

Assembly instruction Series BMA No.27180

Tools and materials required:

Soldering iron 80-100 Watts/220-240°C
 Solder Sn/Pb 60/40, 0,8mm Ø activated rosin flux
 Alcohol, brush, flat-nose pliers, blade
 Stripping tool No.W 157
 Soldering fixture No.W 58
 Locator tool No.W 210 / W 209 see table
 Inserts No.W 133
 Soldering Gauge No.W 162
 Tip trimmer No.W 164

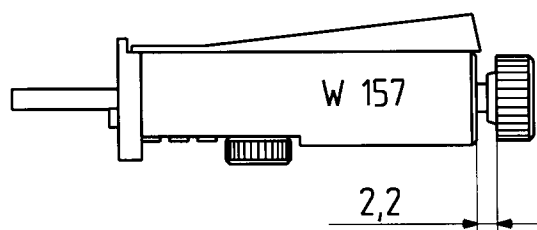
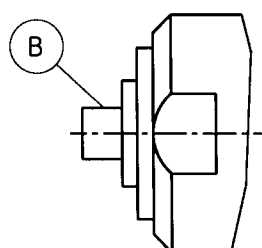
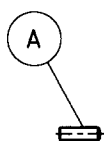
Straight connector for copper jacket

Cable entry: soldered

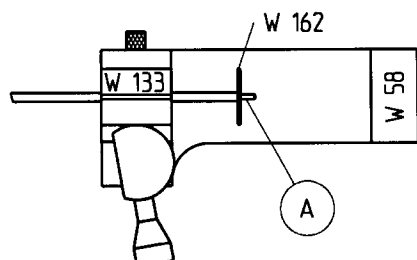
Connector types: (e.g.)

14 BMA - 50 - 1 - 15	24 BMA - 50 - 1 - 2
Locator tool No. W209	Locator tool No. W210
cable EZ 47 (.047")	cable EZ 47 (.047")

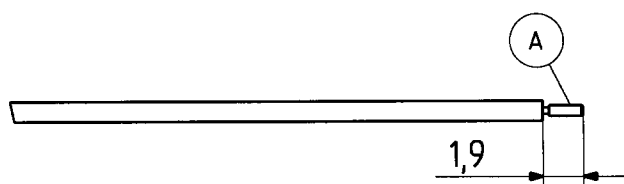
This connector
is supplied
in 2 parts



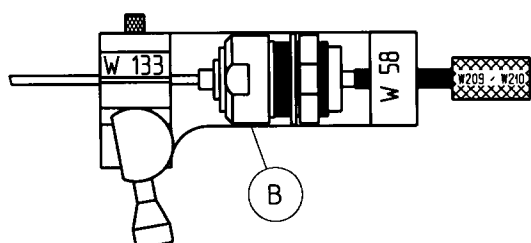
Cut cable in a plane perpendicular to the cable axis. Remove copper jacket using stripping tool W 157.
 Set tool to stripping length $L=2,2\text{mm}$.
 Remove dielectric flush with copper jacket using blade.



Place soldering gauge W 162 over inner conductor of cable as illustrated.
 Press contact sleeve A against soldering gauge W 162 and solder to conductor.



Immediately remove heat, cool down and inspect dimension 1,9mm.
 Point contact sleeve A using tip trimmer W 164.



Push connector body B onto the cable.
 Place cable in soldering fixture as shown.
 Tighten locator tool fully against body B. Solder body B to cable, avoid excessive heat, immediately cool down and clean with alcohol.

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

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