

Assembly instruction Series SMA v8 No.27123

Tools and materials required:

Soldering iron 80 to 100 Watts/220 to 240°C
 Solder Sn/Pb 60/40 0,8mm Ø activated rosin flux
 Alcohol, brush, flat nose pliers, blade (74 Z-0-0-68)
 SR cable stripping tool No.W 157
 Soldering fixture No.W 58
 Dielectric trim-jig No.W 2-2 (74 Z-0-2-2)
 Inserts No.W 60
 Tip trimmer No.W 164
 Positioner No.W 164
 Contact holder No.W 54
 Locator tool No.W 61

Straight connectors for copper jacket cable

Cable entry: soldered

Connector types: (e.g.)

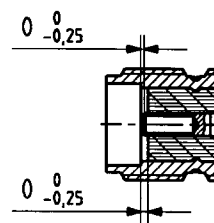
24 SMA - 50 - 2 - 41

24 SMA - 50 - 2 - 50

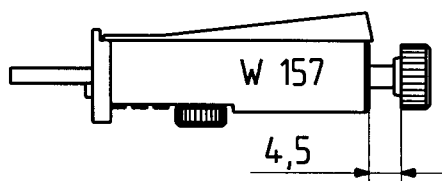
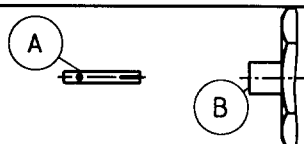
Suitable cable:

EZ 86 (.086")

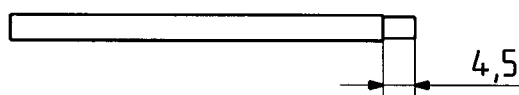
EZ 86 (.086")



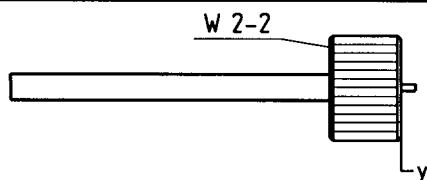
This connector is supplied in 2 parts.



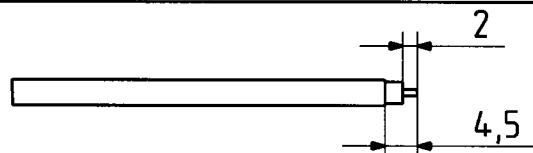
Cut cable end perpendicular to cable axis.
 Cut back copper jacket using cable stripping tool W 157.
 See instruction sheet No. 9144 for detailed description.
 The tool must be set for stripping dimension at 4,5mm.



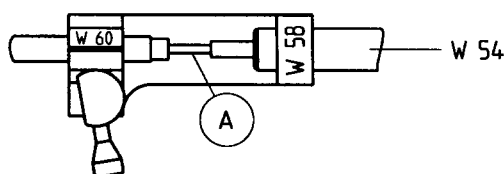
Check dimension 4,5mm.



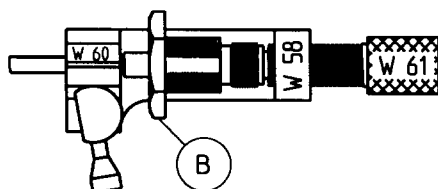
Slide trim-jig W 2-2 on to cable.
 Cut back dielectric along plane y, do not damage inner conductor of cable (use blade).
 Remove trim jig W 2-2, from tip of inner conductor to a 90° cone, using tip trimmer W 164.



Check dimension.
 Tin centre conductor lightly.



Push contact A onto contact holder W 54 and fix cable in soldering fixture W 58 as illustrated.
 Heat contact A, using a dry soldering iron.
 Flow small amount of solder into bore hole of contact, introduce inner conductor of cable and solder to contact.
 Clean contact b and cable dielectric, remove excess solder.



Slide connector body B over prepared cable.
 Place in soldering fixture W 58.
 Screw locator tool W 61 fully against cable end.
 Solder body B to the cable.
 Avoid excessive heat, cool down immediately and clean with alcohol. Remove assembly connector from fixture and check interface dimension.

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.



HUBER + SUHNER AG CH-9100 HERISAU

Deutscher Text: siehe Rückseite