

# Assembly instruction Series SMA No. 27266

## Tools and materials required :

Soldering iron 80 to 100 Watts / 220 to 240°C  
 Solder Sn/Pb 60/40,  $\varnothing$  0,8 mm  
 activated rosin flux  
 Scissors, blade (74Z-0-0-68)  
 Contact holder Nr. W 54  
 Locator tool Nr. W 14 "M"

Straight connectors for flexible cables

Cable entry : crimped

Connector types : (e.g.)

11 SMA 50 - 2 - 5

11 SMA 50 - 2 - 6

Cable : (e.g.)

RG 188 A/U

K 02252-d

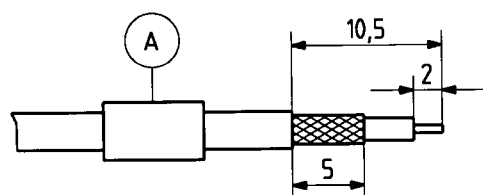
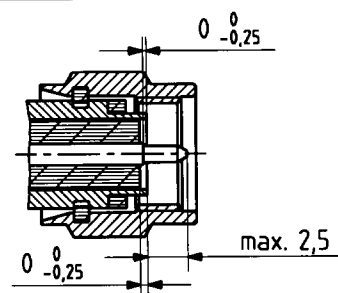
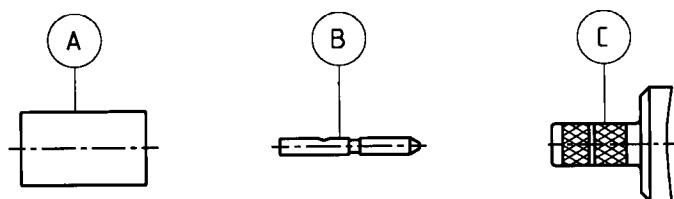
This connector  
is supplied  
in 3 parts

Centre contact :

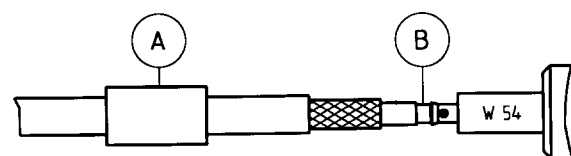
Braid :

soldered

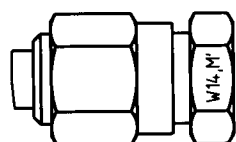
cavity A



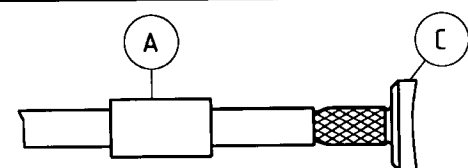
Slide ferrule A onto cable.  
 Prepare cable according to diagram.  
 CAUTION : Do not damage braid, dielectric  
 and inner conductor of cable!



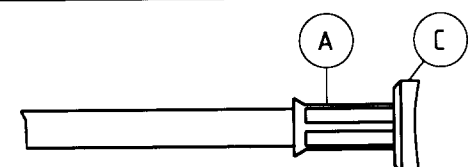
Push contact B onto contact holder W 54.  
 Heat contact B using a dry soldering iron.  
 Flow small amount of solder into bore hole of contact,  
 insert inner conductor of cable and solder to contact.  
 Clean contact B and cable dielectric, remove excess solder.



Mount locator tool W 14 onto connector body C



Splay out braid and insert carefully prepared cable  
 fully into connector body C.  
 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.



HUBER + SUHNER AG CH-9100 HERISAU

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