

Assembly instruction

Series SMA

C	24.11.05
4186/MAP	

No. 3068

Tools and materials required :

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

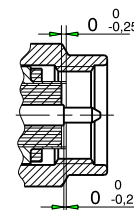
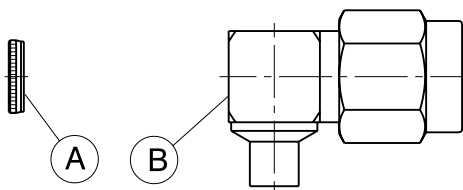
Connector types : (e.g.)

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

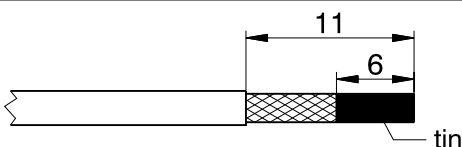
Cables : (e.g.)

EZ 86 , (.086") Multiflex 86	EZ 141 , (.141") Multiflex 141
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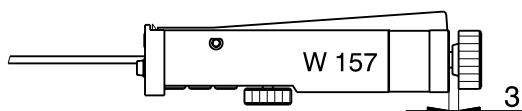
This connector is supplied in 2 parts



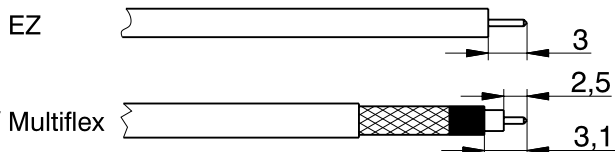
Multiflex



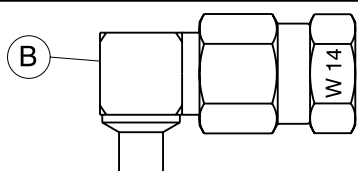
Prepare Multiflex cable according to diagram.
 Lightly tin 6mm of braid.
 Use appropriate shrink tube for strain relief (see table above).



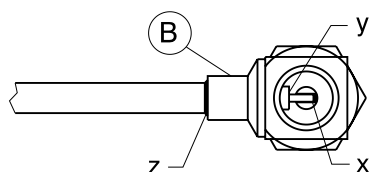
Cut cable end perpendicular to cable axis. Cut back copper jacket / braid using cable stripping tool W 157.
 See instruction sheet No. 9144 for detailed description.
 The tool must be set for 3mm stripping dimension.



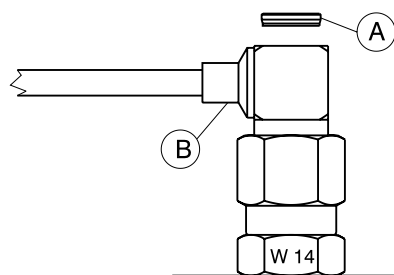
Remove dielectric using a blade.
 (for EZ-cables remove dielectric flush with copper jacket)
 Form tip of inner conductor to a 90° cone using tip trimmer W 164.



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 connector body B to copper jacket at point z.
 Promptly swab soldered area to cool joint and clean.
 Solder inner conductor to contact pin, slot has to be filled up with solder. Rim y must remain free of solder.



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.

HUBER + SUHNER's skilled staff and specialised equipment are available to carry out complete RF. lead-assembly on your behalf.
 We mount your connectors on cables at economic prices! Please contact our representative for further details of this service.