## Assembly instruction Series SMA M No. 27061

Tools and materials required :		Straight connectors for flexible cables	
Soldering iron 80 to 100 Watts / 220 to 240°C Solder Sn/Pb 60/40, 0,8mm Ø , activated rosin flux Scissors, blade (74 Z-0-0-68) Contact holder No. W 54 Locator tool No. W 14 "M" Crimp tool A		Cable entry : crimped	
		Connector types : (e.g.) 11 SMA 50 - 1 - 4 11 SMA 50 - 1 - 5	Cable : (e.g.) RG 196 A/U S 01132
This connector	Centre contact :	soldered	
is supplied in 3 parts	Braid :	cavity A	
A	B	0 -0,25	0 _0,25 max. 2,5
A	8 2	If required, slide taper sleeve or heat-shrink sleeve onto cable (not illustrated). Slide ferrule A onto cable. Prepare cable according to diagram. CAUTION: Do not damage braid, inner conductor and dielectric of cable! Strip carefully and without lateral pressure on inner conductor.	
A	B w 54	Push contact B onto contact holder W 54.  Heat contact B using a dry soldering iron.  Flow a small amount of solder into bore hole of contact,  insert inner conductor of cable and solder to contact.  Clean contact B and cable dielectric, remove excess solder.	
[2,7] X		Mount locator tool W 14 onto connector body C ("M" for male.)	
		Splay out braid and insert carefully prepared cable fully into connector body.  Ensure that braid lies above the crimp neck.	
		Slide ferrule A over braid to about connector body C and crimp as close to connector body C as possible. Remove locator tool and check interface dimensions.	

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.

