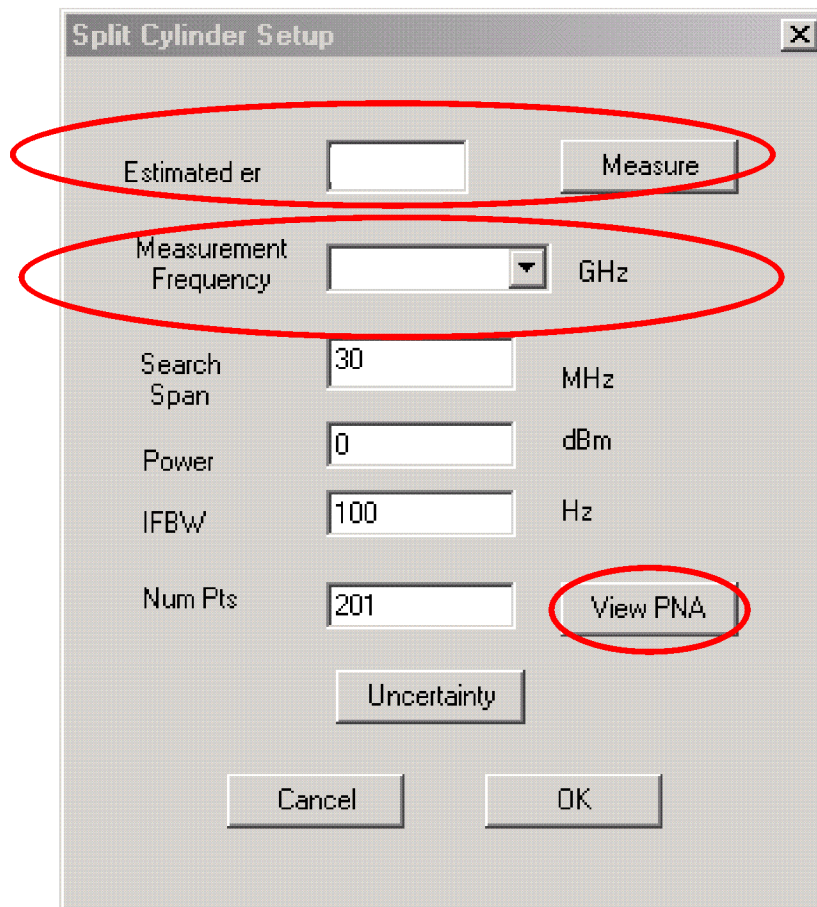
3. Insert the PTFE between the cylinder halves.
4. Measure the PTFE thickness using the micrometer.
5. On the 85071E Option 300 dialog box, click in the **Sample Thickness** cell to open the Thickness Calculator dialog box. Enter the PTFE thickness value and click **OK**. See Figure 3-5.

Figure 3-5 85071E Option 300 Menu



6. On the 85071E Option 300 dialog box, click **Set Range**. See [Figure 3-5](#). Wait a few seconds while the program performs some calculations and opens the Split Cylinder Setup dialog box.
7. In the Split Cylinder Setup dialog box, enter a value for the real part of permittivity in the **Estimated  $\epsilon_r$**  cell or click **Measure** and follow the measurement prompts as the program finds an estimate using the TE<sub>111</sub> mode. See [Figure 3-6](#).  
 $\epsilon_r$  is the real part of permittivity that the program uses as an estimate in calculations. For more technical information, go to [www.keysight.com](http://www.keysight.com) and search for Keysight pub number 5989-6182EN, "Technical Overview of the 85072A 10 GHz Split Cylinder Resonator".

**Figure 3-6 Split Cylinder Setup Dialog Box**



85072\_001\_303

8. In the Split Cylinder Setup dialog box, use the Measurement Frequency drop-down menu to select one of the TE<sub>0np</sub> modes. See [Figure 3-6](#). For your first measurement of any sample, Keysight recommends selecting the lowest frequency mode (TE<sub>011</sub>).
9. If running the program on a PNA Series Network Analyzer, click **View PNA** to see the PNA display for 5 seconds, or use windows functions to switch to the PNA application. The trace on the PNA display should include only one peak, and that peak should be nearly symmetrical. If there is more than one peak or if the peak is not nearly symmetrical, refer to ["Advanced Measurement Techniques"](#) on [page 3-10](#).
10. Press OK and follow the prompts to complete the measurement.

