

Assembly instruction

Series SMA

AG 02/21/00
MAP

No. 3068

Tools and materials required :

CAUTION: solder temperature max. 200°C, heat max. 1 min.
Soldering iron 80 to 100 Watts Solder Sn/Pb 60/40
Activated rosin flux, Alcohol, brush, blade (74 Z-0-0-68)
Soft hammer, small press or small bench vice
SR cable stripping tool No. W 157
Tip trimmer No. W 164
Locator tool "M" No. W 14
Shrink tube for:
Multiflex 86 FEP 73 Z-0-0-299
Multiflex 141 FEP 73 Z-0-0-300

Right angle plug for EZ and Multiflex cables

Cable entry : soldered

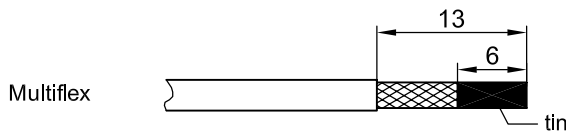
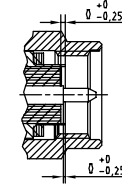
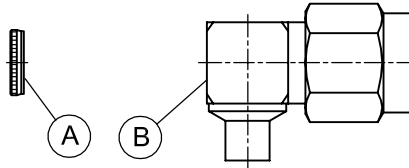
Connector types : (e.g.)

16 SMA-50-2-3	16 SMA-50-3-3
16 SMA-50-2-43	16 SMA-50-3-43
16 SMA-50-2-53	16 SMA-50-3-53

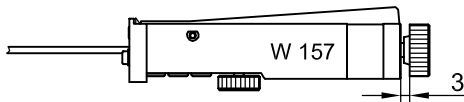
Cables : (e.g.)

EZ 86 , (.086")	EZ 141 , (.141")
Multiflex 86	Multiflex 141

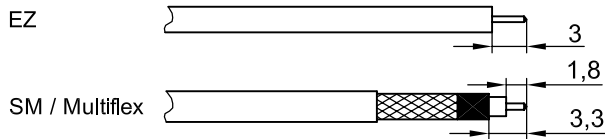
This connector is supplied in 2 parts



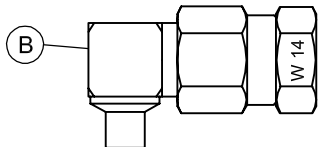
Prepare Multiflex cable according to diagram.
Lightly tin 6mm braid.
Use appropriate shrink tube for strain relief (see table above).



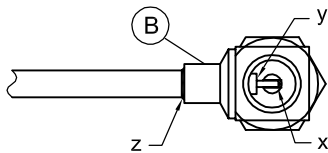
Cut cable end perpendicular to cable axis. Cut back copper jacket / braid using cable stripping tool W 157.
See instruction sheet No. 9144 for detailed description.
The tool must be set for 3mm stripping dimension.



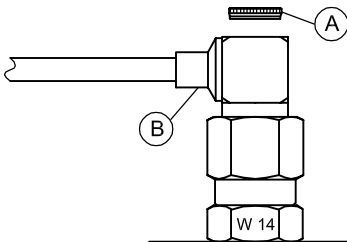
Remove dielectric using a blade.
(for EZ-cables remove dielectric flush with copper jacket)
Form tip of inner conductor to a 90° cone using tip trimmer W 164.



Screw locator tool "M" W 14 to connector body B, fix connector in a small bench vice.



Slide prepared cable into connector body B until inner conductor of cable is flush at point x.
Solder inner conductor to contact pin, slot has to be filled up with solder. Rim y must remain free of solder. Solder connector body B to copper jacket at point z. Promptly swab soldered area with alcohol to cool joint and remove any residual flux.



Position with locator tool "M" W 14 downwards on a solid base.
Place cover A on rear aperture of connector body B.
Carefully drive cover A into connector body B using a soft hammer, a small press or a small bench vice.
Remove locator tool "M" W 14 and check interface dimensions.

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