Assembly Instructions-C56
SMA

BRAID CRIMP-SOLDER CENTER CONTACT TYPES FOR FLEXIBLE CABLE

### Step 1
Slide heat shrink tubing and outer ferrule onto cable. Strip cable jacket, braid, and dielectric to dimensions shown in table above. All cuts are to be sharp and square. Do not nick braid, dielectric, or center conductor when cutting. Avoid excessive heat to prevent swelling of cable dielectric. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule. Do not comb out braiding.

### Step 2
Slide clamp nut over inner ferrule, and slide inner ferrule under braid until cable dielectric is flush with front of inner ferrule. Slide outer ferrule in place and crimp with die set shown in table above.

### Step 3
Place insulator washer on cable center conductor and bottom against inner ferrule body as shown. Contact must butt firmly against insulator washer while soldering.

### Step 4
Screw ferrule-contact assembly into body and tighten to 20-25 lbf.-in. torque. Slide heat shrink tubing over ferrule, up against clamp nut and shrink by applying heat.