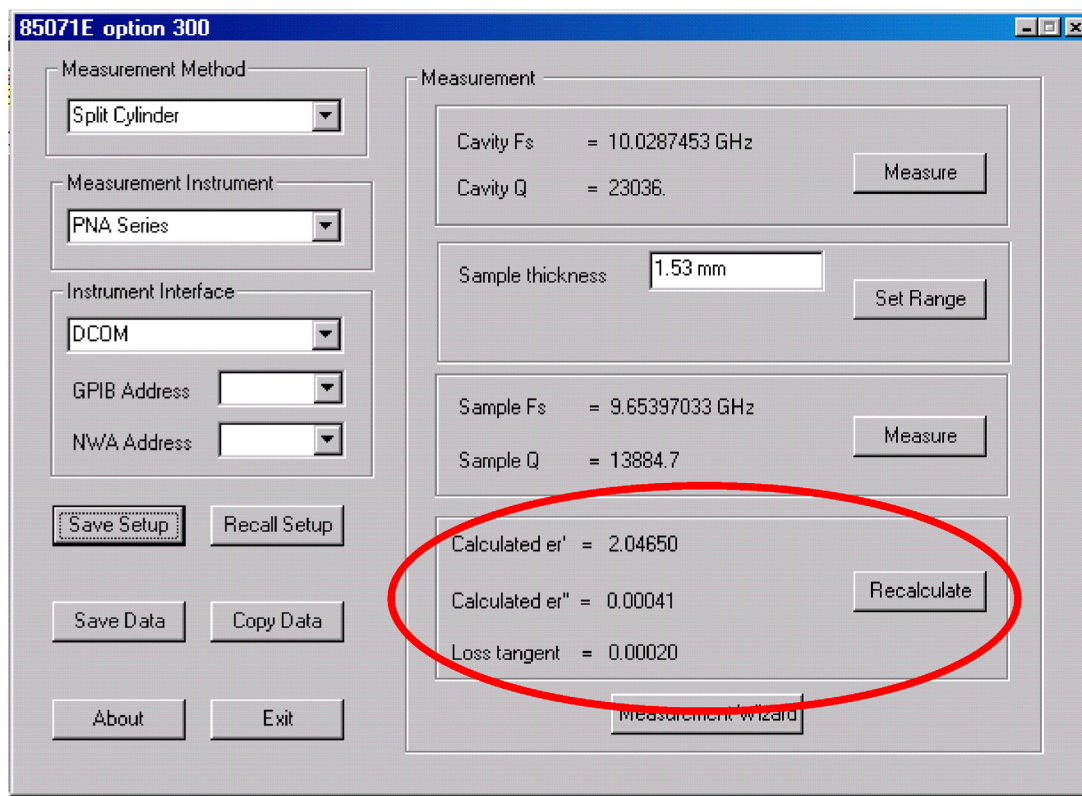
**Measurement Example**

11. When the measurement is completed, the 85071E Option 300 dialog box reappears with the calculated values displayed above the Measurement Wizard button. See [Figure 3-7](#). Typical values for the PTFE sample should be approximately:

- Calculated  $\epsilon_r^I \approx 2.05$
- Calculated  $\epsilon_r^{II} \approx 0.0004$
- Loss Tangent  $\approx 0.0002$

If your measurement values aren't close to the values above, refer to ["Advanced Measurement Techniques"](#) on [page 3-10](#).

**Figure 3-7 Measurement Results for a PTFE Sample**



85072\_001\_304

**Advanced Measurement Techniques**

If the displayed trace includes two peaks, try the following suggestions in the order listed. If one of the suggestions gives you expected measurement results, it is not necessary to use the remainder.

- o In the Split Cylinder Setup dialog box, use the Measurement Frequency drop-down menu to select a *different*  $TE_{0np}$  mode than the one you selected for the first measurement. See [Figure 3-6](#).
- o Choose the most likely peak.
  1. Use the network analyzer marker functions to select the desired peak. If using a PNA Series network analyzer, refer to the PNA Help system in the analyzer for complete information.



2. In the Split Cylinder Setup dialog box, enter the frequency of the peak in the **Measurement Frequency** cell. See **Figure 3-6 on page 3-9**.
  3. In the Split Cylinder Setup dialog box, enter values in the **Search Span** cell until the peak you selected is the only peak visible on the display.
  4. Click OK and check the new measurement results.
- o Try changing the sample thickness. An easy way to do this is measuring two sheets of the sample, being careful to minimize any air gaps between the two sheets.

Making Measurements  
**Measurement Example**

## **4 Specifications**

## Electrical Characteristics

- TE<sub>011</sub> Resonant mode of closed empty cylinders
  - o Frequency = 10.03 + 0.03 GHz
  - o Q ≥ 20,000 (input coupling at -60 dB)
- Additional, possibly usable, higher order TE<sub>0np</sub> modes exist in the empty cylinders approximately at the following frequencies (GHz):

13.1	22.8	27.0
17.8	22.9	27.1
19.7	25.6	28.2

Usability of TE<sub>0np</sub> modes depends on dielectric properties and thickness of the sample. For some samples, interference from other non-TE modes can make one or more higher order TE<sub>0np</sub> modes unusable. Increasing or decreasing the thickness of the sample may shift the measurement frequency away from the interfering mode.

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## Typical Uncertainty

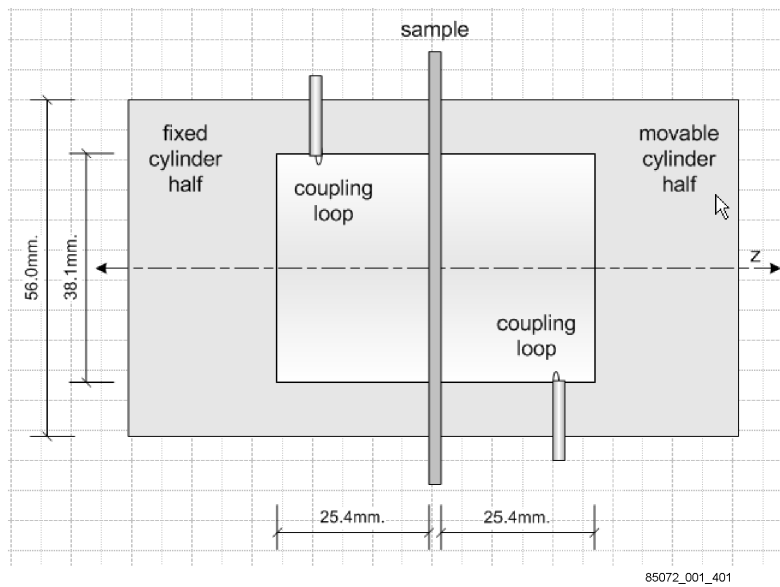
- TE<sub>011</sub> mode
  - o Real part of permittivity: +/- 1%
  - o Loss tangent: +0.0001
- Usable higher order TE<sub>0np</sub> modes:
  - o Real part of permittivity: +/- 1 - 2%
  - o Loss tangent: +0.0005

