REVISIONS

SYM.	DESCRIPTION	DATE	APPROVED
31	REDRAWN - ADDED SHEETS 25 & 26 SHEET 7 REVISED ECO. 29676	12/22/88 ECR 29676	
32	ADD SHT 27 3-15-90 ECO 37121	3/12/90	[illegible]
33	REVISE SHEET 12 ECO 38009	3/12/91	AB
34	Remove 60/40 Solder Ref ECO 46001	3/29/96	CPM

NAME	DATE
PREP. BY J.A. HURTBLE	
CHK. BY	
PROJ. ENG.	
APPD. BY	
DATE ISSUED	

AMPHENOL • Danbury, Connecticut

SPECIFICATION TITLE:

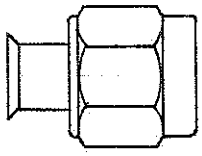
ASSEMBLY PROCEDURES FOR TYPE SMA CONNECTORS.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES:
AND TOLERANCES ARE:
FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1°

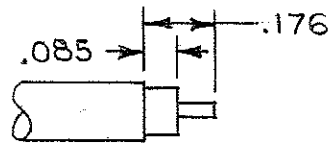
CODE IDENT.	SPECIFICATION No.	ISSUE
	349-50114	34

SCALE: NONE SHEET 1 CONT. ON 2

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-113

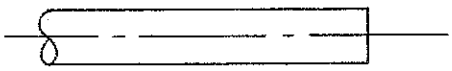
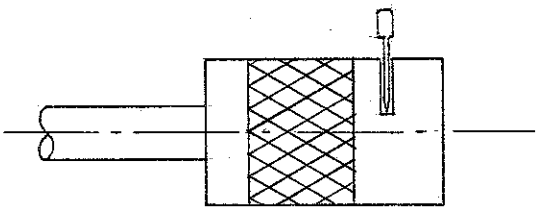
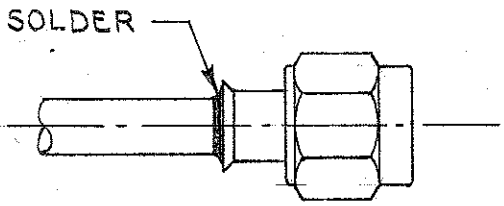
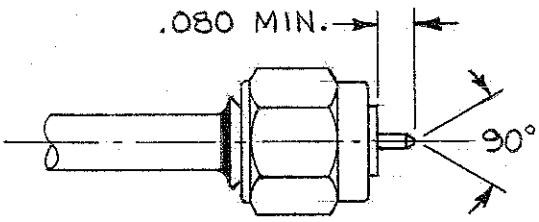


901-113 COMPLETE ASSEMBLY (PLUG)



STRIPPING DIM'S SHOWN FOR REF. ONLY

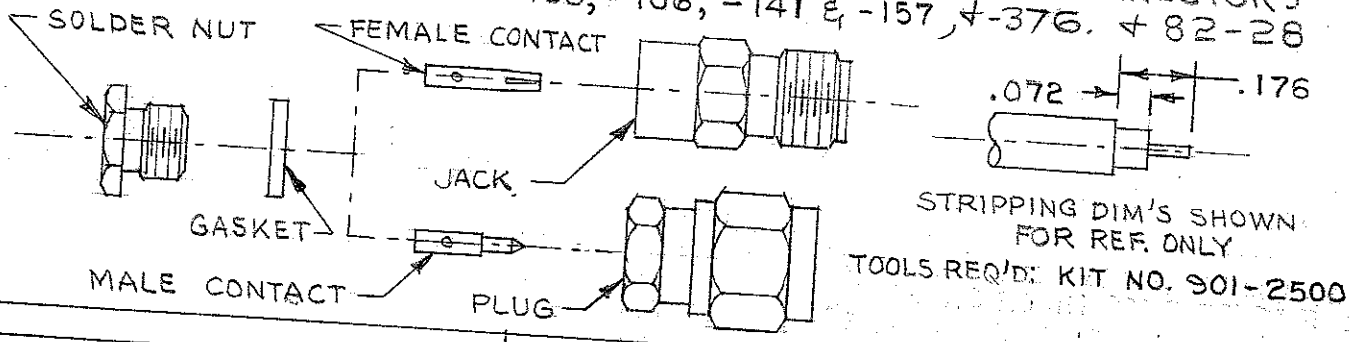
TOOLS REQ'D: KIT NO. 901-2500.

	TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	PLACE PLUG ASSEMBLY OVER CABLE; COPPER JACKET MUST BOTTOM ON SHOULDER OF BODY. SOLDER AS SHOWN.
	CAUTION – BEFORE TRIMMING DIELECTRIC, ASSEMBLY MUST BE ALLOWED TO COOL. SLIDE COUPLING NUT BACK AGAINST SOLDERING FLANGE. CUT DIELECTRIC SQUARE AND AS CLOSE TO BODY AS POSSIBLE AND REMOVE. DO NOT NICK CENTER CONDUCTOR. FILE BLUNT END OF CENTER CONDUCTOR TO A 90° CONE.

Spec. No. 349-50114

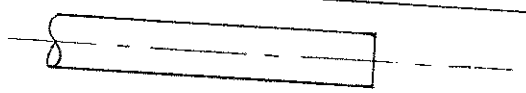
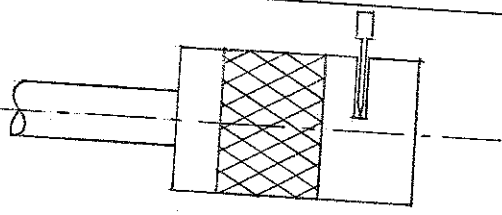
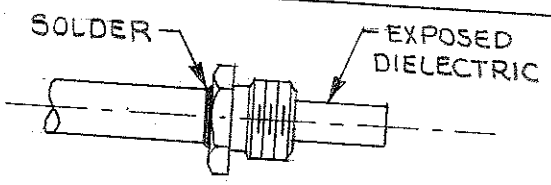
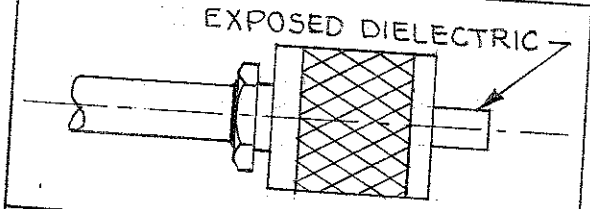
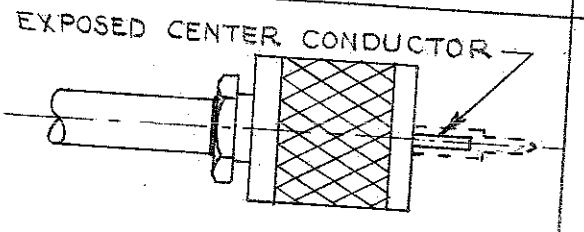
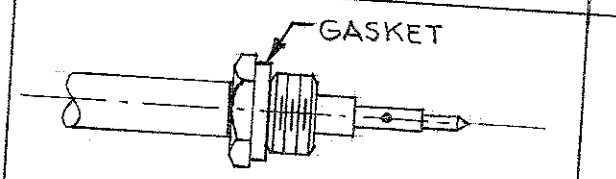
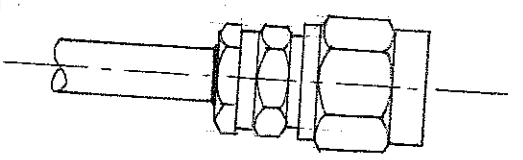
Sheet 2 Cont. on 3

