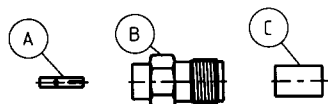


# Assembly instruction Series SMA v10 No. 9057

## 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 53  
 Trimtool No. W 142

This connector  
 is supplied  
 in 3 parts



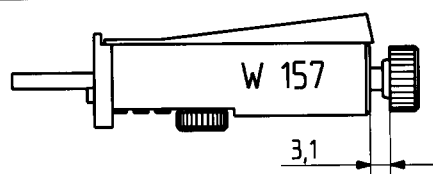
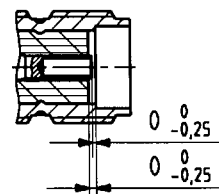
## Straight connectors for copper jacket cable

### Cable entry: soldered

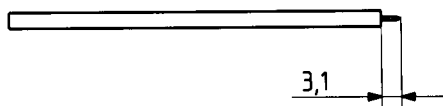
### Connector types: e.g.

21 SMA-50-2-15	25 SMA 50-2-15	Kabel EZ 086 (.086")
21 SMA 50-3-15	25 SMA 50-3-15	Kabel EZ 141 (.141")
24 SMA 50-2-15	25 SMA 50-2-25	Kabel EZ 086 (.086")
24 SMA 50-3-15	25 SMA 50-3-25	Kabel EZ 141 (.141")

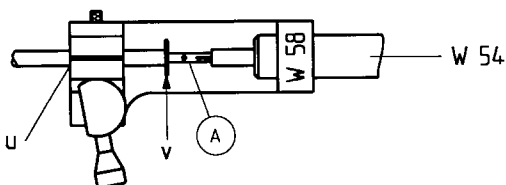
### SMA female connector interface dimensions



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.

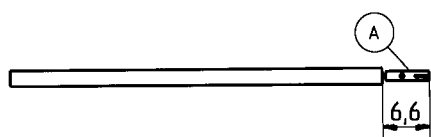


Remove dielectric flush with copper jacket using a blade.  
 Form tip of inner conductor to a 90° cone using tip trimmer W 164.

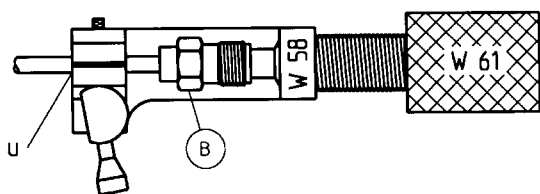


Push contact A onto contact holder W 54.  
 Fix cable in soldering fixture W 58 as illustrated.  
 Place soldering gauge on inner conductor as illustrated.  
 Flow small amount of solder into bore of contact.  
 Push contact holder against soldering gauge and solder.

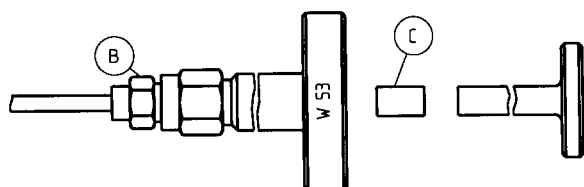
cable	Insert u	Soldering gauge v
EZ 086 (.086")	W 60	W 56 (0,4mm)
EZ 141 (.141")	W 59	W 55 (0,25mm)



Immediately cool down, remove cable from fixture and  
 check dimension 6,6mm



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 53 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