## Mechanical Characteristics

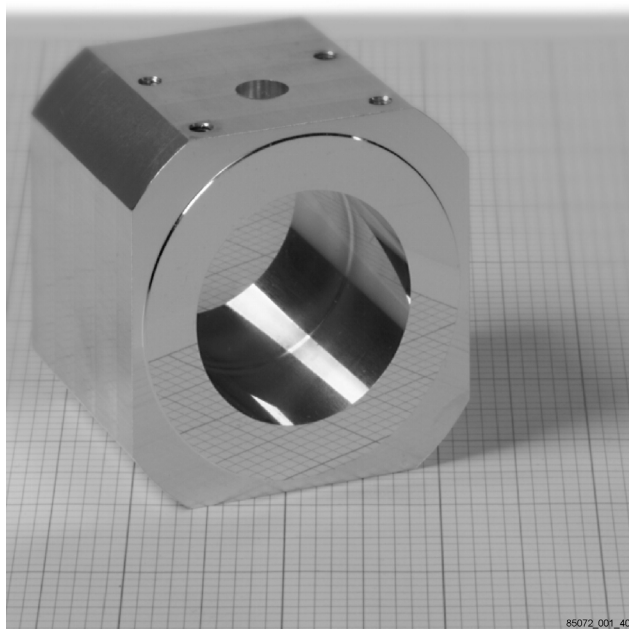
### Cylinder

Cylinders are precision diamond-turned Al 6061-T6 plated with 0.5  $\mu\text{m}$  Cu., 0.25  $\mu\text{m}$  PdNi, and 2.0  $\mu\text{m}$  Au.

**Figure 4-1** Cylinder Dimensions

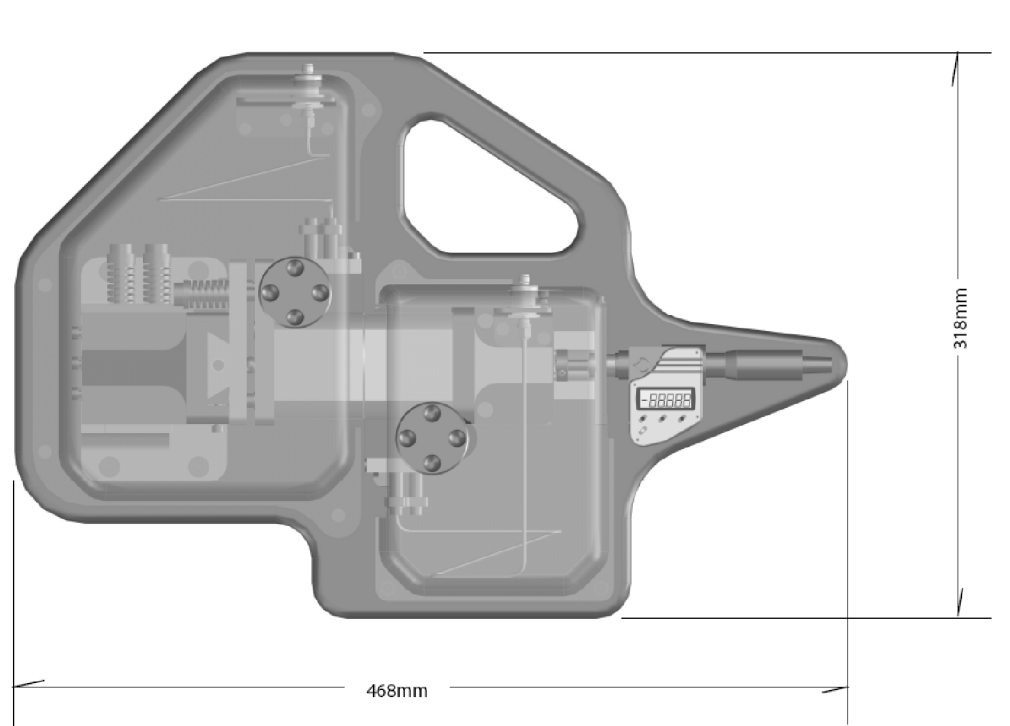


**Figure 4-2** One Half of a Split Cylinder

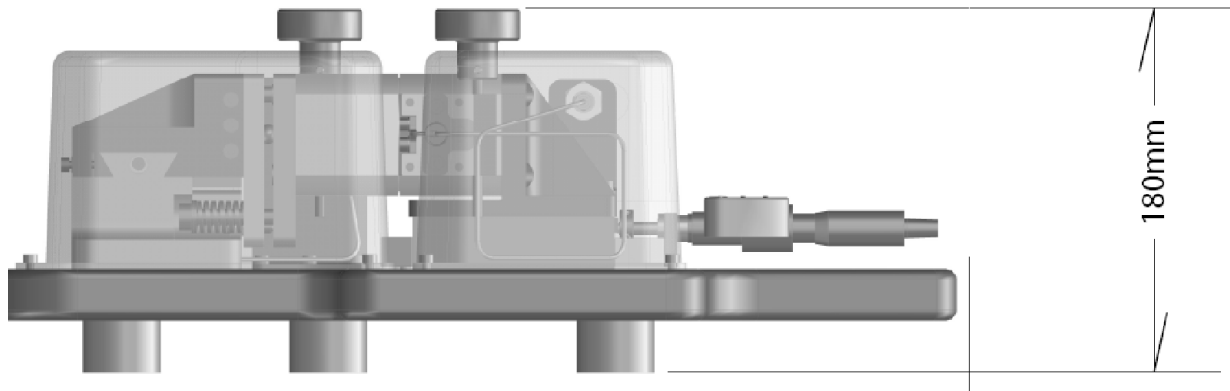


## Split Cylinder Resonator

**Figure 4-3. Split Cylinder Resonator Dimensions: Top View**



**Figure 4-4. Split Cylinder Resonator Dimensions: Side View**



85072\_001\_404

- Connectors: 3.5 mm female
- Weight: 25 lbs ((11.25 kg)

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## **Micrometer Characteristics**

Micrometer resolution: 0.001 mm

Micrometer typical accuracy: 0.01 mm



## **5 Maintenance and Troubleshooting**

## Instrument Markings



The instruction documentation symbol. The product is marked with this symbol when it is necessary for the user to refer to the instructions in the documentation.



This symbol indicates separate collection for electrical and electronic equipment, mandated under EU law as of August 13, 2005. All electric and electronic equipment are required to be separated from normal waste for disposal (Reference WEEE Directive, 2002/96/EC).

## Physical Maintenance

### Connectors

The best techniques for maintaining the integrity of the connectors on the resonator include:

- routine visual inspection
- cleaning
- proper cable connection techniques

For complete information on connectors, go to [www.keysight.com](http://www.keysight.com) and type “Connector Care” in the search function.

