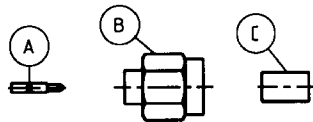


Assembly instruction Series SMA No. 9056

Tools and materials required:

Soldering iron 80 to 100 W/220 to 240°C
 Solder Sn/Pb 60/40 0,8mm Ø activated rosin flux
 Alcohol, brush, flat nosed pliers, blade
 SR cable stripping tool No. W 157
 Soldering fixture No. W 58
 Locator tool No. W 61
 Inserts (see table) No. W 59 oder W 60
 Soldering gauge (see table) No. W 55 oder W 56
 Tip Trimmer No. W 164
 Contact Holder No. W 54
 Dielectric insert tool No. W 52
 Trimtool No. W 142

This connector is supplied in 3 parts



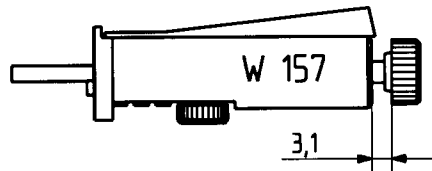
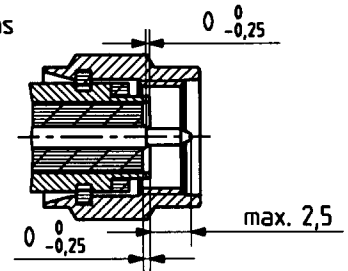
Straight connectors for copper jacket cable

Cable entry: soldered

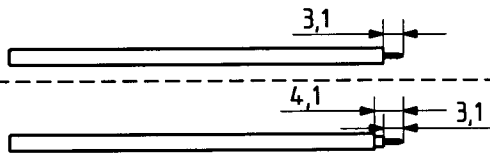
Connector types: e.g.

11 SMA 50-2-2	11 SMA 50-2-15	Kabel EZ 086 (.086")
11 SMA 50-3-15	11 SMA 50-3-65	Kabel EZ 141 (.141")
11 SMA 50-2-17	11 SMA 50-2-65	Kabel EZ 086 (.086")
11 SMA 50-3-38		Kabel EZ 141 (.141")

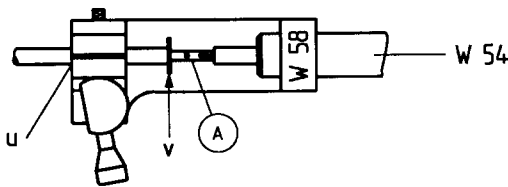
SMA plug interface dimensions



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 3,1mm stripping dimension.

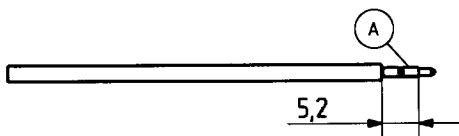


Remove dielectric flush with copper jacket using a blade.
 Form tip of inner conductor to a 90° cone using tip trimmer W 164.

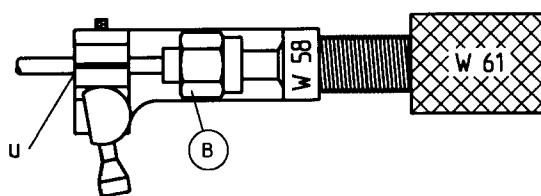


Push contact A onto contact holder W 54.
 Fix cable in soldering fixture W 58 as illustrated.
 Place soldering gauge on inner conductor as illustrated.
 Flow small amount of solder into bore of contact.
 Push contact holder against soldering gauge and solder.

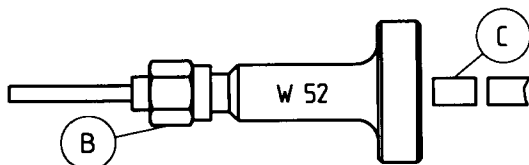
cable	Insert u	Soldering gauge v
EZ 086 (.086")	W 60	W 56 (0,4mm)
EZ 141 (.141")	W 59	W 55 (0,25mm)



Immediately cool down, remove cable from fixture and check dimension 5,2 mm.



Slide connector housing B over cable and fix cable in fixture.
 Tighten locator tool W 61 fully against cable end.
 Push connector housing B completely against locator tool W 61 and keep in this position.
 Solder connector housing B to cable, avoid excessive heat, immediately cool down and clean with alcohol.
 Remove extended dielectric using W 142.



Screw dielectric insert tool W 52 onto connector.
 Place insulator C in rear opening of insert tool and press fully through insert tool into connector.
 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

Deutscher Text: siehe Rückseite