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTORS
NOS. 901-105, -106, -141 & -157, +-376, + 82-28

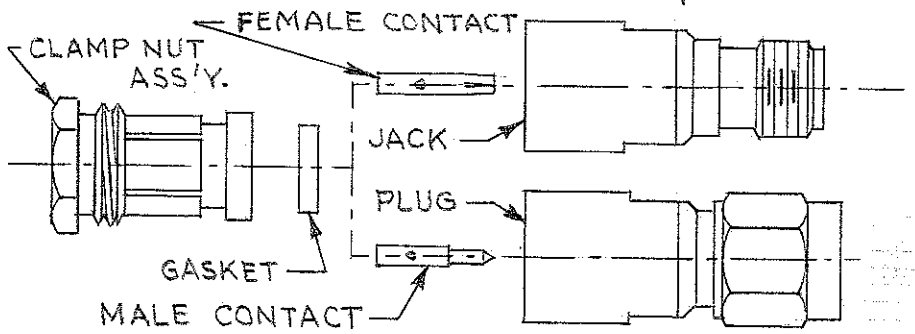


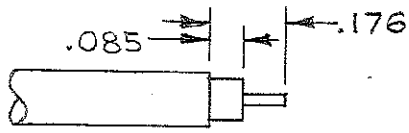
STRIPPING DIM'S SHOWN FOR REF. ONLY

TOOLS REQ'D: KIT NO. 901-2500

	TRIM CABLE SQUARE, DEBURR & CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING FORCE ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	PLACE SOLDER NUT OVER CABLE; COPPER JACKET MUST BOTTOM ON SHOULDER OF SOLDER NUT. SOLDER AS SHOWN.
	CAUTION - BEFORE TRIMMING DIELECTRIC, ASSEMBLY MUST BE ALLOWED TO COOL. USING DIELECTRIC TRIM TOOL 901-B AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR.
	SOLDER CENTER CONTACT TO CABLE. CENTER CONTACT MUST SEAT SQUARE AGAINST DIELECTRIC. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY. INSTALL GASKET AS SHOWN.
	THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 15 - 20 IN/LBS. TORQUE.

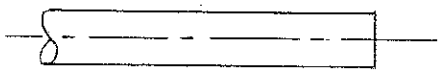
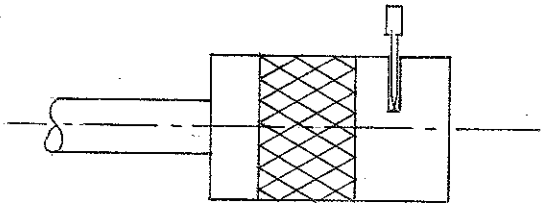
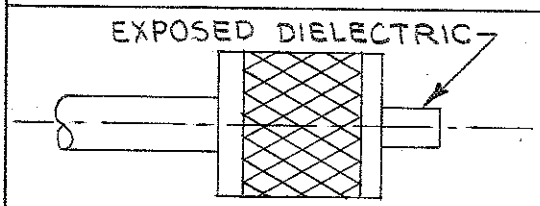
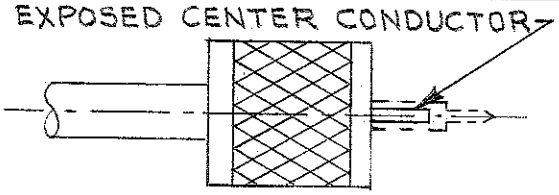
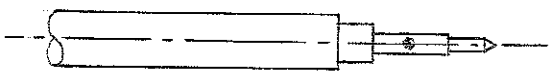
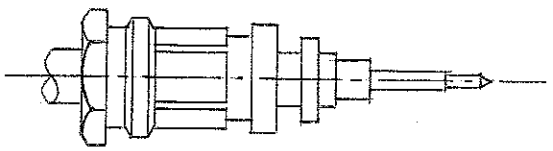
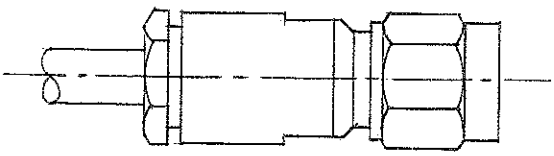
ASSEMBLY PROCEDURE FOR FIELD SERVICEABLE SMA CONNECTORS
NOS. 901-107 & 901-108





STRIPPING DIM'S SHOWN FOR REF. ONLY

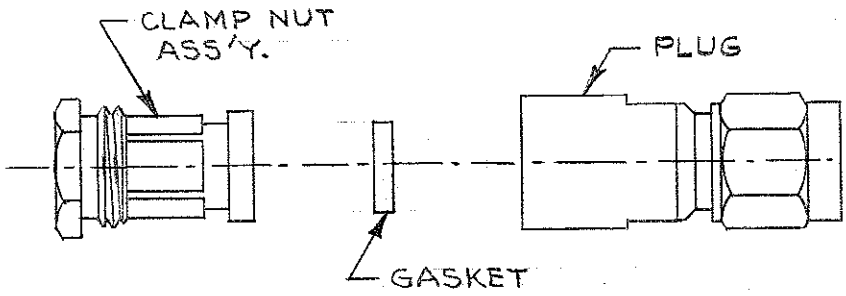
TOOLS REQ'D:
KIT NO. 901-2500.

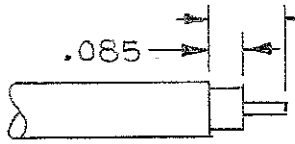
	TRIM CABLE SQUARE, DEBURR & CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING FORCE ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	USING DIELECTRIC TRIM TOOL 901-C AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR.
	SOLDER CENTER CONTACT TO CABLE, CENTER CONTACT MUST SEAT SQUARE AGAINST DIELECTRIC. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY.
	SLIDE CLAMP NUT AND GASKET OVER COPPER JACKET OF CABLE.
	INSERT PREPARED CABLE TERMINATION INTO CONNECTOR BODY. MAKE SURE COPPER JACKET OF CABLE SEATS PROPERLY AGAINST CONNECTOR BODY SHOULDER. TIGHTEN NUT TO 15-20 IN/LBS TORQUE, WHILE HOLDING BODY STATIONARY.

Spec. No. 349-50114

Sheet 4 Cont. on 5

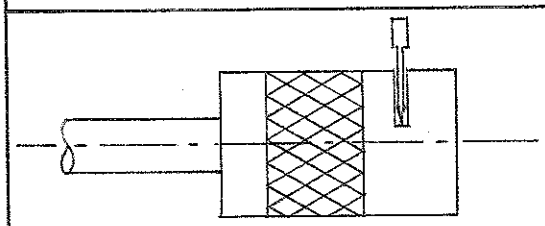
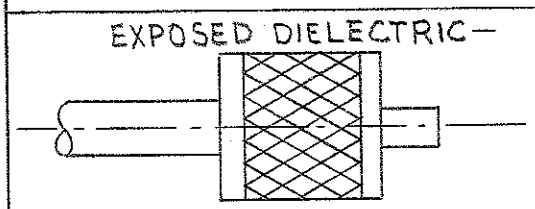
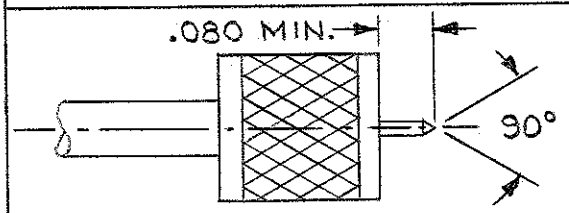
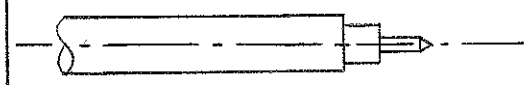
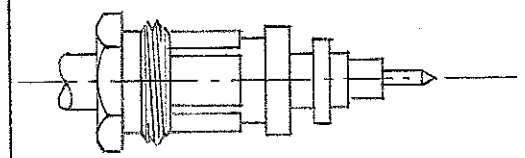
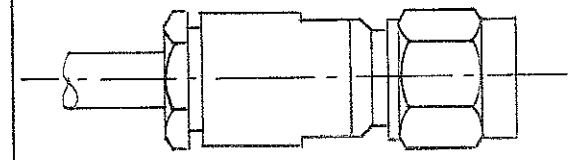
ASSEMBLY PROCEDURE FOR FIELD SERVICEABLE SMA CONNECTOR NO. 901-111