### Cylinders Halves

#### Clean the Mating Surfaces of the Cylinder Halves

- Dampen a large portion of a lint-free cloth with anhydrous isopropyl alcohol (>92% pure).
- Insert the damp part of the cloth between the cylinder halves, where the PTFE was previously located.
- Turn the micrometer’s large dial (see [Figure 1-2 on page 1-5](#)) clockwise to carefully move the cylinder halves *loosely* together. It is very important not to overtighten the cylinder halves together when using the large dial.
- Turn the micrometer’s small dial (see [Figure 1-2 on page 1-5](#)) clockwise to further move the cylinder halves together. When the halves are fully closed together, the small dial will continue to turn while making a clicking sound, but will not allow you to overtighten the halves.
- Turn the micrometer’s small dial counterclockwise to open the closed cylinder halves by 0.02 mm. This space between the halves allows the damp cloth to be moved around.
- Move the cloth back and forth between the cylinder halves and then pull the cloth out from between the cylinders.

#### Clean Inside the Cylinder Halves

- Separate the cylinders fully, using the large micrometer dial.
- Spray compressed air inside both cylinder halves to remove any particulate matter.
- Leave the cylinder open for five minutes to allow the alcohol to evaporate fully.

### Protective Covers and Base

Clean the protective covers and the base using a dry or slightly damp cloth only. Do not use abrasive cleaners or cloths.

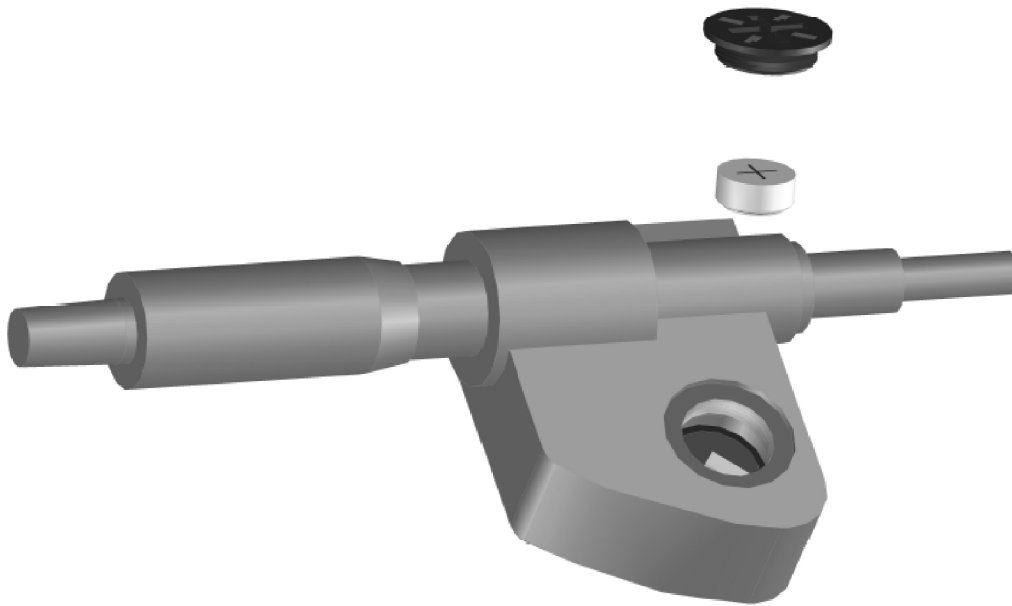
### Changing the Micrometer SR-44 Battery

1. Locate the hole in the base underneath the micrometer. Look through the hole and locate the round, black cover on the micrometer.

**Physical Maintenance**

2. Insert a flat-blade screwdriver through the hole and into the slot in the black cover.
3. Turn the screwdriver blade counter-clockwise until the black cover and the battery can be removed through the hole.
4. Recycle the old battery.
5. Place the new SR-44 battery inside the black cover with the inscribed “+” on the battery facing down.
6. Use your fingers to lift the black cover/battery through the base hole and into the micrometer.
7. Holding the black cover in place with your finger, use the screwdriver to tighten the cover.

**Figure 5-1. Changing the Micrometer Battery**



85072\_001\_501

## Troubleshooting Process

- The most likely cause of resonator problems is the cylinder halves not being clean. For instructions on cleaning them, refer to:
  - o “Clean the Mating Surfaces of the Cylinder Halves” on page 5-3, and
  - o “Clean Inside the Cylinder Halves” on page 5-3

Perform the “Operator’s Check” on page 3-2 to see if the problem has been fixed.

- The second most likely cause of resonator problems is the cylinder halves being out of alignment with each other. Use the following procedure to align the cylinder halves.

### Alignment Procedure

The goal of the alignment process is to have the two cylinder halves aligned to a common central axis. In order to accomplish this, two rotational errors and two translational errors must be minimized. The only tools needed are 2 mm and 3 mm ball-end hex keys, and a feeler gage (all supplied with the resonator).

The resonator’s movable cylinder half (see [Figure 1-1 on page 1-5](#)) is attached to the ball bearing slide, as is the micrometer. The fixed cylinder half (see [Figure 1-1 on page 1-5](#)) is attached to the kinematic/dovetail (K/D) mount. The alignment process involves making small adjustments to the K/D mount until the cylinders are aligned to a common central axis.

The K/D mount has four adjustments — two rotational and two translational — one for each error in position. See [Figure 5-3 on page 5-7](#), showing the adjustment screws and associated error corrections.

