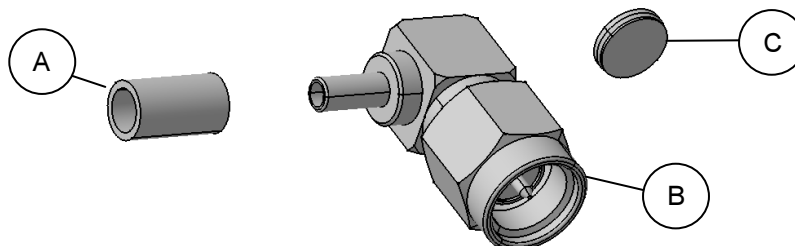


# Assembly instruction Series SMA 0000178742

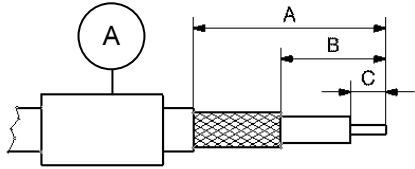
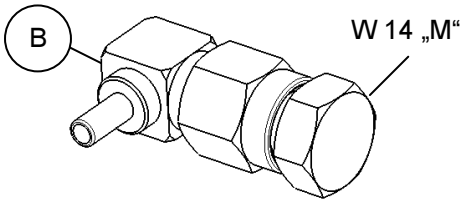
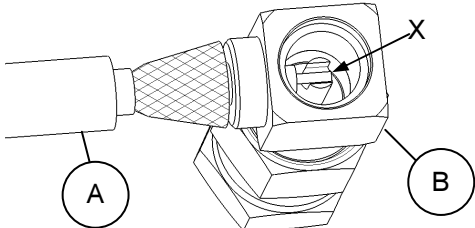
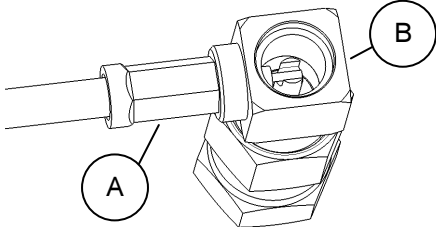
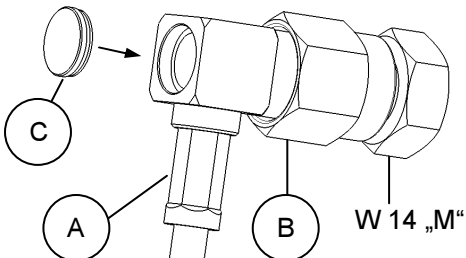


Connector type (e.g.):	16 SMA-50-1-1, 16 SMA-50-2-105, 16 SMA-50-3-105	Inner conductor contact:	Soldered
Suitable cables (e.g.):	RG 178/U, K 02252D, RG 58 C/U	Outer conductor contact:	Crimped

## Parts list connector:



## Assembly steps:

Assembly steps:				Process	Feature / Check	Tools required													
<table><tr><td>Connector type</td><td>A</td><td>B</td><td>C</td></tr><tr><td>16 SMA-50-1-.. , 16 SMA-50-2-..</td><td>11</td><td>6</td><td>2</td></tr><tr><td>16 SMA-50-3-..</td><td>13.5</td><td>6</td><td>3</td></tr></table>				Connector type	A	B	C	16 SMA-50-1-.. , 16 SMA-50-2-..	11	6	2	16 SMA-50-3-..	13.5	6	3	Slide ferrule A onto cable. Prepare cable according to diagram.	Do not damage braid, dielectric and inner conductor of cable.	Stanley blade scissors	
Connector type	A	B	C																
16 SMA-50-1-.. , 16 SMA-50-2-..	11	6	2																
16 SMA-50-3-..	13.5	6	3																
																			
				Screw locator tool W14 "M" onto connector body B.		Locator tool W14 "M"													
				Slide prepared cable into connector body B until inner conductor of cable is flush at X.	Ensure that braid lies above crimp neck														
				Slide ferrule A over braid and crimp. Solder inner conductor to cable	Crimp as close to connector body B as possible	<table><tr><td>Connector type</td><td>Crimp tool</td></tr><tr><td>16 SMA-50-1-...</td><td>Cavity A</td></tr><tr><td>16 SMA-50-2-...</td><td></td></tr><tr><td>16 SMA-50-3-...</td><td>Cavity B</td></tr></table>	Connector type	Crimp tool	16 SMA-50-1-...	Cavity A	16 SMA-50-2-...		16 SMA-50-3-...	Cavity B					
Connector type	Crimp tool																		
16 SMA-50-1-...	Cavity A																		
16 SMA-50-2-...																			
16 SMA-50-3-...	Cavity B																		
				Place cover C on rear aperture of body B. Press cover C into body B.		Small press or a small bench vice.													

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

Revision	E
Date	13.04.06
Initiator	4186/MAP