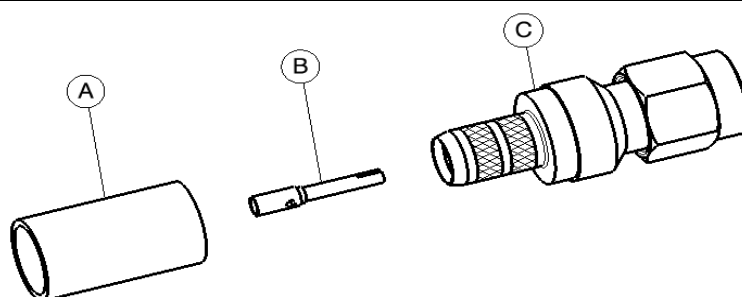


Assembly instruction Series SMA 0000241878



Connector type:	11_SMA-R50-4-97	Inner conductor contact:	soldered
Suitable cables:	S_04262_D-03, S_04172_D	Outer conductor contact:	Crimped (cavity C)

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	Slide ferrule A onto cable. Prepare cable according to diagram.	CAUTION: Do not damage braid, dielectric and inner conductor of cable.	Stanley blade scissors
	Form tip of inner conductor to a 90° cone.		Tip trimmer W 264
	Push contact B onto contact holder W 54. Heat contact B using a dry soldering iron. Flow small amount of solder into bore hole of contact.	Clean contact B and cable dielectric, remove excess solder.	Contact holder W 54, soldering iron, solder
	Mount locator tool W 323 onto connector body C.		Locator tool W 323 "F"
	Splay out braid and insert prepared cable fully into connector body C.	Ensure that braid lies above the crimp neck.	
	Slide ferrule A over braid to about body C and crimp. Remove locator tool W 323 and check interface dimensions.	Crimp as close to connector body C as possible.	Crimp tool, Crimp insert C

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.

Revision	A
Date	04.05.2006
Initiator	4662/RAK

Old Assembly instruction No. :

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