### Pre-Alignment

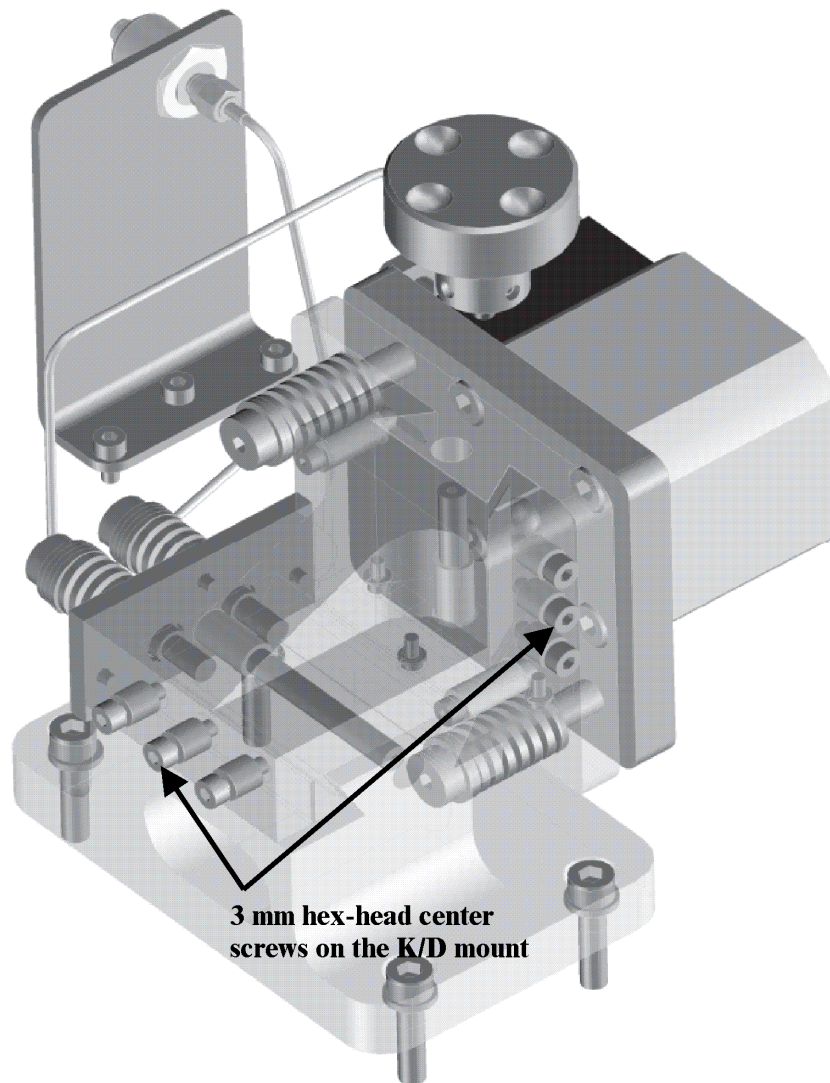
1. Use the 2 mm ball-end hex key (supplied) to loosen, but not remove, the two 2 mm hexhead setscrews in both coupling adjustment knobs. The setscrews can be accessed below the clear plastic covers.
2. Remove both coupling adjustment knobs.
3. Remove the seven sockethead cap screws using the 3 mm ball-end hex key (supplied), along with the lock washers and flat washers that secure both clear plastic covers.
4. Remove both clear plastic covers.
5. Remove the shipment security screw, located on the underside of the stage. It should only be finger tight.
6. Loosen the center screw on each K/D mount using a 3 mm ball-end hex key. If the K/D mount still won’t move freely, loosen the screws on both sides of the center screw. See [Figure 5-2 on page 5-6](#).

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**NOTE** Keep the system security screw in a safe location so that you can install it if you need to ship the resonator.

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**Figure 5-2 3 mm Hex-Head Center Screws on K/D mount**



85072\_001\_502

### **Coarse Alignment**

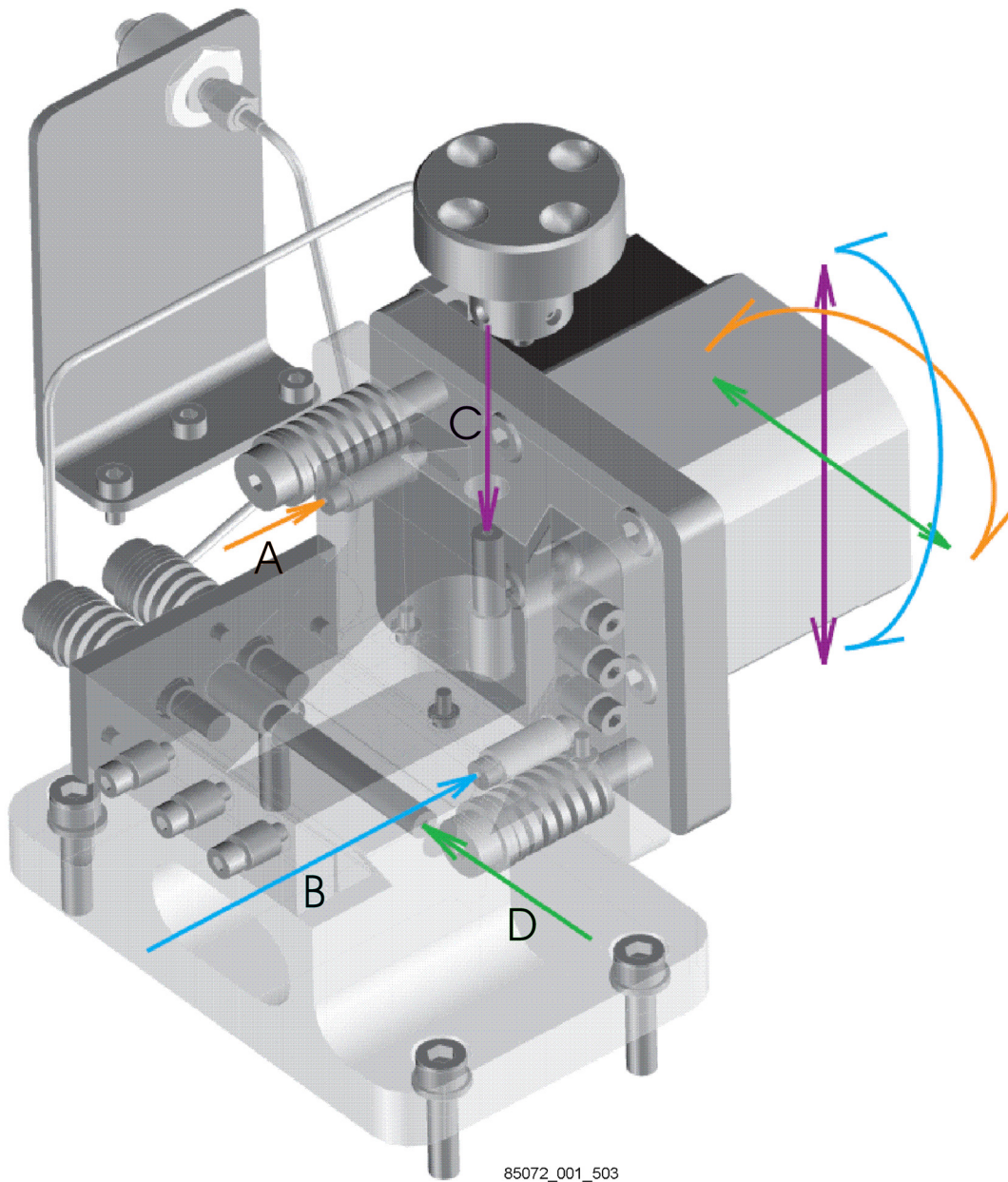
1. Move the cylinder halves together by following steps 1 and 2 in **“Performing the Operator’s Check with the PNA Series Network Analyzer”** on page 3-2.
2. Looking down from the top of the resonator, notice any gaps between the cylinder halves.
3. Find the micro adjuster identified with the orange arrow [A] in **Figure 5-3 on page 5-7**. Using the 2 mm ball-end hex key, turn this micro adjuster until the gap between the cylinder halves is minimized.

