

# Assembly instruction

Series SMA

AC 9/18/02  
JTH

No. 9056

## Tools and materials required :

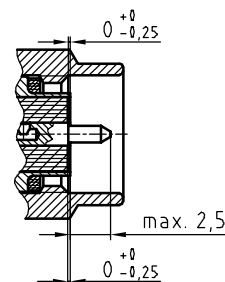
Soldering iron 80 to 100 Watts / 220°C to 240°C  
Solder Sn/Pb 60/40 0,8mm Ø activated rosin flux,  
Alcohol, brush, flat nosed pliers, blade  
SR cable stripping tool No. W 157  
Soldering fixture No. W 58  
Locator tool No. W 61  
Inserts (see table) No. W 59, W 60  
Soldering gauge (see table) No.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

## Straight connectors for copper jacket cable

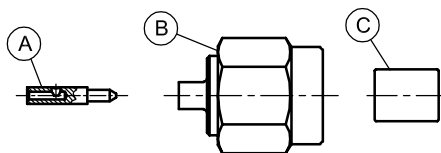
### Cable entry : soldered

Connector types : (e.g.)		Cable types: (e.g.)
11 SMA-50-2-2	11 SMA-50-2-15	EZ 086 (0,86")
11 SMA-50-3-15	11 SMA-50-3-65	EZ 141 (0,141")
11 SMA-50-2-17	11 SMA-50-2-65	EZ 086 (0,086")
11 SMA-50-3-38		EZ 141 (0,141")

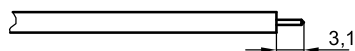
### SMA plug interface dimensions



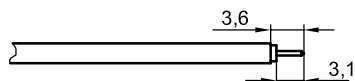
This connector is supplied in 3 parts



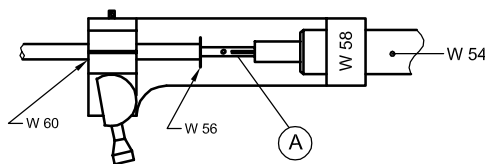
Cut cable end perpendicular to cable axis.  
Cut back copper jacket using cable stripping tool W 157.  
See instruction sheet No. 9144 for detailed description.  
The tool must be set for 3,1mm stripping dimension.



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

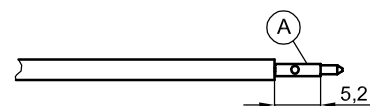


CAUTION: Prepare Sucoform 86 and Multiflex 86 cable according to diagram.

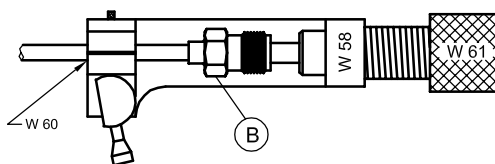


Push contact A onto contact holder W 54.  
Fix cable in soldering fixture W 58 as illustrated.  
Place soldering gauge on inner conductor as illustrated.  
Flow small amount of solder into bore of contact.  
Push contact holder against soldering gauge and solder.

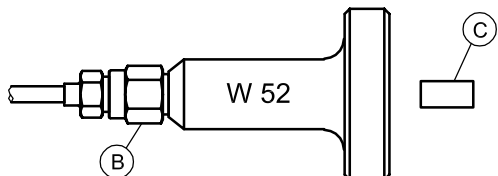
Cable	Insert u	Soldering gauge v
EZ 086 (.086")	W 60	W 56 (0,4mm)
EZ 141 (.141")	W 59	W 55 (0,25mm)



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 368 fully against cable end.  
Push connector housing B completely against locator tool W 368 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.

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