

Assembly instruction Series SMA No. 27055

Tools and materials required:

Soldering iron	
Solder, 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 379
Inserts (see table)	No. W 59 oder W 60
Soldering gauge (see table)	No. W 262 or W 263
Tip Trimmer	No. W 164
Contact Holder	No. W 54
Dielectric insert tool	No. W 261
Positioner	No. W 81 (zu W 164)
Trimtool	No. W 281

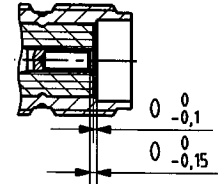
Straight connectors for copper jacket cable

Cable entry: soldered

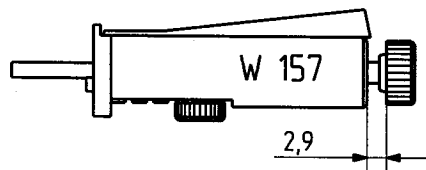
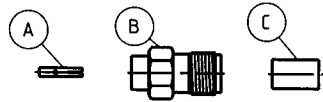
Connector types: e.g.

21 SMA-50-2-100	Kabel EZ 086 (.086")
21 SMA 50-3-100	Kabel EZ 141 (.141")
24 SMA 50-2-100	Kabel EZ 086 (.086")
24 SMA 50-3-100	Kabel EZ 141 (.141")

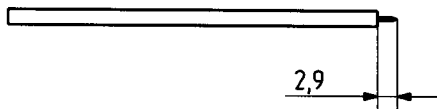
SMA female connector interface dimensions



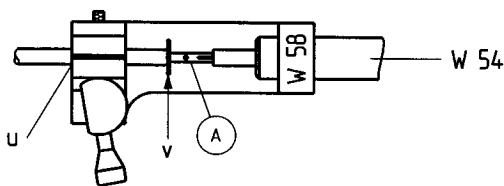
This connector is supplied in 3 parts



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 2,9mm stripping dimension.

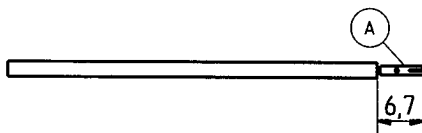


Remove dielectric flush with copper jacket using a blade.
Form tip of inner conductor to a 90° cone using tip trimmer.
W 164 and W 81.

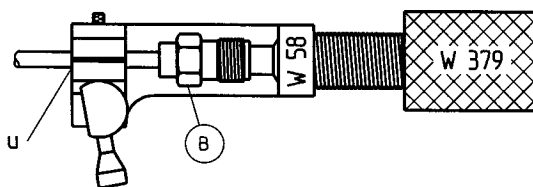


Push contact A onto contact holder W 54.
Fix cable in soldering fixture W 58 as illustrated.
Place soldering gauge on inner conductor as illustrated.
Flow small amount of solder into bore of contact.
Push contact holder against soldering gauge and solder.

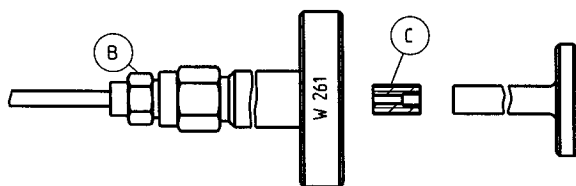
cable	insert u	Soldering gauge v
EZ 086 (.086")	W 60	W 263 (0.3mm)
EZ 141 (.141")	W 59	W 262 (0.15mm)



Immediately cool down, remove cable from fixture and check dimension 6,7mm



Slide connector housing B over cable and fix cable in fixture.
Tighten locator tool W 379 fully against cable end.
Push connector housing B completely against locator tool W 379 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 281.



Screw dielectric insert tool W 261 onto connector.
Place insulator C in rear opening of insert tool and press fully through insert tool into connector.
Check interface dimensions.

SUHNER'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



HUBER + SUHNER AG CH-9100 HERISAU

Deutscher Text: siehe Rückseite