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**NOTE** The following graphic includes color and should be viewed online or printed using a color printer.

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**Figure 5-3 Location and Action of the Four Hex Adjusters**



4. Looking from the front of the resonator, notice any gaps between the cylinder halves. When you're facing the front of the resonator, the micrometer is to your right
5. Find the micro adjuster identified with the blue arrow [B] in [Figure 5-3 on page 5-7](#). Using the 2 mm ball-end hex key, turn this micro adjuster until the gap between the cylinder halves is minimized.
6. Find the micro adjuster identified with the purple arrow [C] in [Figure 5-3 on page 5-7](#). Using the 2 mm

### Troubleshooting Process

ball-end hex key, turn this micro adjuster counterclockwise (loosen) and press down on the K/D mount with your thumb until the cylinder halves are at the same height. If you need to raise the fixed cylinder half, turn the micro adjuster clockwise.

7. Find the micro adjuster identified with the green arrow [D] in [Figure 5-3 on page 5-7](#). Using the 2 mm ball-end hex key, turn this micro adjuster until the cylinder halves are aligned back-to-front.

Repeat the Coarse Alignment steps until the gap between the cylinder halves is barely visible.

### Fine Alignment

1. Slowly turn the micrometer's small dial (see [Figure 1-1 on page 1-5](#)) clockwise to further move the cylinder halves together. When the halves are fully closed together, the small dial will continue to turn while making a clicking sound, but will not allow you to overtighten the halves.
2. Zero the micrometer by pressing its middle button.
3. Slowly turn the micrometer's small dial counterclockwise until there is at least a 2 mm gap between the cylinder halves.
4. Insert the feeler gage (supplied) into the gap at the center line between the cylinder halves from the front of the resonator. When you're facing the front of the resonator, the micrometer is to your right. See [Figure 5-4 on page 5-9](#).



**Figure 5-4** Feeler Gage in the Gap Between Cylinder Halves



Feeler gage inserted from front of resonator at center line of gap between cylinder halves

85072\_001\_506

5. Slowly turn the micrometer's small dial clockwise until the cylinder halves tightly clamp the feeler gage and the dial clicks.
6. Record the micrometer reading.
7. Slowly turn the micrometer's small dial counterclockwise and remove the feeler gage.
8. Insert the feeler gage into the gap at the center line between the cylinder halves from the back of the resonator. When you're facing the back of the resonator, the micrometer is to your left.
9. Slowly turn the micrometer's small dial clockwise until the cylinder halves tightly clamp the feeler gage and the dial clicks.
10. Again, record the micrometer reading.  
*The difference between the two micrometer readings is an indication of the rotational error between the two cylinders.*
11. Find the micro adjuster identified with the orange arrow [A] in **Figure 5-3 on page 5-7**. Using the 2 mm ball-end hex key, turn this micro adjuster until the rotational error between the cylinder halves is

**Troubleshooting Process**

minimized.

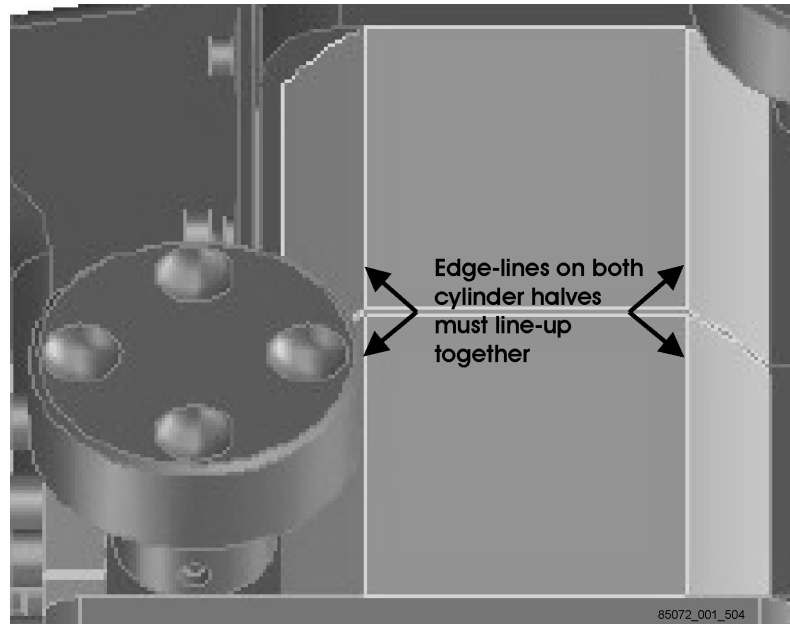
12. Repeat through until the rotational error is less than 5  $\mu\text{m}$ .
13. Record the micrometer reading for later use.
14. Slowly turn the micrometer's small dial counterclockwise until there is at least a 2 mm gap between the cylinder halves.
15. Insert the feeler gage into the gap at the center line between the cylinder halves from the top of the resonator.
16. Slowly turn the micrometer's small dial clockwise until the cylinder halves tightly clamp the feeler gage and the dial clicks.
17. Record the micrometer reading.
18. Using the 2 mm ball-end hex key, turn the micro adjuster (blue arrow [B] in [Figure 5-3 on page 5-7](#)) until the gap between the cylinder halves is the same as that recorded in Fine Alignment . It may be necessary to repeat Fine Alignment through to reduce the total rotational errors to less than 5  $\mu\text{m}$ .
19. Slowly turn the micrometer's small dial counterclockwise until there is approximately a 0.5 mm gap between the cylinder halves.
20. Using the 2 mm ball-end hex key, turn the micro adjuster (purple arrow [C] in [Figure 5-3 on page 5-7](#)) counterclockwise (loosen) and press down on the K/D mount with your thumb until the fixed cylinder half is slightly lower than the movable cylinder half. If you need to raise the fixed cylinder half, turn the micro adjuster clockwise.
21. Holding the feeler gage, place its long edge on top of the fixed cylinder half at the center line. See [Figure 5-5](#).

