

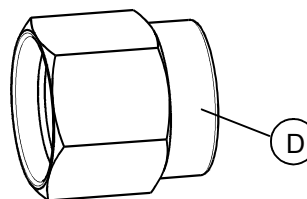
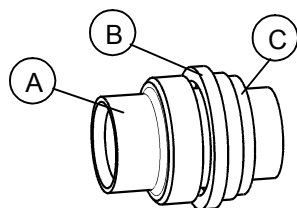
Assembly instruction Series SMA 0000179294

Old instruction No.: 9055



Connector type:	11_SMA-50-3-14 , 11_SMA-50-3-16 , 11_SMA-50-3-42 11_SMA-50-3-64 , 11_SMA-50-3-66 , 11_SMA-50-3-69	Inner conductor contact:	--
Suitable cables:	EZ-141	Outer conductor contact:	Soldered

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	Prepare cable according to the diagram.	Do not damage the dielectric.	Stanley blade
	Slide connector body A onto cable. Place cable in W 58 and fix between inserts W 59. Tighten W 499 completely against cable end. Push body A completely against tool W 499. Solder body A to cable at Z.	IMPORTANT: Remove gasket C from connector body A prior to soldering. Avoid excessive heat, immediately cool down and clean with alcohol.	Locator tool : W 499 Locator tool : W 58 Inserts : W 59 Solder iron Solder Alcohol
	Cut off dielectric at plane Y using a blade. With trim tool W 63 plan milling area Y, if necessary. Form tip of inner conductor to a 90° cone using tip trimmer W 164 with top part "11_SMA" !	Do not damage centre contact. Check dimension 2.3 mm ! Mount gasket C on connector body A !	Stanley blade Tip trimmer : W 164 with top part "11_SMA"
	Press connector body A into nut D until spring washer B engages. Use tool W 164 and W 81 for this operation !	A slight rotary action might be necessary !	Positioner : W 81 (for W 164)
	Check interface dimension !	Distance end of pin and insulator to reference plane.	

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	F
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Initiator	4779/JPE

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