

# Montageanleitung Serie SMA Nr. 27266

## Benötigte Hilfsmittel:

Lötkolben ca. 80-100 Watt / 220-240°C  
 Lötzinn Sn/Pb 60/40,  $\varnothing$  0,8 mm  
 aktiviertes Kolophonium  
 Schere, Klinge (74Z-0-0-68)  
 Kontakthalter Nr. W 54  
 Montagelehre Nr. W 14 "M"

Gerade Verbinder für flexible Kabel

Kabeleinführung : Suhner Crimp

Verbinder-Typen : (z.B.)

11 SMA 50 - 2 - 5

11 SMA 50 - 2 - 6

Kabel : (z.B.)

RG 188 A/U

K 02252-d

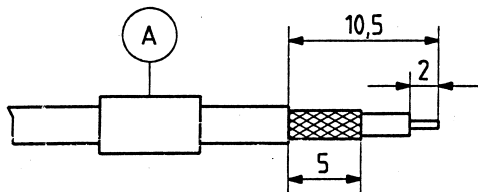
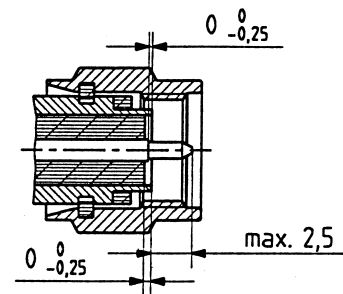
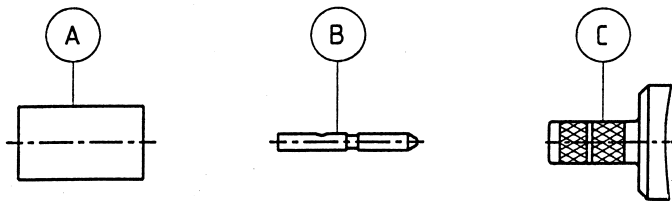
Dieser Verbinder  
 wird in 3 losen Teilen  
 geliefert

Innenleiter :

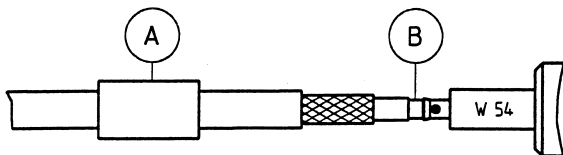
gelötet

Aussenleiter :

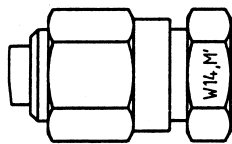
Aussparung A



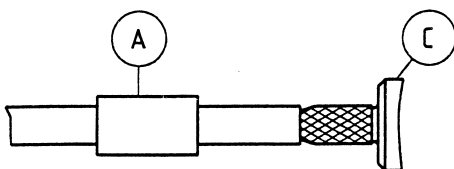
Hülse A auf das Kabel schieben.  
 Kabel gemäss Figur abisolieren.  
 Achtung : Innenleiter, Dielektrikum und  
 Abschirmung nicht beschädigen.



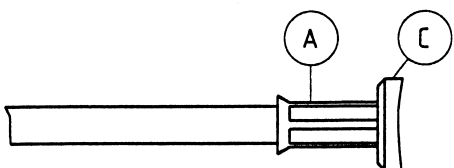
Kontakt B auf Kontakthalter W 54 stecken.  
 Kontakt B mit trockenem Lötkolben erwärmen,  
 Lötzinn in die Bohrung geben, vorbereitetes  
 Kabel in die Bohrung stossen und verlöten.  
 Kontakt B und Dielektrikum reinigen.



Montagelehre W 14 auf das Gehäuse schrauben.



Abschirmung leicht aufspreizen und  
 vorbereitetes Kabel sorgfältig und vollständig  
 in Gehäuse C stossen.  
 Abschirmung muss über dem Klemmhals liegen .



Hülse A über die Abschirmung schieben und  
 möglichst nahe am Gehäuse C festklemmen.  
 Montagelehre entfernen und Anschlussmass  
 prüfen.

SUHNER verfügt über gut ausgebildete Fachkräfte und rationelle Einrichtungen zur Herstellung kompletter HF-Verbindungsleitungen. Wir montieren Ihre Verbinder zu wirtschaftlichen Preisen! Wenden Sie sich an unsere Vertreter.