**Figure 5-5 Using the Feeler Gage**



22. Using the 2 mm ball-end hex key, turn the micro adjuster (purple arrow [C] in [Figure 5-3 on page 5-7](#)) clockwise to slowly tighten as you gently slide the feeler gage from left to right across the center line of the fixed cylinder half until it bumps gently against the movable cylinder half. See [Figure 5-5](#).
23. Repeat this motion while continuing to slowly tighten the micro adjuster (purple arrow [C] in [Figure 5-3 on page 5-7](#)) until the feeler gage no longer bumps against the movable cylinder.
24. Now slide the feeler gage from right to left across the center line of the movable cylinder half to verify that it does not bump against the fixed cylinder half.
25. Repeat to until the feeler gage slides across the center line from either direction without bumping into a cylinder half.
26. Look down the cylinder halves top flats from the side of the resonator with the fixed cylinder half. Notice if the horizontal edge-lines on each cylinder half line-up together, appearing straight as shown in [Figure Minimize the straightness error using the 2 mm ball wrench to tune the micro adjuster \(green arrow \[D\] in \[Figure 5-3 on page 5-7\]\(#\)\).](#)

**Figure 5-6. Edge-Lines on Both Cylinder Halves Must Line-Up Together**



27. Verify the alignment by measuring the feeler gage as in Fine Alignment through .
28. If the variation is more than 5  $\mu\text{m}$ , repeat Fine Alignment through .
29. Tighten the center screws on the K/D mount.
30. Replace covers and cover screws.
31. Replace the coupling adjustment knobs and tighten setscrews.
32. Perform the **“Operator’s Check”** on page 3-2 to see if the alignment was successful.

## **Preparing the Resonator for Shipment**

### **Install the PTFE Sample**

The resonator must be shipped with a rectangular PTFE sample held between the two cylinder halves. The PTFE prevents the mating surfaces of the cylinder halves from accidentally hitting together. To install the PTFE:

- Turn the micrometer's large dial (see [Figure 1-1 on page 1-5](#)) clockwise to move the cylinder halves towards each other, leaving enough space between them to insert the PTFE sample.
- Insert the PTFE sample between the cylinder halves.
- Turn the micrometer's small dial (see [Figure 1-1 on page 1-5](#)) clockwise to tighten the cylinder halves on the PTFE. When the halves are fully tightened, the small dial will continue to turn while making a clicking sound, but will not allow you to overtighten the halves.

### **Lock the Linear Slide**

The resonator must be shipped with the linear slide locked to prevent the movable cylinder-half from moving. To lock it, locate the small, knurled screw on the stage (see [Figure 1-1 on page 1-5](#)) and turn it clockwise until the linear slide won't move when the micrometer is adjusted.

### **Install the Shipment Security Screw**

The resonator must be shipped with the shipment security screw in place. Having the screw in place helps prevent the cylinder halves from moving out of alignment with each other. Hand tighten the screw only - no wrench needed or supplied.

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## Returning a Resonator to Keysight Technologies

If your resonator requires service, contact Keysight Technologies for information on where to send it. See [“Contacting Keysight” on page 5-15](#). Include the following information:

- your company name and address
- a technical contact person within your company, and the person's complete telephone number including country code and area code
- the serial number of the resonator
- the type of service required
- a *detailed* description of the problem (if applicable) and how the resonator was being used when the problem occurred

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**IMPORTANT** Save the original inner-box and foam along with the original or comparable outer-box and foam for reuse to ensure shipment safety.

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## Contacting Keysight

Assistance with test and measurements needs and information on finding a local Keysight office are available on the Web at:

[www.keysight.com/find/assist](http://www.keysight.com/find/assist)

If you do not have access to the Internet, please contact your Keysight field engineer.

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<b>NOTE</b>	In any correspondence or telephone conversation, refer to the Keysight product by its model number and full serial number. With this information, the Keysight representative can determine whether your product is still within its warranty period.
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## **6 Replaceable Parts**

## Introduction

**Table 6-1** lists the replacement part numbers for items included in the 85072A Split Cylinder Resonator.

**Table 6-1 Replaceable Parts for the 85072A Split Cavity Resonator**

Description	Qty	Keysight Part Number
User's and service guide <sup>a</sup>	1	85072-90001
Coupling adjustment knobs	2	5023-0181
Screw-set M4 x 0.7 6MM-LG HEX-SKT-HD	4	0515-2129
F cover (for fixed cylinder half)	1	5023-0184
M cover (for movable cylinder half)	1	5023-0185
3.5 mm bulkhead connector - female	2	5062-6618
Washer-FL MTLC 4.0 4.4-MM-ID 8.85-MM-OD	7	3050-0893
Washer-LK HLCL 4.0 4.1-MM-ID 7.6-MM-OD	7	2190-0586
Washer-LK INTL T 7/16 IN 0.439-IN-ID	2	2190-0104
Nut-HEX-DBL-CHAM UNEF-2B-THD 0.094-IN-THK	2	2950-0132

- a. This document is available online for a free download. Refer to [See "Printing Copies of This Document" on page iii.](#)

**NOTE** To purchase extra PTFE samples, go to [www.mcmaster.com](http://www.mcmaster.com) and order part number 8545K13.

