

Assembly instruction Serie SMB,SMC,SMS U12 No.9002

Tool 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
 Tip trimmer No. W 164
 Positioner No. W 81 (zu W 164)
 Inserts No. W 60
 Soldering gauge No. W 55 (0,25mm)
 Soldering fixture No. W 58
 Crimp tool 1, 2, A (rot)

Straight connectors for copper jacket cable

Cable entry : soldered (center contact may be crimped)

Connector types : (e.g.)

11 SMB/C/S 50-2-13

21 SMB/C/S 50-2-13

24 SMB/C/S 50-2-13

This connector
is supplied
in 2 parts.

Suitable cables :

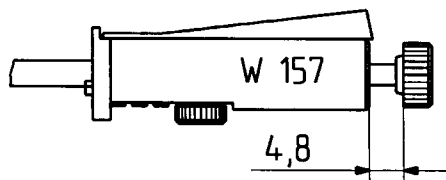
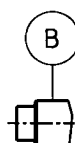
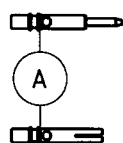
EZ 86 (.086")

Centre contact : captive

soldered

Copper jacket :

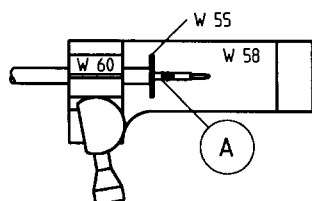
soldered



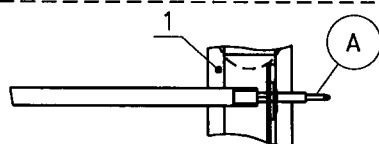
Cut cable end perpendicular to cable axis.
 Cut back copper jacket using cable stripping tool W 157.
 See instruction sheet No. 9144 for detailed description.
 The tool must be set for 4,8mm stripping dimension.



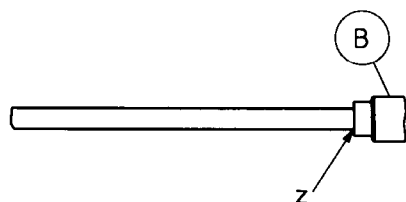
Cut back 2,7mm of dielectric, do not damage inner conductor of cable.
 Form tip of inner conductor with tip trimmer W 164 und positioner W 81.
 Check dimension 2,7mm and 4,8mm.



Fix cable in soldering fixture W 58 as illustrated.
 Place soldering gauge W 55 (0,25mm) on inner conductor as illustrated.
 Heat hole of centre contact A with soldering iron and tin-plate.
 Press centre contact A against soldering gauge W 55 (0,25mm and solder to conductor. Clean contact pin A and cable dielectric.



Alternatively centre contact A may be crimped.
 Push centre contact A over inner conductor of cable to abut cable dielectric and crimp with insert 1.



Push prepared cable into connector body B to the positive stop.
 Solder connector body B to copper jacket at z.
 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

Deutscher Text : siehe Rückseite