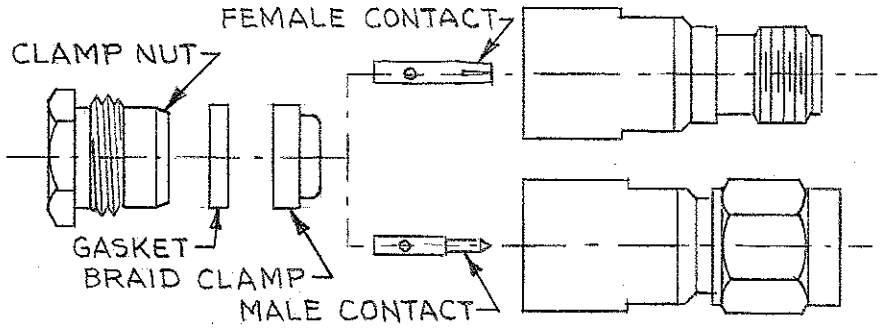
STRIPPING DIM'S SHOWN FOR REF. ONLY

TOOLS REQ'D.
KIT NO. 901-2500

	TRIM CABLE SQUARE, DEBURR & CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING FORCE ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	USING DIELECTRIC TRIM TOOL 901-C AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE DO NOT NICK CENTER CONDUCTOR.
	FILE BLUNT END OF CENTER CONDUCTOR TO A 90° CONE.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY.
	SLIDE CLAMP NUT AND GASKET OVER COPPER JACKET OF CABLE.
	INSERT PREPARED CABLE TERMINATION INTO CONNECTOR BODY. MAKE SURE COPPER JACKET OF CABLE SEATS PROPERLY AGAINST CONNECTOR BODY SHOULDER. TIGHTEN NUT TO 15-20 IN./LB. TORQUE, WHILE HOLDING BODY STATIONARY.

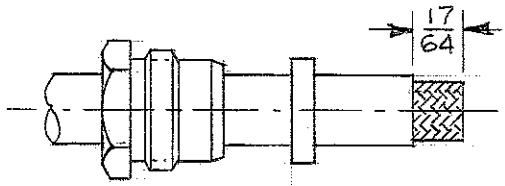
Spec. No. 349-50114

ASSEMBLY PROCEDURE FOR FIELD SERVICEABLE SMA CONNECTORS

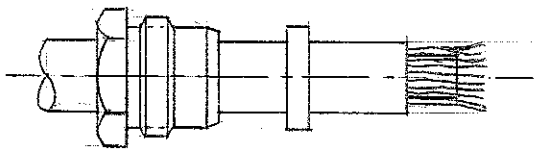


TOOLS REQ'D:
KIT NO. 901-2500

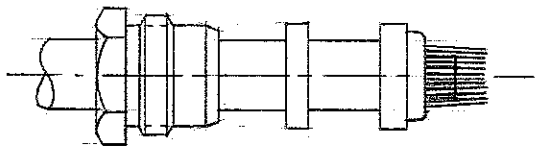
TOOL NO.	CONNECTOR
901-D	901-103, -104, -121 & -122.
901-8	901-257, -257-11 & 257-12.



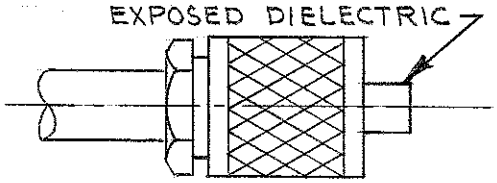
PLACE NUT AND GASKET OVER CABLE AND CUT JACKET TO DIMENSION SHOWN.



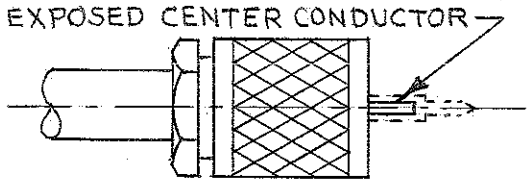
COMB OUT BRAID AND FOLD OUT.



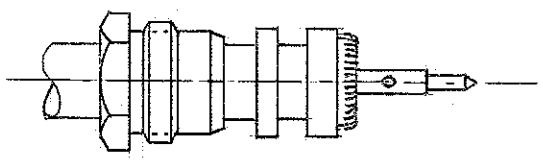
PULL BRAID WIRES FORWARD AND TAPER TOWARD CENTER CONDUCTOR. PLACE BRAID CLAMP OVER BRAID AND PUSH BACK AGAINST CABLE JACKET. FOLD BACK BRAID WIRES, TRIM AS NECESSARY SO THAT WIRES DO NOT TOUCH SHOULDER OF CLAMP.



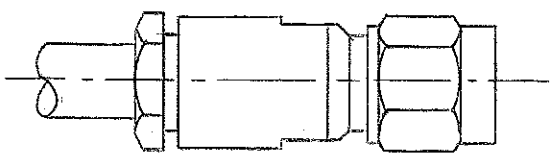
USING DIELECTRIC TRIM TOOL, SEE TABLE ABOVE, AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR. TIGHTEN NUT LIGHTLY. DO NOT DAMAGE GASKET.



SOLDER CENTER CONTACT TO CABLE. CENTER CONTACT MUST SEAT SQUARE AGAINST DIELECTRIC. AVOID EXCESSIVE HEAT, WHICH MAY DISTORT DIELECTRIC



REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY.

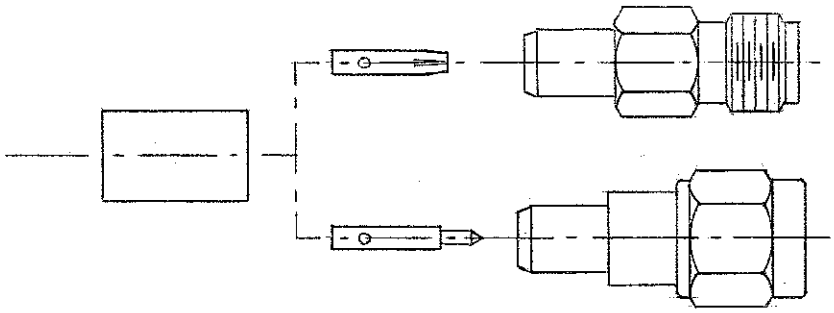


THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 20-25 IN./LBS. TORQUE.

