

Assembly instruction Series SMA 0000178687



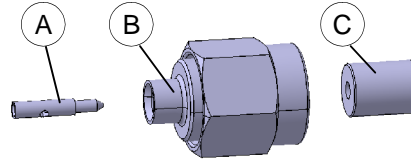
Connector type: (e.g.)		Suitable cables:
11 SMA-50-2-15 11 SMA-50-2-65	15 SMA-50-2-1 11 SMA-50-2-165	EZ_86 , SM_86 , MF_86
11 SMA-50-3-15 11 SMA-50-3-65	11 SMA-50-3-34	EZ_141 , SM_141 , MF_141

Inner conductor contact:	Soldered
Outer conductor contact:	Soldered

Parts list connector:

Note 1

If it is not possible to fulfill the electrical requirements, leave dimension 3,6 out (same stripping dimension like the EZ cables).
CAUTION: Without this additional shoulder, we recommend to test 100 % for short circuit.



For MULTIFLEX cable it is recommended to use a Shrink tube. The Shrink tube is not included in the connector.

Assembly steps:

Picture	Process	Feature / Check	Tools required
<p>EZ cable</p> <p>SUCOFORM</p>	<p><u>For EZ and SM cables</u> Remove dielectric according to diagram. Dimension Y applies to SM cables with jacket. Deburr centre contact. For 11 SMA types : Y = 12mm For 15 SMA types : Y = 17mm</p>	<p>Cut cable end perpendicular to cable axis. Do not damage centre contact, dielectric and braid. If a SUCOFORM cables is used see note 1.</p>	<p>Stripping tool W 157. See instruction sheet No. 9144 for detailed description. Blades (74 Z 0-0-68) Tip trimmer tool W 164.</p>
<p>MULTIFLEX</p>	<p><u>For Multiflex cables</u> Dive the on length cutted cable in flux and tin. Cut in jacket until screen. Remove jacket. Remove cable dielectric and tinned braid according to diagram. For 11 SMA types : Y = 12mm For 15 SMA types : Y = 17mm</p>	<p>The solder must flow at behind for min. 6.5 mm. If the cable does not fit into the cable entry, use a flat-nose plier to calibrate the outer contact. See note 1.</p>	<p>Blades (74 Z 0-0-68) Flat-nose plier</p>
<p>W 58 or W 442</p> <p>W 55 or W 56</p> <p>W 54</p>	<p>Push contact A onto contact holder W 54. Fix cable in soldering fixture W 58. Place soldering gauge on centre contact. Flow small amount of solder into bore of contact. Push contact holder against soldering gauge and solder.</p>	<p>Clean contact A and cable dielectric. Remove excess solder. Check dimension 5.2mm.</p>	<p>Gauge W56: EZ,MF,SM-86 (0.4) Gauge W55: EZ,MF,SM-141(0.25) Contact holder W 54. Soldering fixture W58, W442 Inserts W 60 (EZ or SM-86) Inserts W 364 (MF-86) Inserts W 59 (EZ or SM-141) Inserts W 365 (MF-141)</p>
<p>W 58 or W 442</p> <p>W 369</p> <p>B</p>	<p>Slide body B over cable. Push body B completely against locator tool W 369. Solder body B to cable.</p>	<p>Avoid excessive heat. Promptly swap soldered area with alcohol to cool joint and remove any residual flux.</p>	<p>Locator tool W 369 Soldering fixture W58, W442 Inserts as described above</p>
<p>W 52</p> <p>B</p> <p>C</p>	<p>If necessary, countersink hole, before press in the insulator. 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.</p>	<p>Press in insulator until stop</p>	<p>Milling tool W 142 Dielectric insert tool W 52</p>
<p>0 / -0.25</p> <p>0 / -0.25</p>	<p>Check interface dimension.</p>	<p>Distance shoulder of pin and Insulator to reference plane.</p>	
<p>Shrink tube</p> <p>X</p>	<p>Slide shrink tube over connector body B and shrink with Hot-air fan. Dimension X max. 1mm.</p>	<p>Avoid excessive heat.</p>	<p>Hot-air fan</p>

The cable assembly of R.F. connectors can only be done by well trained assembly staff and suitable assembly equipment. Huber+Suhr'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.

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