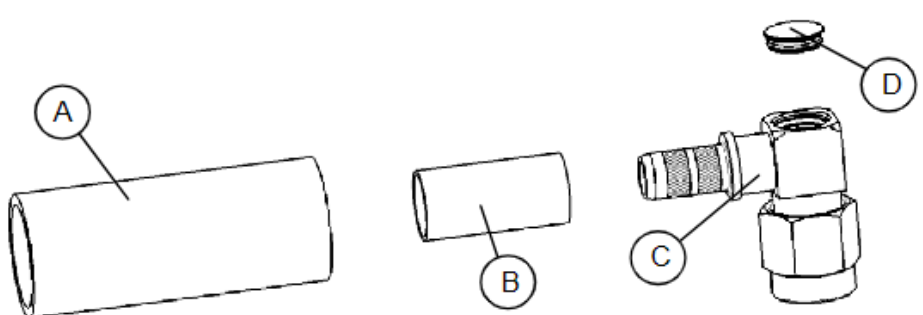
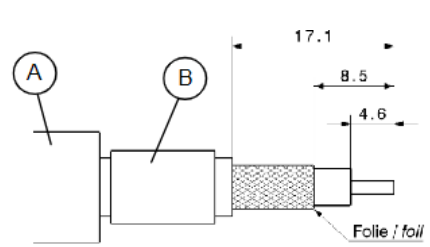
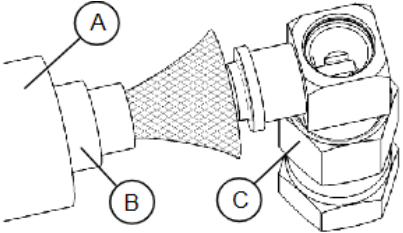
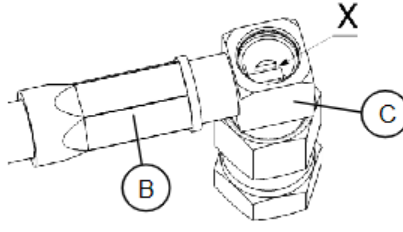
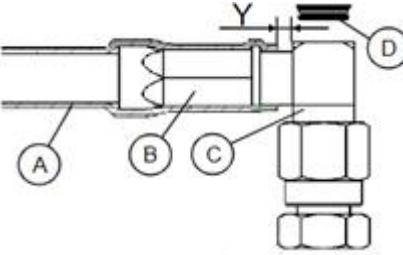


## Assembly instruction Series SMA 0000443145

<b>Connector type:</b>	16_SMA-50-4-77	<b>Inner conductor contact:</b>	Soldered
<b>Suitable cables:</b>	SPUMA_240-RS-FR, SPUMA-240, SPUMA-240-FR	<b>Outer conductor contact:</b>	Crimped
<b>Parts list connector:</b>			

Assembly steps:			
Picture	Process	Feature/Check	Tools required
	Slide shrink tube A and ferrule B onto cable. Prepare cable according to diagram. Cut foil on same length as braid.	Do not damage inner conductor, dielectric, foil and braid of cable.	Stanley blade Scissors

	<p>Splay out braid and insert prepared cable in connector body C until stop.</p>	<p>Ensure that braid lies above the crimp neck and the foil enters the body C.</p>	
	<p>Slide ferrule B over braid and crimp as close to connector body C as possible. Solder inner conductor to cable at X.</p>	<p>During the crimping push the cable against body C.</p>	<p>Coax Crimptool, HX4 (M6000112) Coax Crimptool, Inserts, Y206P (M6000113)</p>
	<p>Place cover D on rear aperture of body C. Press cover D into body C. Slide shrink tube A over ferrule B and shrink to connector body C. Dimension Y max. 1mm.</p>	<p>For achieving better adhesive sealing of the shrinking tube, clean surfaces on body and cable, e.g. with Acetone. Avoid excessive heat. Heat Time 12-15 s. Glue of the shrink tube has to ooze out slightly on both sides.</p>	<p>Soft hammer, a small press or a small bench vice. Hot-air fan Acetone</p>

<p>The cable assembly of R.F. connectors can only be done by well trained assembly stuff and suitable assembly equipment. Huber+Suhner's skilled stuff 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.</p>	<p>Revision Date Initiator</p>	<p>C 15.04.2015 4779/JPE</p>
---	--	--------------------------------------