

Assembly instruction Series SMA 0000179086



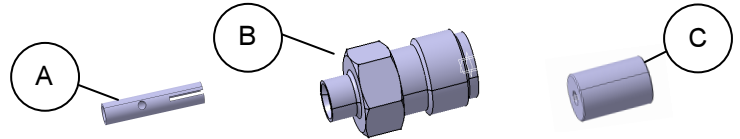
Connector type: (e.g.)		Suitable cables:
21 SMA-50-2-15	25 SMA-50-2-15	EZ-86 , SM-86 , MF-86
21 SMA-50-3-15	25 SMA-50-3-15	
24 SMA-50-2-15	25 SMA-50-2-25	EZ-141 , SM-141 , MF-141
24 SMA-50-3-15	25 SMA-50-3-25	

Inner conductor contact:	Soldered
Outer conductor contact:	Soldered

Parts list connector:

Note 1

If it is not possible to fulfill the electrical requirements, leave dimension 3.6 out (same stripping dimension like the EZ cables).
CAUTION: Without this additional shoulder, we recommend to test 100 % for short circuit.



Assembly steps:

Picture	Process	Feature / Check	Tools required
	<u>For EZ and SM cables</u> The tool must be set for a stripping dimension X. EZ cable : X = 3.1 mm SM cable : X = 3.6 mm	Cut cable end perpendicular to cable axis.	Stripping tool W 157. See instruction sheet No. 9144 for detailed description.
	Remove dielectric according to diagram. Dimension Y applies to cables with jacket. Debur centre contact. 21 SMA types : Y = 11.5 mm 24 SMA types : Y = 18 mm 25 SMA types : Y = 11.5 mm	Do not damage centre contact, dielectric and braid. If a SM cables is used see note 1.	Blades (74 Z 0-0-68) Tip trimmer tool W 164.
	<u>For Multiflex 141</u> Dive 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. 21 / 25 SMA types : Y = 11.5 mm 24 SMA types : Y = 18 mm	The solder must flow at behind for min. 6.5 mm. If the cable does not fit into the cable entry, use a flat-nose plier to calibrate the outer contact. See note 1.	Activated rosin flux Solder Blades (74 Z 0-0-68) Flat-nose plier
	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 6.6 mm.	Soldering iron, Solder Activated rosin flux Gauge W56: EZ, MF, SM-86 (0.4) Gauge W55: EZ, MF, SM-141 (0.25) Contact holder W 54. Soldering fixture W58, W442 Inserts W 60 (EZ or SM-86) Inserts W 364 (MF-86) Inserts W 59 (EZ or SM-141) Inserts W 365 (MF-141)
	Slide body B over cable. Push body B completely against locator tool W 368. Solder body B to cable.	Avoid excessive heat. Promptly swap soldered area with alcohol to cool joint and remove any residual flux.	Soldering iron, Solder Activated rosin flux Alcohol and brush Locator tool W 368 Soldering fixture W58, W442 Inserts as described above
	Screw dielectric insert tool W 53 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 53
	Check interface dimension.	Distance shoulder of pin and Insulator to reference plane.	

The cable assembly of R.F. connectors can only be done by well trained assembly stuff and suitable assembly equipment.
Huber+Suhr's skilled stuff 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.

Revision	B
Date	30.04.04
Initiator	4779/JPE