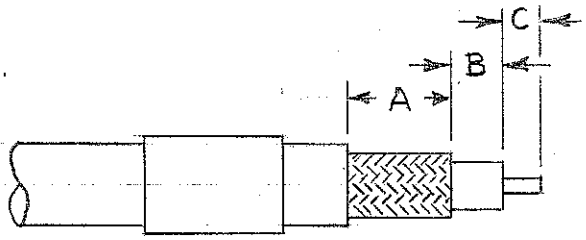
Spec. No. 349-50114

Sheet 6 Cont. on 7

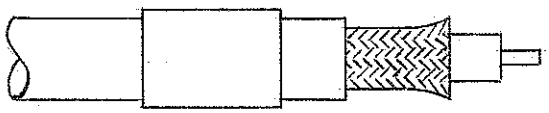
ASSEMBLY PROCEDURE FOR CRIMP TYPE SMA CONNECTOR
NOS. 901-101, -102, -109, -110, -192, -152, 153, -246 & -200



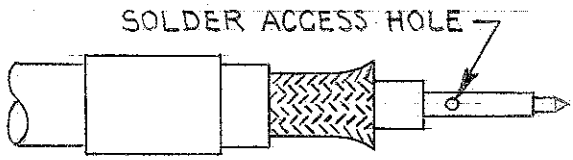
SEE TABLE BELOW FOR PROPER CRIMPING TOOL.



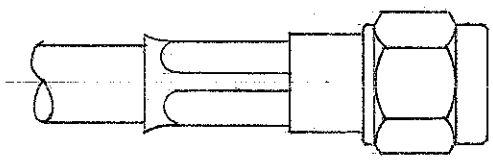
SLIDE OUTER FERRULE ONTO CABLE AS SHOWN. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.



FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE. IMPORTANT: DO NOT COMB OUT BRAID.



SOLDER CENTER CONTACT TO CABLE. NOTE: CENTER CONDUCTOR SHOULD BE VISIBLE THROUGH SOFT SOLDER ACCESS HOLE IN CONTACT, PRIOR TO SOLDERING.

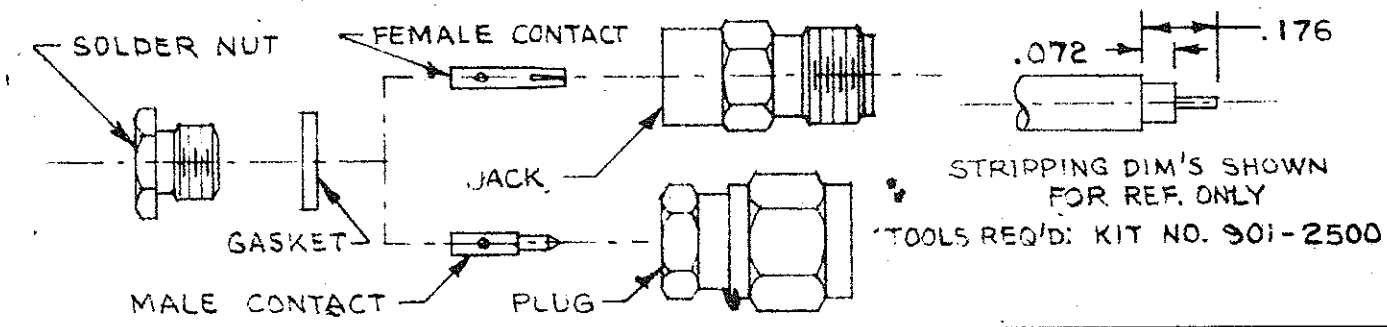


INSTALL BODY ONTO CABLE SO THAT FERRULE PORTION SLIDES UNDER BRAID AND INSULATOR BUTTS FLUSH AGAINST CABLE DIELECTRIC. SLIDE OUTER FERRULE OVER BRAID AND UP AGAINST BODY. MAKE SURE NO SLACK EXISTS IN BRAID. CRIMP OVER FERRULE WITH TOOL SPECIFIED IN TABLE, KEEPING CABLE DIELECTRIC BOTTOMED AGAINST INSULATOR.

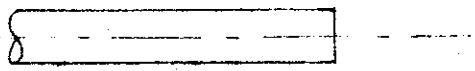
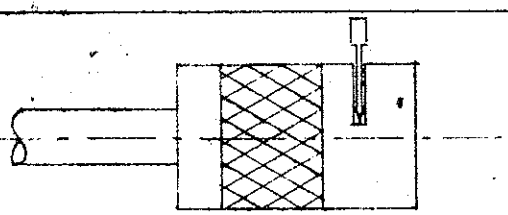
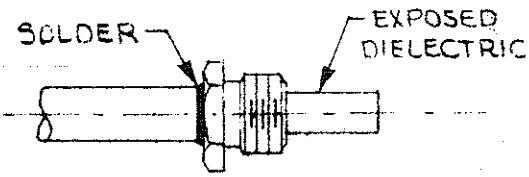
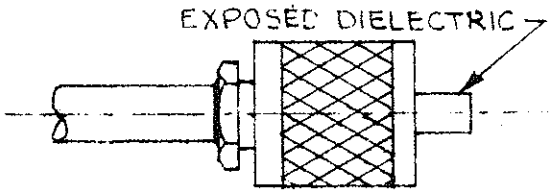
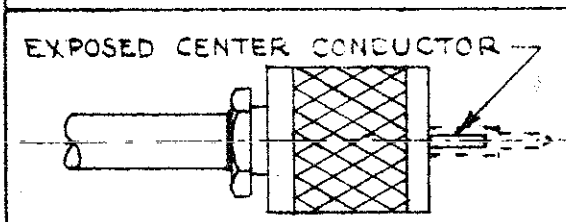
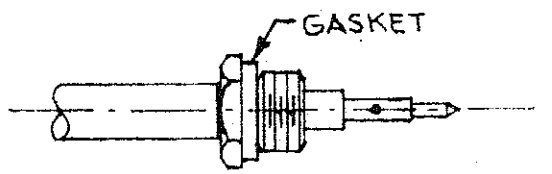
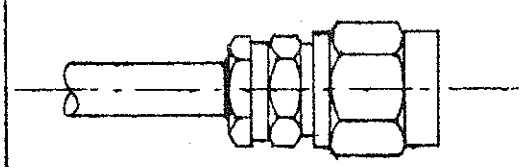
PART NO.	A	B	C	AMPHENOL HEX CRIMP TOOLS FOR USE WITH RG-/U CABLE	AMPHENOL TOOL NO.	AMPHENOL DIE NO.	DIE CAVITY DESIGNATION
901-101, -102, -109, -110, -152, -153, -246	9/32	7/64	9/64	55, 58, 141, 142, 223	227-944	227-1221-11	A
901-192	9/32	5/64	3/32	195, 180	227-944	227-1221-09	A
901-422, -423	9/32	3/32	9/64	174, 179, 187, 316		227-1221-03	
901-200	9/32	7/64	3/32	59	227-944	227-1221-13	A
901-3079, 82, 85, 88 80, 83, 86, 89 81, 84, 87	9/32	7/64	9/64	Spec. No. 349-50114			

SHEET NO. 7- CONT. ON SHEET NO. 8

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTORS
FOR NOS. 901-126, 901-127, 901-151, 901-158, 901-193 & 901-195



