Assembly instruction

Tools and materials required:
- Soldering iron 80 to 100 Watts / 220°C to 240°C
- Solder Sn/Pb 60/40 0.8mm Ø 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 368
- Inserts (see table) No. W 59, W 60
- Soldering gauge (see table) No. W 65, W 56
- Tip trimmer No. W 164
- Contact holder No. W 54
- Dielectric insert tool No. W 53
- Trim tool No. W 142

Straight connectors for copper jacket cable

<table>
<thead>
<tr>
<th>Connector types : (e.g.)</th>
<th>Cable types: (e.g.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>21 SMA-50-2-15</td>
<td>25 SMA-50-2-15</td>
</tr>
<tr>
<td>25 SMA-50-3-15</td>
<td>EZ 086 (0.86&quot;)</td>
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<tr>
<td>24 SMA-50-2-15</td>
<td>25 SMA-50-2-25</td>
</tr>
<tr>
<td>24 SMA-50-3-15</td>
<td>EZ 141 (0.14&quot;)</td>
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</tbody>
</table>

Cable entry: soldered

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 3.1mm stripping dimension.

- Remove dielectric flush with a blade.
- Form tip of inner conductor to a 90° cone using tip trimmer tool W 164.

- 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.

- Immediately cool down, remove cable from fixture and check dimension 6.6 mm.

- Slide connector housing B over cable and fix cable in fixture.
- Tighten locator tool W 368 fully against cable end.
- Push connector housing B completely against locator tool W 368 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 142.

- Screw dielectric insert tool W 53 onto connector.
- Place insulator C in rear opening of insert tool and press fully through Insert tool into connector.
- Check interface dimensions.

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