HUBER + SUHNER AG CH-9100 HERISAU

for English text see overleaf

# Assembly instruction

# Series BNC, TNC, N v8 No.3015

## Tools and materials required:

Stanley blade  
Scissors  
Crimp tool (see table below)

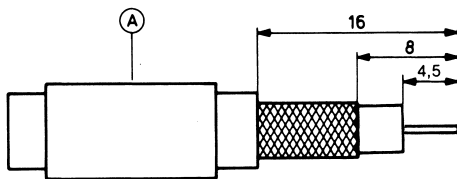
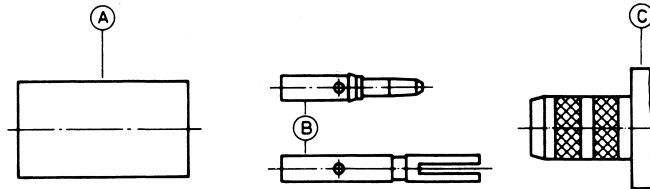
## Straight connectors for flexible cable

**Cable entry:** SUHNER Full-Crimp

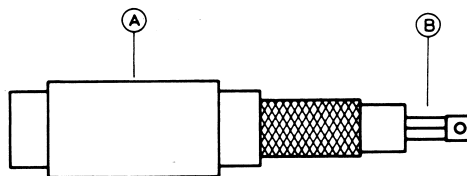
### Connector types: (e. g.)

11 BNC-50-3-4	11 BNC-50-4-4	11 BNC-75-5-6
21 BNC-50-3-2	21 BNC-50-4-1	21 BNC-75-5-3
11 TNC-50-3-9	11 TNC-50-4-7	
21 TNC-50-3-7	21 TNC-50-4-6	
11 N-50-3-28	11 BNC-75-4-4	

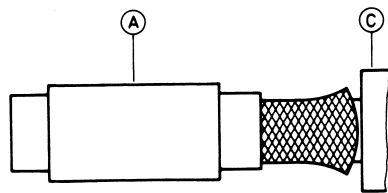
This connector is supplied in 3 parts	<b>Suitable cables e. g.:</b>	RG 58 C/U	RG 59 B/U	G 05133 d
	<b>Centre contact:</b>	cavity 2	cavity 2	cavity 2
	<b>Braid:</b>	cavity B	cavity C	cavity 8,0
	<b>Crimp tool:</b>	2B (orange)	2C (yellow)	2/8,0



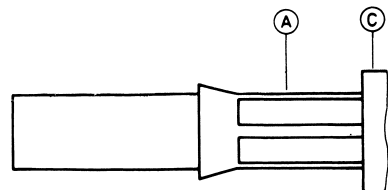
Slide ferrule A onto cable.  
Prepare cable according to diagram.  
**CAUTION:** Do not damage braid, dielectric and inner conductor of cable!



Push contact B over inner conductor of cable to abut dielectric and crimp.



Splay out braid and insert cable in connector body C.  
Ensure that braid lies above the crimp neck.



Slide ferrule A over braid and crimp as close to connector body C as possible.



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 LTD. CH-9100 HERISAU

# Assembly instruction Series C, N, J F1 No. 3017

## Tools and materials required:

Stanley blade  
 Scissors  
 Soldering iron 150.Watts  
 Solder Sn/Pb 60/40  
 activated rosin flux  
 Spanner 11 mm (74 Z-0-0-2)

## Straight cable connectors for flexible cables

**Cable entry:** Screw-type

### Connector types: (e. g.)

11C-50-3-2c	11C-50-4-2c
21C-50-3-2c	21C-50-4-2c
11N-50-3-2c	11N-50-4-2c
21N-50-3-2c	21N-50-4-2c
11J-50-3-1c	11J-50-4-1c
21J-50-3-1c	21J-50-4-1c

This connector is supplied in 10 parts

**Suitable cables e. g.:**

**Centre contact:**

**Braid:**

RG 58 C/U

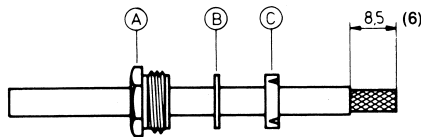
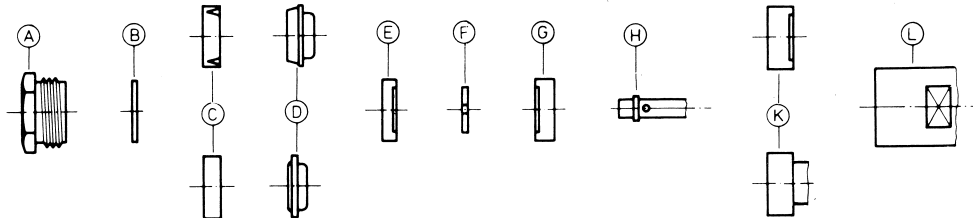
RG 59 B/U