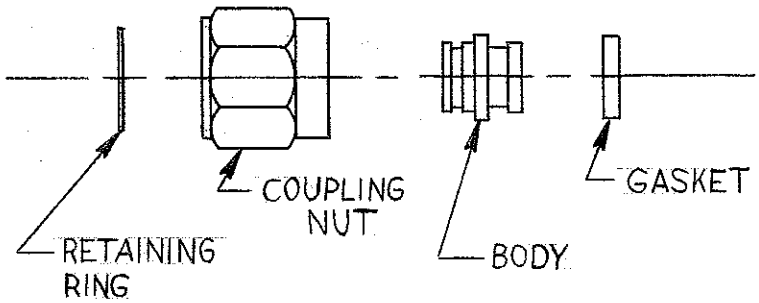
TOOLS REQ'D: KIT NO. 901-2500

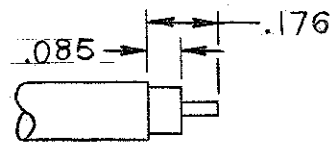
	TRIM CABLE SQUARE, DEBURR & CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-E AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING FORCE ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	PLACE SOLDER NUT OVER CABLE; COPPER JACKET MUST BOTTOM ON SHOULDER OF SOLDER NUT. SOLDER AS SHOWN.
	<u>CAUTION</u> - BEFORE TRIMMING DIELECTRIC, ASSEMBLY MUST BE ALLOWED TO COOL. USING DIELECTRIC TRIM TOOL 901-F AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR.
	SOLDER CENTER CONTACT TO CABLE. CENTER CONTACT MUST SEAT SQUARE AGAINST DIELECTRIC. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY. INSTALL GASKET AS SHOWN.
	THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 15 - 25 IN/LBS. TORQUE.

Spec. No. 349-50114

SHEET 8 CONT. ON 9

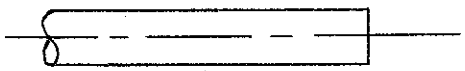
ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-183



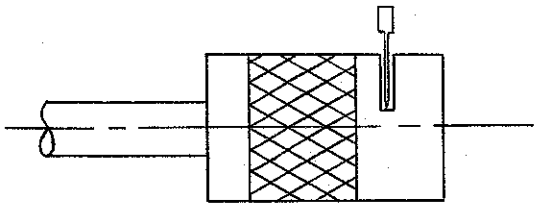


STRIPPING DIM'S SHOWN FOR REF. ONLY

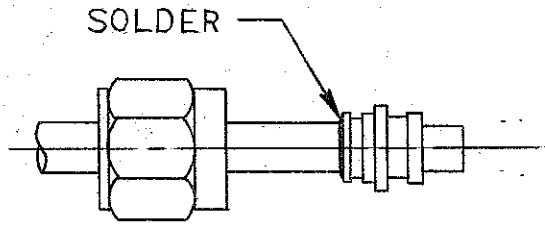
TOOLS REQ'D: KIT NO. 901-2500.



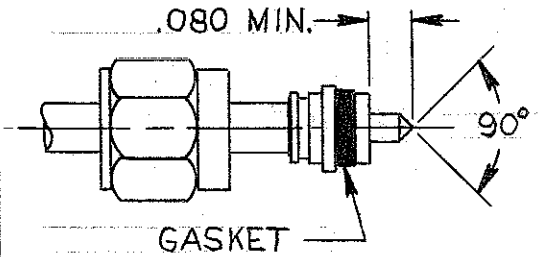
TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.



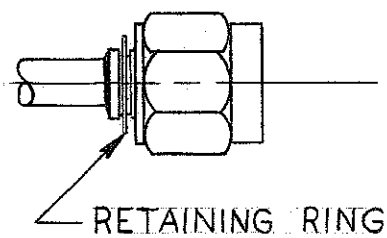
USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.



SLIDE COUPLING NUT ON CABLE. PLACE BODY ON CABLE. COPPER JACKET MUST BOTTOM ON SHOULDER OF BODY. SOLDER AS SHOWN. USE MINIMUM AMOUNT OF SOLDER AND CARE TO PREVENT SOLDER FLOWING OVER OUT SIDE OF BODY.

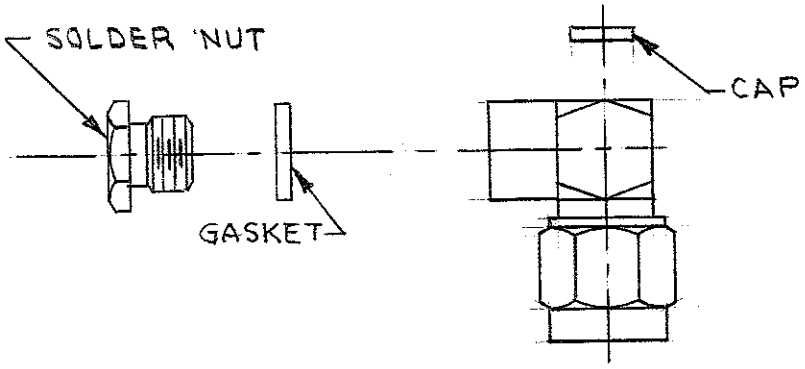


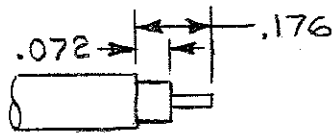
CAUTION – BEFORE TRIMMING DIELECTRIC, ASSEMBLY MUST BE ALLOWED TO COOL. CUT DIELECTRIC SQUARE AND AS CLOSE TO BODY AS POSSIBLE AND REMOVE. DO NOT NICK CENTER CONDUCTOR. FILE BLUNT END OF CENTER CONDUCTOR TO A 90° CONE. INSTALL GASKET.



SLIDE NUT OVER BODY AND SNAP RETAINING RING IN PLACE.

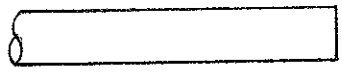
ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-136



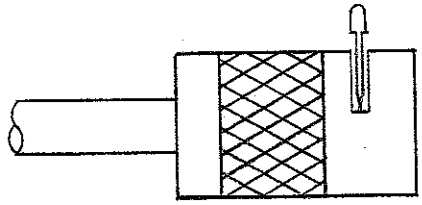


STRIPPING DIM'S. SHOWN FOR REF. ONLY

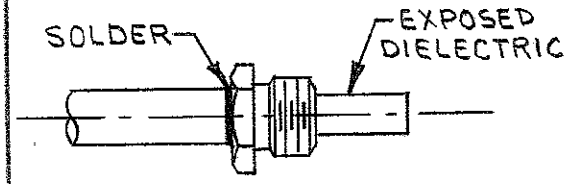
TOOLS REQ'D: KIT NO. 901-2500



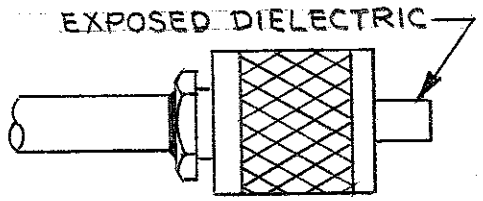
TRIM CABLE SQUARE DEBURR AND CLEAN COPPER JACKET 5/8 MIN.



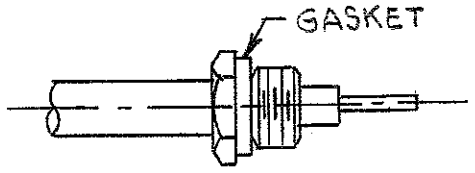
USING TOOL 901-E AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE, APPLY LIGHT BENDING FORCE ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.



