

Assembly instruction Series SMA 0000181590

Old instruction No. 27032

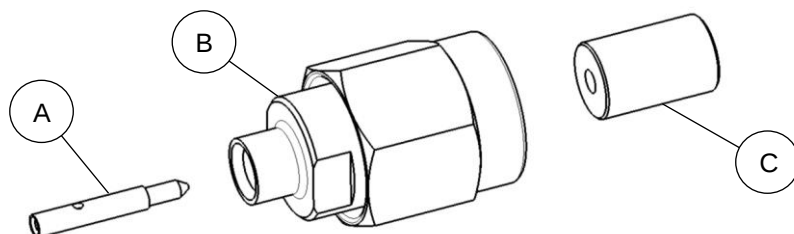


Connector type: (e.g.)	Suitable cables:
11_SMA-50-2-100	EZ-86 , SM-86
11_SMA-50-3-100	EZ-141 , SM-141 , MF-141

Inner conductor contact:	Soldered
Outer conductor contact:	Soldered

Parts list connector:

For MULTIFLEX cable it is recommended to use a Shrink tube. The shrink tube is not included in the connector.



Assembly steps:

Picture	Process	Feature / Check	Tools required
EZ cable SUCOFORM	For EZ and SM cables Prepare cable according to diagram. Dimension 11 mm applies to SUCOFORM with jacket.	Cut cable end perpendicular to cable axis. Do not damage centre contact, dielectric and braid.	Stripping tool W 157. See instruction sheet DOC-0000199604 for detailed description. Blades (74_Z 0-0-68) Tip trimmer tool W 164
MULTIFLEX	For MF cables Divide the on length cutted cable in flux and tin. Cut in jacket until screen. Remove jacket. Remove cable dielectric and tinned braid according to diagram.	The solder must flow at behind for min. 8 mm. If the cable does not fit into the cable entry, use a flat-nose pliers to calibrate the outer contact.	Blades (74_Z 0-0-68) Flat-nose pliers
W 58 or W 442 W 262 or W 263 W 54	Push contact A onto contact holder W 54. Fix cable in soldering fixture W 58. Place soldering gauge on centre contact. Flow small amount of solder into bore of contact. Push contact holder against soldering gauge and solder.	Clean contact A and cable dielectric. Remove excess solder. Check dimension 6.2 mm.	Gauge W 263: EZ , SM-86 Gauge W 262: EZ , MF , SM-141 Contact holder W 54 Soldering fixture W 58, W 442 Inserts W 60 (EZ-86 or SM-86) Inserts W 59 (EZ-141 or SM-141) Inserts W 365 (MF-141)
W 58 or W 442 W 369	Slide body B over cable. Push body B completely against locator tool W 369. Solder body B to cable. Remove excess dielectric using W 281.	Avoid excessive heat. Clean and cool soldered area immediately with alcohol. Remove any residual flux.	Locator tool W 369 Soldering fixture W58, W442 Inserts as described above Face cutter W 281
W 224	Screw dielectric insert tool W 224 onto connector. Place insulator C in rear opening of insert tool and press fully through insert tool into connector.	Press in insulator until stop	Dielectric insert tool W 224
0.125 ±0.125 0.125 ±0.125	Check interface dimensions.	Distance from shoulder of contact A and insulator C to reference plane.	
Shrink tube X B	Slide shrink tube over connector body B and shrink with Hot-air fan. Dimension X max. 1 mm.	Avoid excessive heat.	Hot-air fan

The cable assembly of R.F. connectors can only be done by well trained assembly staff and suitable assembly equipment. Huber+Suhner's skilled staff and specialised equipment are available to carry out complete R.F. lead-assembly on your behalf. We mount your connectors on cables at economic prices! Please contact our representative for further details of this service.

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