soldered

soldered

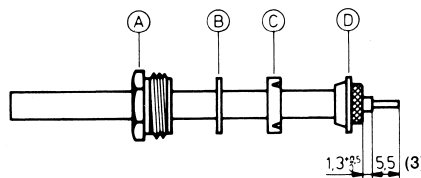
screwed

screwed

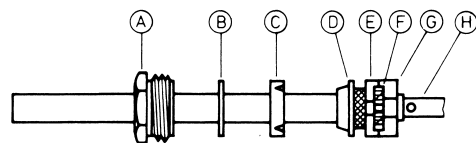


Slide nut A, washer B and gasket C onto cable. Prepare cable according to diagram (6 mm for angle connectors).  
**CAUTION: Do not damage braid!**

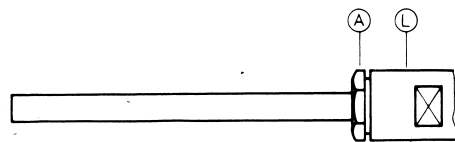
Armoured cables: Slide two-piece FK-armour-clamp on cable instead of nut A.  
 Remove 27,5 mm of armour.



Push braid back slightly to expose dielectric and cut back dielectric 5,5 mm perpendicular to cable axis (3 mm for angle connectors). Do not damage inner conductor. Taper braid towards inner conductor. Position braid clamp D so that its shoulder fits against cable sheath. Fold back braid over clamp D and trim overlapping braid. Check dimension of 1,3 mm.



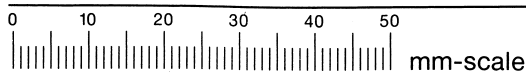
Position bushing E, insulator F and G. Heat inner contact H using a soldering iron (approx. 150 W) and flow small amount of solder into bore. Push cable inner conductor into bore, immediately remove soldering iron to prevent melting of the dielectric.



Push prepared cable into connector body L, with front part of insulator K and tighten nut A. Do not rotate cable in connector body.

Armoured cable: Finally screw on and tighten armour clamp.

For cable assemblies subjected to particular tensile strength, connectors can be fitted with the FUK-cable clamping. Please ask for data leaflets.



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 LTD. CH-9100 HERISAU

## Tools and materials required:

Soldering iron 80 to 100 Watts / 220 to 240°C  
 Solder Sn/Pb 60/40, 0.8 mm Ø activated rosin flux,  
 Stanley blade  
 Soldering fixture SUHNER 74Z-0-0-15  
 Locator tool SUHNER 74Z-0-0-14  
 Crimp tool: A insert for --SMA-50-2--  
 B insert for --SMA-50-3--

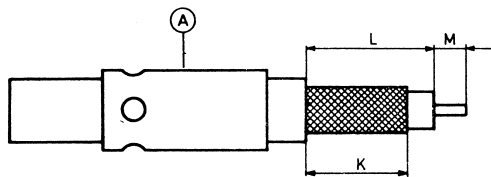
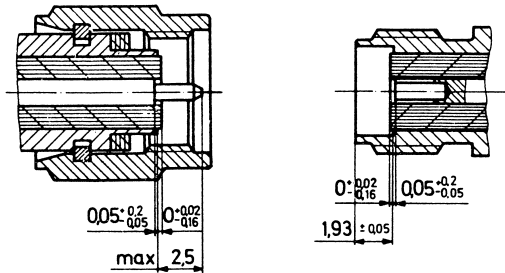
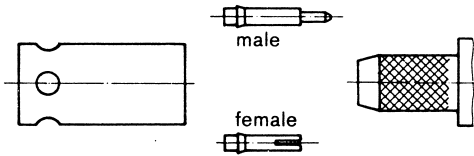
## Straight connectors for flexible cables

**Cable entry:** crimped or soldered

### Connector types: (e.g.)

11 SMA-50-2-5	21 SMA-50-2-5
11 SMA-50-2-6	21 SMA-50-2-6
11 SMA-50-3-5	21 SMA-50-3-5
11 SMA-50-3-6	21 SMA-50-3-6

This connector is supplied in 3 parts



1. If required, slide taper sleeve or heat-shrink sleeve onto cable (not illustrated).

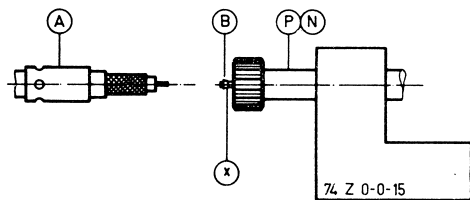
2. Prepare cable as follows:

Connector type	K	L	M
--SMA-50-2--	5 mm	7.5 mm	2 mm
--SMA-50-3--	8 mm	10.5 mm	2 mm

3. Slide ferrule A onto cable as follows:

for CRIMPING: position ferrule as illustrated.

for SOLDERING: reverse ferrule (holes in ferrule adjacent to connector body).