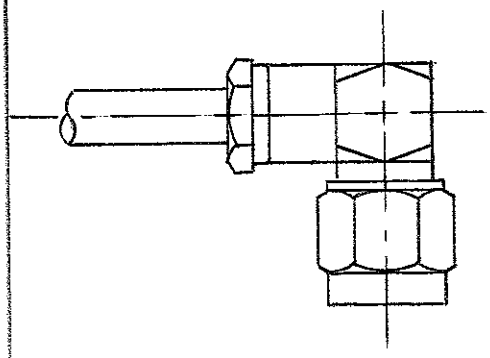
PLACE SOLDER NUT OVER CABLE; COPPER JACKET MUST BOTTOM ON SHOULDER OF SOLDER NUT. SOLDER AS SHOWN.



<u>CAUTION</u> - BEFORE TRIMMING DIELECTRIC, ASSEMBLY MUST BE ALLOWED TO COOL. USING DIELECTRIC TRIM TOOL 901-F AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE DO NOT NICK CENTER CONDUCTOR.



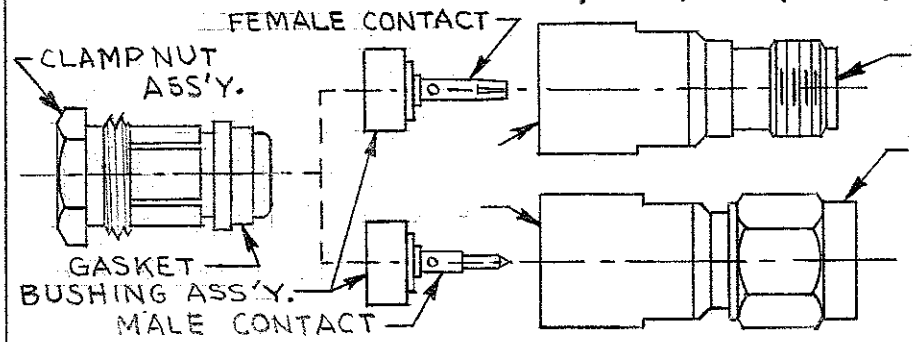
REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY. INSTALL GASKET AS SHOWN



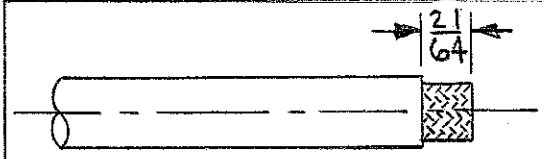
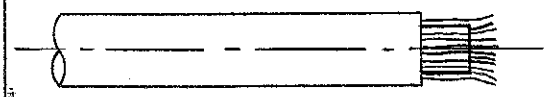
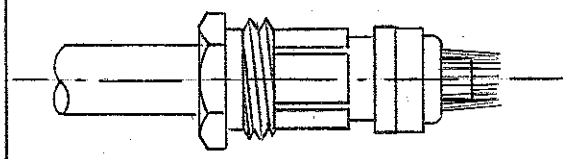
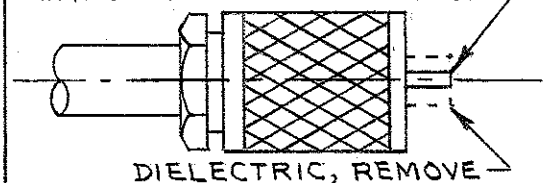
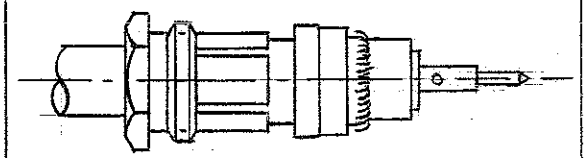
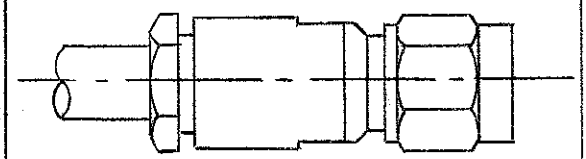
THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 15-25 IN./LBS. TORQUE AND SOLDER CENTER CONDUCTOR AND CAP IN PLACE.

SHEET 10 CONT'D ON 11

ASSEMBLY PROCEDURE FOR FIELD SERVICEABLE SMA CONNECTORS NOS. 901-128,-173,-174,-139,-129,-220,-281,-283,-256,-246



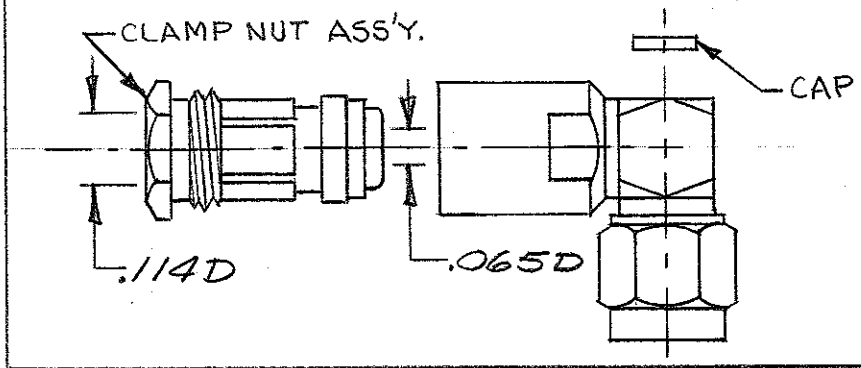
TOOLS REQ'D:
KIT NO. 901-2500

	CUT JACKET TO DIMENSION SHOWN.
	COMB OUT BRAID AND FOLD OUT.
	PULL BRAID WIRES FORWARD AND TAPER TOWARD CENTER CONDUCTOR. PLACE CLAMP NUT ASS'Y. OVER BRAID AND PUSH BACK AGAINST CABLE JACKET. FOLD BACK BRAID WIRES, TRIM AS NECESSARY SO THAT WIRES DO NOT TOUCH SHOULDER OF GASKET.
	SCREW TRIM TOOL (SEE TABLE BELOW) ONTO CLAMP NUT ASSEMBLY. TIGHTEN NUT LIGHTLY. DO NOT DAMAGE GASKET. USING RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY. ASSEMBLE BUSHING ASSEMBLY AND SOLDER CENTER CONTACT TO CABLE.
	THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 20-25 IN./LBS. TORQUE.

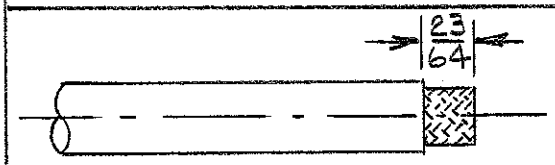
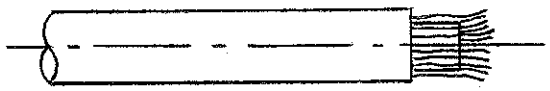
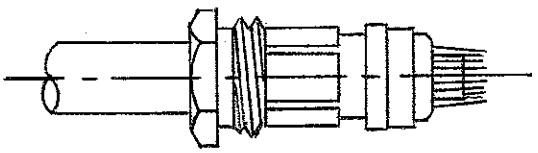
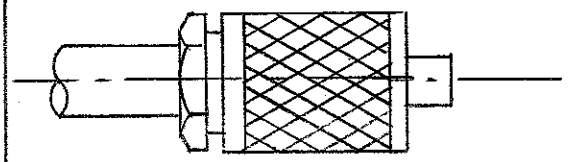
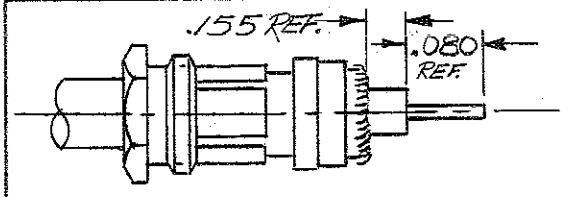
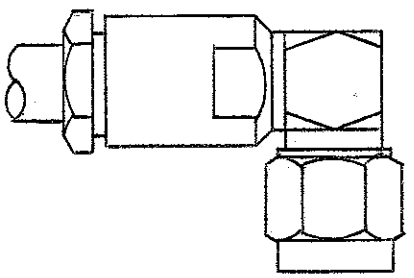
TOOL NO.	CONNECTOR
901-G	901-128,-173,-174,-129
901-3	901-139,-220, 246
901-6	901-281,-283 & -256