**Table 6-2 Items Not Included with the Split Cylinder Resonator**

Description	Qty	Keysight Part or Model Number
<b>Misc.</b>		
85071E Materials Measurement Software with Option 300 Resonant Cavity Software	1	85071E-300 UL7 (parallel key) —or— UL8 (USB key)
N4419AK20 3.5 mm male-to-female flexible cable	2	E7342-60004
PNA Series, PNA-X Series, or PNA-L Series Network Analyzer	1	varies <sup>a</sup>
<b>Wrenches</b>		
1/2 inch and 9/16 inch, open-end wrench	1	8710-1770
5/16 inch (8 mm), open-end torque wrench; 0.9 N-m (8 in-lb)	1	8710-1765
<b>ESD Protection Devices</b>		
Grounding wrist strap	1	9300-1367
5 ft grounding cord for wrist strap	1	9300-0980
2 x 4 ft conductive table mat and 15 ft ground wire	1	9300-0797
<b>Connector Cleaning Supplies</b>		
Anhydrous isopropyl alcohol (>92% pure) <sup>b</sup>	--	--
Compressed air	--	--
Cleaning swabs	100	9301-1243

a. For more information, go to [www.keysight.com](http://www.keysight.com) and type “PNA Network Analyzer” in the search function.

b. Keysight can no longer safely ship isopropyl alcohol, so customers should purchase it locally.



## **7 Replacement Procedures**

## Replacing Parts in the Resonator

This chapter contains procedures for replacing the following resonator parts:

- 3.5 mm connectors
- Clear plastic covers
- Coupling adjustment knobs

For replacement of all other parts, the resonator must be returned to Keysight. See [“Contacting Keysight” on page 5-15](#).

### Replacing the 3.5 mm Connectors

#### Required Tools

- 2 mm ball-end hex key (supplied)
- 3 mm ball-end hex key (supplied)
- 5/16” torque wrench (not supplied)
- 9/16” open-end wrench (not supplied)

#### Required Parts

**Table 7-1 Required Parts for Replacing the 3.5 mm Connectors**

Part Number	Quantity	Description
5023-0181	2	Coupling adjustment knobs
0515-2129	4	Screw-set M4 x 0.7 6MM-LG HEX-SKT-HD
5023-0184	1	F cover (for fixed cylinder half)
5023-0185	1	M cover (for movable cylinder half)
5062-6618	2	3.5 mm bulkhead connector - female
3050-0893	7	Washer-FL MTLC 4.0 4.4-MM-ID 8.85-MM-OD
2190-0586	7	Washer-LK HLCL 4.0.4.1-MM-ID 7.6-MM-OD
2190-0104	2	Washer-LK INTL T 7/16 IN 0.439-IN-ID
2950-0132	2	Nut-HEX-DBL-CHAM UNEF-2B-THD 0.094-IN-THK

#### Procedure

1. Use the 2 mm ball-end hex key (supplied) to loosen, but not remove, the two 2 mm hexhead setscrews in both coupling adjustment knobs. The setscrews can be accessed below the clear plastic covers.
2. Remove both coupling adjustment knobs.
3. Use the 3 mm ball-end hex key (supplied) to remove the seven M4 sockethead cap screws from the clear

plastic covers, and then remove the lock washers, and flat washers.

4. Remove both clear plastic covers.
5. Use a 5/16" torque wrench (not supplied) to unscrew the semi-rigid coaxial cable nuts from the back of the connectors. Be careful not to bend the cables.
6. Use a 9/16" torque wrench (not supplied) to unscrew the nuts from the back of the connectors.
7. Remove and recycle the original connectors and lock washers.
8. Install the new connectors and lock washers.
9. Reinstall the nuts on the back of the connectors.
10. Reinstall semi-rigid coaxial cable nuts and torque to 8 in-lbs.
11. Reinstall the plastic covers, replacing the seven M4 sockethead cap screws, lock washers, and flat washers.
12. Reinstall original (or install new) coupling adjustment knobs. Set the height of the knobs so that there is approximately a 1 mm gap between the underside of the knobs and the clear plastic covers.
13. Tighten the setscrews in both knobs.

## Replacing the Clear Plastic Covers

See [Step 1](#) through [Step 4](#), and [Step 11](#) through [Step 13](#) in "Replacing the 3.5 mm Connectors" on page 7-2.

### Required Tools

- 2 mm ball-end hex key (supplied)
- 3 mm ball-end hex key (supplied)

### Required Parts

**Table 7-2 Required Parts for Replacing the Clear Plastic Covers**

Part Number	Quantity	Description
5023-0184	1	F cover (for fixed cylinder half)
5023-0185	1	M cover (for movable cylinder half)
3050-0893	7	Washer-FL MTLC 4.0 4.4-MM-ID 8.85-MM-OD
2190-0586	7	Washer-LK HLCL 4.0.4.1-MM-ID 7.6-MM-OD

## Replacing the Coupling Adjustment Knobs

See [Step 1](#), [Step 2](#), [Step 12](#), and [Step 13](#) in “Replacing the 3.5 mm Connectors” on page 7-2.

### Required Tools

- 2 mm ball-end hex key (supplied)

### Required Parts

**Table 7-3. Required Parts for Replacing the Coupling Adjustment Knobs**

Part Number	Quantity	Description
5023-0181	2	Knob
0515-2129	4	Screw-set M4 x 0.7 6MM-LG HEX-SKT-HD



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