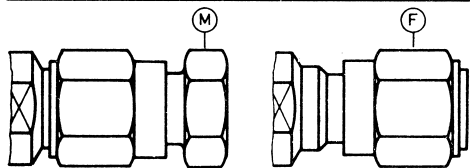


SUHNER soldering fixture 74Z-0-0-15 with insert P (male) or N (female) is required for assembly stages 4 and 5.

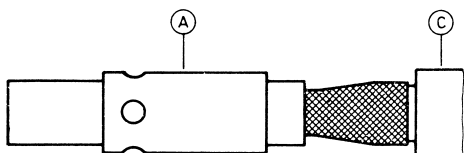
4. Position contact B at rear end of insert P or N.

5. Heat contact B at point x, using a dry soldering iron. Flow small amount of solder into bore hole of contact, introduce inner conductor of cable and solder to contact.

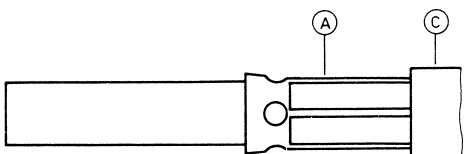
6. Clean contact B and cable dielectric, remove excess solder.



7. Mount locator tool SUHNER 74Z-0-0-14 onto connector body C (M for male, F for female).



8. Carefully insert prepared cable fully into connector body C.



9. Slide ferrule A over braid to abut connector body C.

10. a) CRIMP: Crimp as close to connector body C as possible.

b) SOLDER: Heat ferrule A with soldering iron and solder through holes (recommended for PTFE cables only).

11. Remove locator tool and 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 Ltd. CH-9100 HERISAU

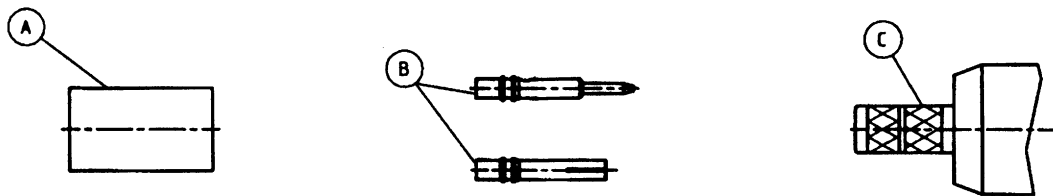
Phone 071 · 531515, Telex 77426

Switzerland

Deutscher Text: siehe Rückseite

# Assembly instruction Series SMB, SMC, SMS AD 24.11.99 4727/HUC No.3077

Tools and materials required: Stanley-blade Scissors Crimp tool (see table below)	Straight connectors for flexible cable		
	Cable entry: SUHNER Full-Crimp		
This connector is supplied in 3 parts.	Suitable cables: (e.g.)	RG 178 B/U	RG 174/U
	Centre contact:	cavity 1	cavity 1
	Braid:	cavity A	cavity A
	Crimp tool:	1, 2, A (red)	1, 2, A (red)



	Slide ferrule A onto cable. Prepare cable according to diagram. CAUTION: Do not damage braid, inner conductor and dielectric of cable!
	Push contact B over inner conductor of cable to abut dielectric and crimp.
	Splay out braid and insert cable in connector body C. Ensure that braid lies above the crimp neck. When cable dimension 2 is used Center-Pin has to snap in.
	Slide ferrule A over braid and crimp as close to connector body C as possible.

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HUBER + SUHNER AG CH-9100 HERISAU

# Assembly instruction Series SMB, SMC, SMS F9 No. 3077

## Tools and materials required:

Stanley blade  
Scissors  
Crimp tool (see table below)

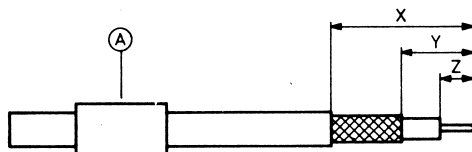
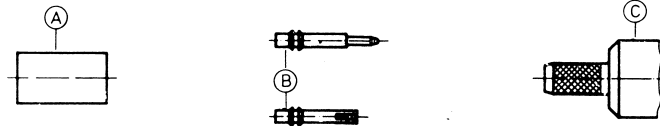
## Straight connector for flexible cables