SPEC. 349-50114 SHEET 11

ASSEMBLY PROCEDURE FOR FIELD SERVICEABLE SMA CONNECTORS NOS. 901-140,-172 & -287, 367, 368

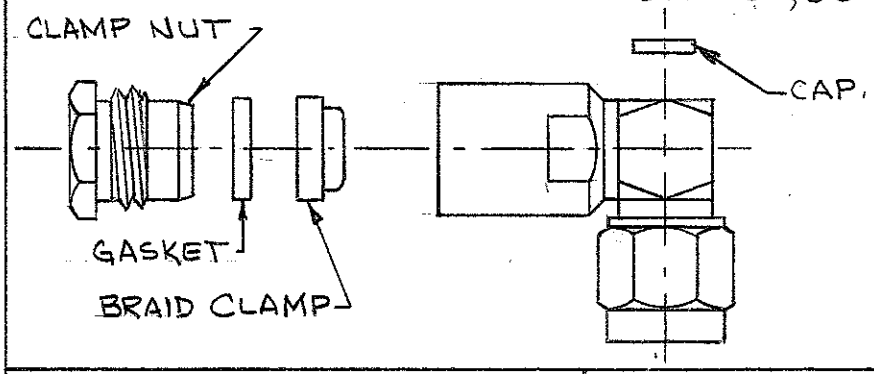


OPTIONAL TOOLS REQ'D: KIT NO. 901-2500.

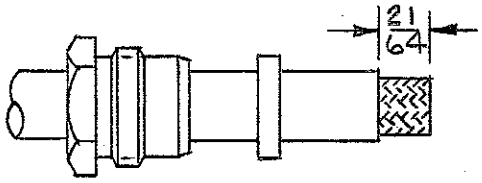
	CUT JACKET TO DIMENSION SHOWN.
	COMB OUT BRAID AND FOLD OUT.
	PULL BRAID WIRES FORWARD AND TAPER TOWARD CENTER CONDUCTOR. PLACE CLAMP NUT ASS'Y. OVER BRAID AND PUSH BACK AGAINST CABLE JACKET. FOLD BACK BRAID WIRES, TRIM AS NECESSARY SO THAT WIRES DO NOT TOUCH SHOULDER OF GASKET.
	USING DIELECTRIC TRIM TOOL (SEE TABLE BELOW) AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR. TIGHTEN NUT LIGHTLY. DO NOT DAMAGE GASKET.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY. OR TRIM DIELECTRIC & CENTER CONDUCTOR TO DIMENSONS SHOWN
	THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 14-16 IN./LBS. TORQUE AND SOLDER CENTER CONDUCTOR AND CAP IN PLACE.

CONNECTOR	TOOL NO.
901-140, 172, 287 & 368	901-5
901-367	901-7

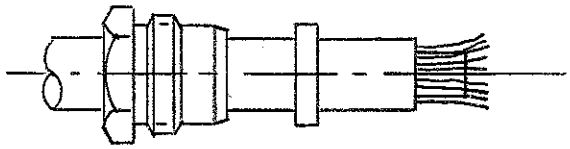
ASSEMBLY PROCEDURE FOR FIELD SERVICEABLE SMA CONNECTOR NO. 901-130, 901-369, -370



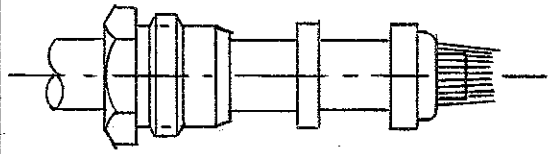
TOOLS REQ'D:
KIT NO. 901-2500.



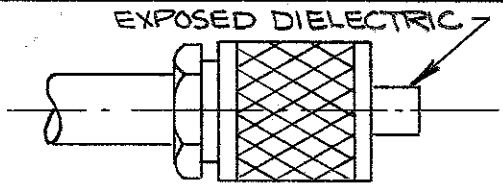
PLACE NUT AND GASKET OVER CABLE AND CUT JACKET TO DIMENSION SHOWN.



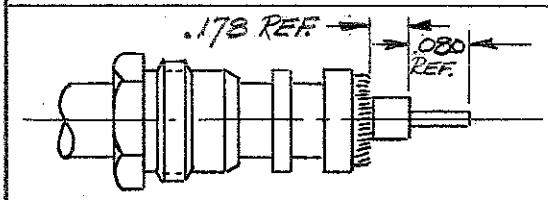
COMB OUT BRAID AND FOLD OUT.



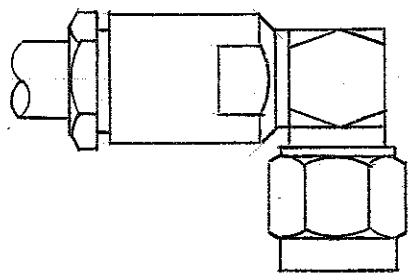
PULL BRAID WIRES FORWARD AND TAPER TOWARD CENTER CONDUCTOR PLACE BRAID CLAMP OVER BRAID AND PUSH BACK AGAINST CABLE JACKET. FOLD BACK BRAID WIRES, TRIM AS NECESSARY SO THAT WIRES DO NOT TOUCH SHOULDER OF CLAMP.



USING DIELECTRIC TRIM TOOL 901-4 AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR, TIGHTEN NUT LIGHTLY. DO NOT DAMAGE GASKET.



REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY.

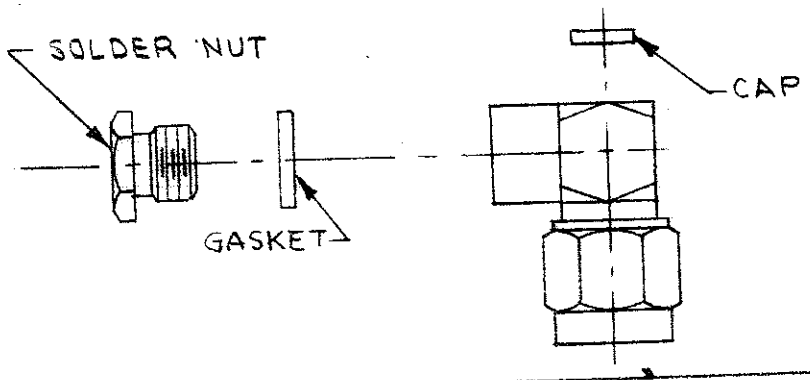


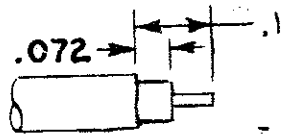
THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY TIGHTEN TO 15-18 IN./LBS. TORQUE AND SOLDER CENTER CONDUCTOR AND CAP IN PLACE.

