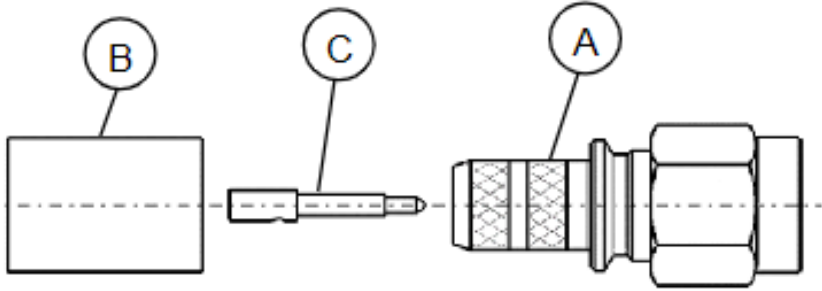
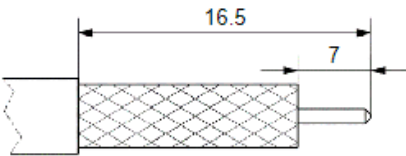
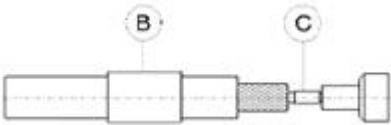
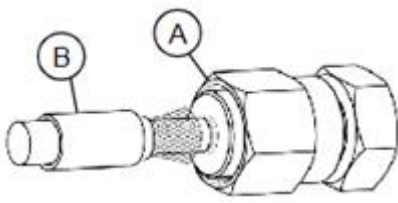
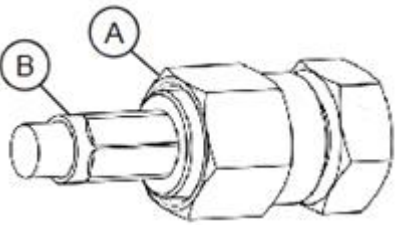
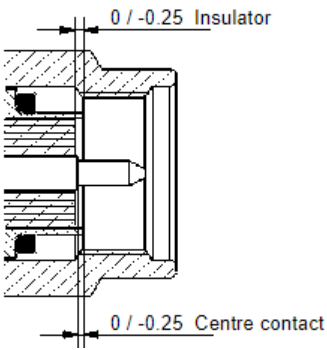


## Assembly instruction Series SMA 0000871945

|                              |  |                                 |          |
|------------------------------|--|---------------------------------|----------|
| <b>Connector type:</b>       | 11_SMA-50-4-63   | <b>Inner conductor contact:</b> | Soldered |
| <b>Suitable cables:</b>      | SPUMA_240-RS-FR,<br>S_04162_B-01   | <b>Outer conductor contact:</b> | Crimped  |
| <b>Parts list connector:</b> |  |                                 |          |

| <b>Assembly steps:</b>  |  |  |                                |
|---|--|--|--------------------------------|
| <b>Picture</b>  | <b>Process</b>   | <b>Feature/Check</b>   | <b>Tools required</b>          |
|  | <p>Prepare cable according to diagram. Slide ferrule B onto cable. Form tip of inner conductor of cable to a 60° cone.</p>   | <p>Do not damage centre contact, dielectric, foil and braid of cable. Ensure that the inner conductor of cable is straight. Ensure that the cone end is well formed.</p> | <p>Suitable stripping tool</p> |
|  | <p>Heat centre contact C using a dry soldering iron. Flow small amount of solder into borehole of centre contact C. Insert inner conductor of cable and solder to centre contact C. Clean centre contact C and cable dielectric, remove excess solder.</p> | <p>Front surface of cable dielectric must be clean, cleanse if necessary.</p>  | <p>Solder iron and solder</p>  |

|  |   |   |   |
|--|---|---|---|
|   | <p>Splay out braid and insert prepared cable fully into connector body A.</p> | <p>Ensure that braid lies above the crimp neck.</p>               |   |
|   | <p>Slide ferrule A over braid to body A and crimp.</p>                        | <p>Crimp as close to connector body A as possible.</p>            | <p>Coax Crimptool, HX4 (M6000112)<br/>Coax Crimptool, Inserts, Y206P (M6000113)</p> |
|  | <p>Check interface dimension.</p>   | <p>Distance shoulder of pin and insulator to reference plane.</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<br/>Date<br/>Initiator</p> | <p>B<br/>05.06.2020<br/>4952/WiS</p> |
|---|--|--------------------------------------|