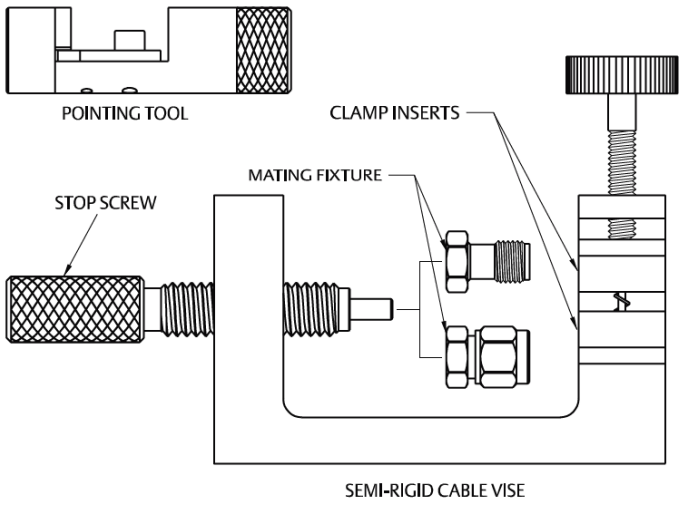
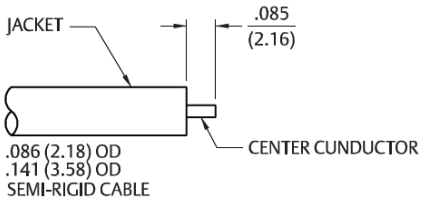
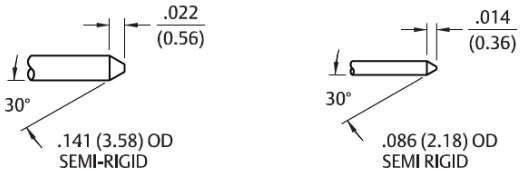
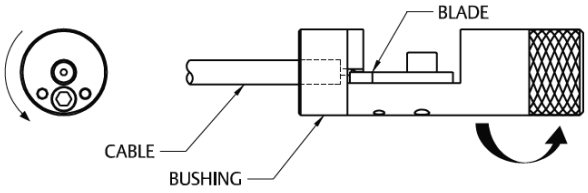
SMA Straight Solder Type for Semi-Rigid Cables

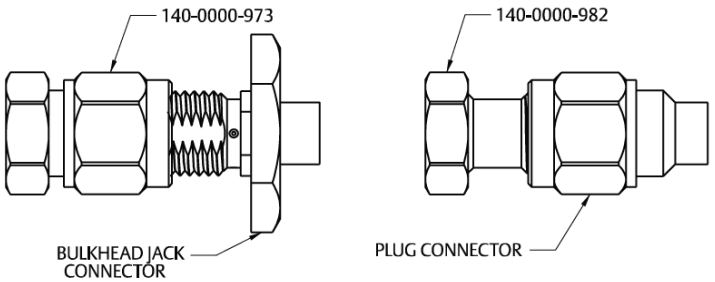
1. Identify the connector (plug or jack) and tools.
2. Strip the cable jacket and dielectric to dimension shown. Do not nick the center conductor.
3. Bevel the entire diameter on the end of the cable center conductor until the point resembles the appropriate dimensional profile. This operation can be accomplished effectively by using the recommended center conductor pointing tool as described in step 4.
4. Insert the stripped cable into the bushing of the appropriate pointing tool until the center conductor just touches the blade. While maintaining light pressure on the center conductor against the blade, turn the tool in a counter-clockwise fashion as viewed from the bushing end of the tool. Continue cutting the center conductor point until the cable jacket bottoms out inside the bushing.
5. Attach the appropriate soldering mating fixture to the connector and tighten to a maximum of 8 inch pounds of torque.
6. Clean all debris from the prepared cable and insert the cable into the connector, making sure that the cable jacket bottoms out against the internal shoulder of the connector body.
7. Insert the stop screw into the mating fixture. Clamp the cable and fixtured connector assembly securely in the soldering vise. Solder the connector body to the cable as shown, while insuring the cable dielectric expansion does not move the assembly. Allow the assembly to cool before removing the connector from the fixture.











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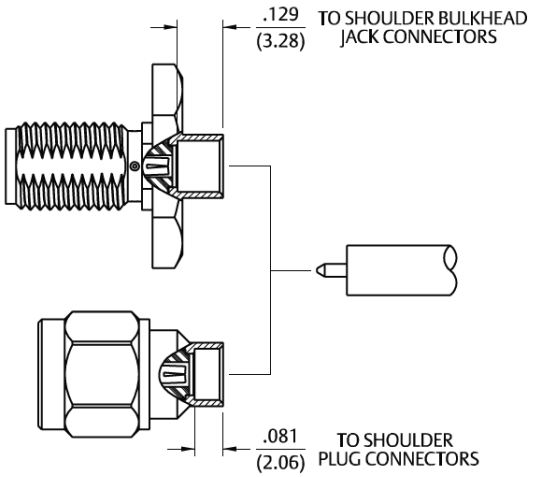
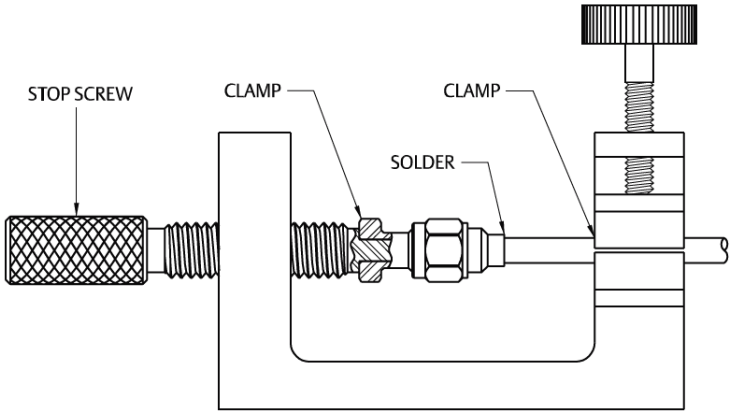
SMA Straight Solder Type for Semi-Rigid Cables (cont'd from last page)

Cable Group	Part No.
RG-405/U (.086 Semi-Rigid)	141-0593-421 141-0693-062
RG-402/U (.141 Semi-Rigid)	141-0594-421 141-0694-062





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