**Cable entry:** SUHNER Full-Crimp

### Connector types: (e. g.)

11 SMB/C/S-50-1-10	11 SMB/C/S-50-2-10c
21 SMB/C/S-50-1-10	21 SMB/C/S-50-2-10c
24 SMB/C/S-50-1-10	24 SMB/C/S-50-2-10c

This connector is supplied in 3 parts	<b>Suitable cables e. g.:</b>	RG 178 B/U	RG 174/U
	<b>Centre contact:</b>	cavity 1	cavity 1
	<b>Braid:</b>	cavity A	cavity A
	<b>Crimp tool:</b>	1, 2, A (red)	1, 2, A (red)

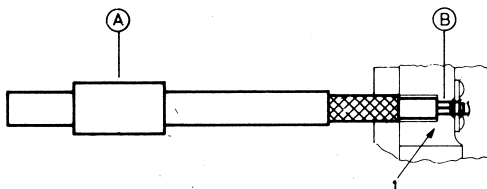


Slide ferrule A onto cable.

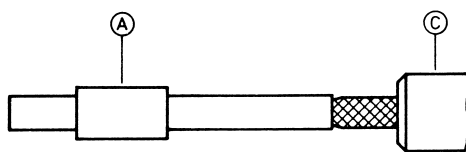
Prepare cable according to diagram.

**CAUTION:** Do not damage braid, dielectric and inner conductor of cable!

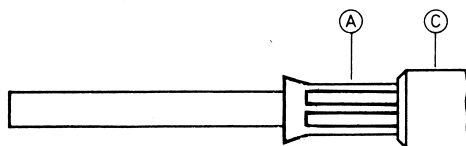
Type	X	Y	Z
11/21 SM...	11	5,5	2,5
24 SM...	10,4	4,9	2,5



Push contact B over inner conductor of cable and crimp with insert 1.



Splay out braid and insert cable in connector body C. Ensure that braid lies above the crimp neck.



Slide ferrule A over braid and crimp as close to connector body C as possible.



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Deutscher Text: siehe Rückseite

**Tools and materials required:**

Stanley blade  
Scissors  
Crimp tool (see table below)

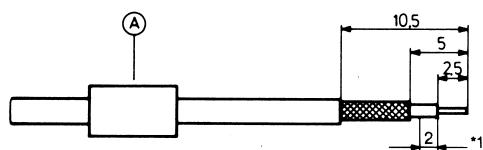
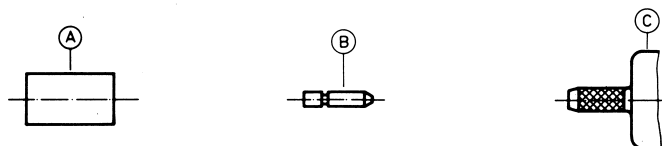
**Straight connectors for flexible cable**
**Cable entry:** SUHNER Full-Crimp

**Connector types: (e. g.)**

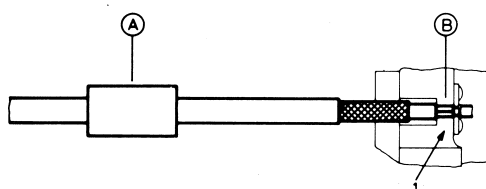
11 BNC-50-1-5c	11 BNC-50-2-13c	11 BNC-50-2-16c
21 BNC-50-1-4c	21 BNC-50-2-9c	
	24 BNC-50-2-13c	

This connector is supplied in 3 parts

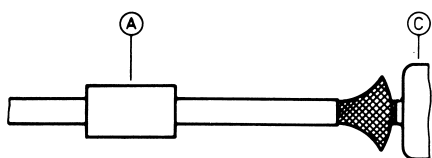
<b>Suitable cables e. g.:</b>	RG 196 A/U	RG 188 A/U	G 01130 HT *1
<b>Centre contact:</b>	cavity 1	cavity 1	cavity 1
<b>Braid:</b>	cavity A	cavity A	cavity A
<b>Crimp tool:</b>	1, 2, A (red)	1, 2, A (red)	1, 2, A (red)



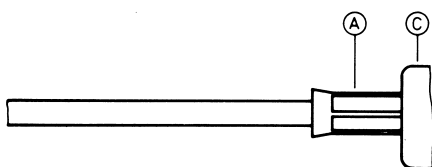
Slide ferrule A onto cable.  
Prepare cable according to diagram.  
**CAUTION:** Do not damage braid, dielectric and inner conductor of cable.  
\*1 Remove semi conducting layer 2 mm towards braid.



Push contact B over inner conductor of cable to abut cable dielectric and crimp with insert 1.



Splay out braid and insert cable in connector body C. Ensure that braid lies above the crimp neck.



Slide ferrule A over braid and crimp as close to connector body C as possible.



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