SPEC. X349-50114 SHEET 13

SHEET 13 CONT. ON 14.

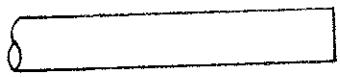
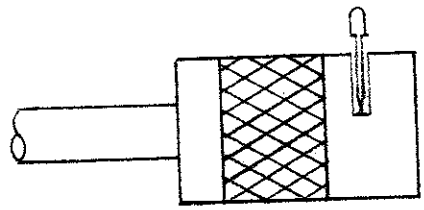
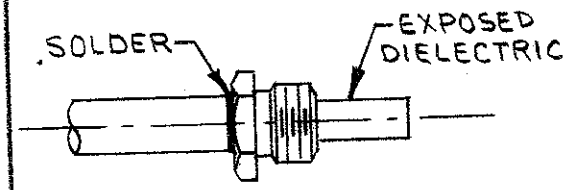
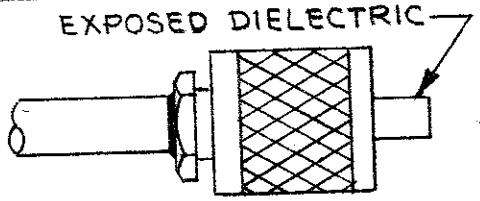
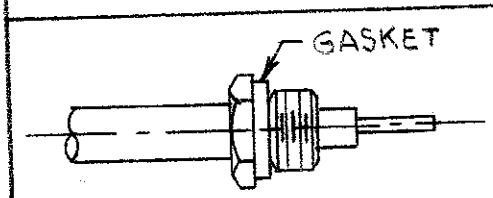
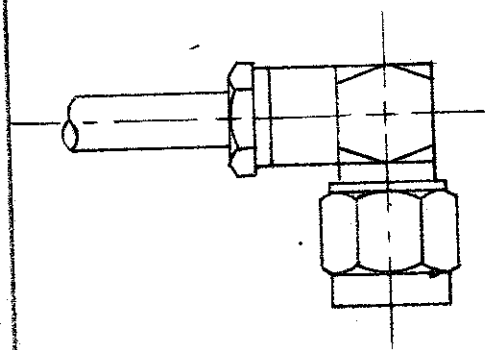
ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-142





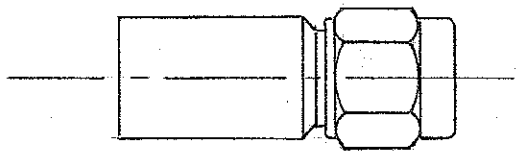
STRIPPING DIM'S. SHOWN FOR REF. ONLY

TOOLS REQ'D: KIT NO. 901-2500

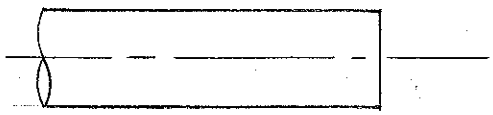
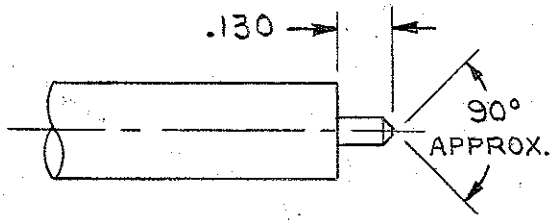
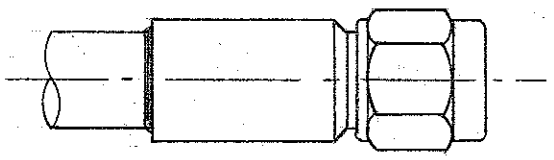
	TRIM CABLE SQUARE DEBURR AND CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE, APPLY LIGHT BENDING FORCE ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	PLACE SOLDER NUT OVER CABLE; COPPER JACKET MUST BOTTOM ON SHOULDER OF SOLDER NUT. SOLDER AS SHOWN.
	<u>CAUTION</u> - BEFORE TRIMMING DIELECTRIC, ASSEMBLY MUST BE ALLOWED TO COOL. USING DIELECTRIC TRIM TOOL 901-B AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE DO NOT NICK CENTER CONDUCTOR.
	REMOVE DIELECTRIC TRIM TOOL AND CLEAN ALL SURFACES THOROUGHLY. INSTALL GASKET AS SHOWN
	THREAD CONNECTOR ASSEMBLY ONTO PREPARED CABLE ASSEMBLY. TIGHTEN TO 15-25 IN./LBS. TORQUE AND SOLDER CENTER CONDUCTOR AND CAP IN PLACE.

SHEET 14 CONT'D. ON 15

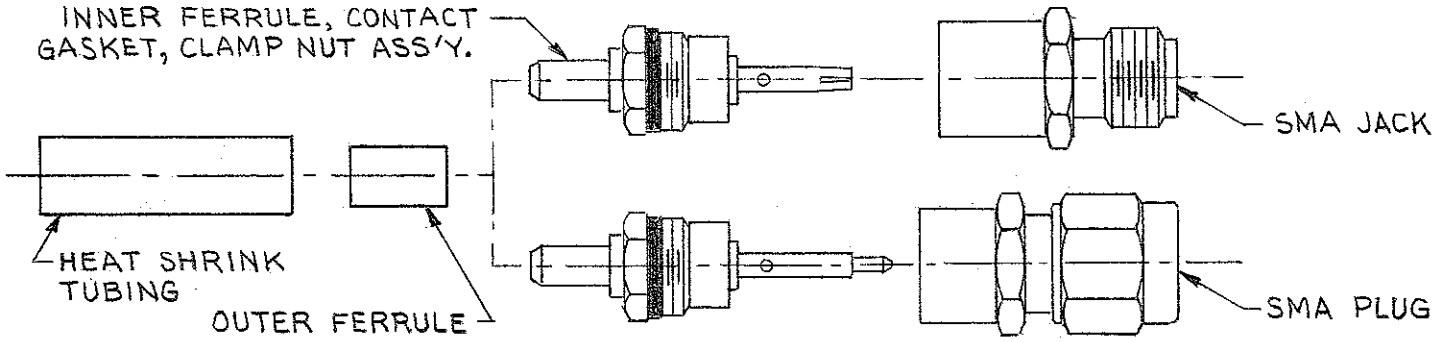
ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-273

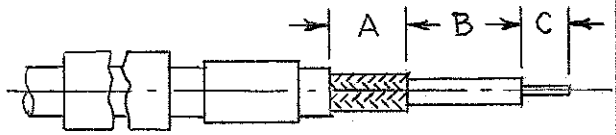


FOR USE WITH .250 CUJAK CABLE

	TRIM CABLE SQUARE. CLEAN COPPER JACKET 5/8 MIN.
	TRIM JACKET AND DIELECTRIC TO DIMENSION SHOWN. CUT MUST BE SMOOTH AND SQUARE. DO NOT NICK CENTER CONDUCTOR. POINT CENTER CONDUCTOR AS SHOWN. REMOVE BURRS.
	INSERT CABLE. JACKET MUST BUTT FIRMLY AGAINST SHOULDER OF CONNECTOR. MAINTAIN END PRESSURE WHILE SOLDERING. CAUTION - AVOID OVERHEATING.

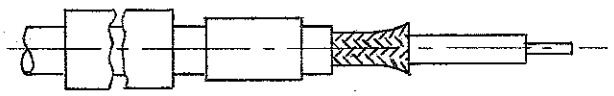
ASSEMBLY PROCEDURE FOR CRIMP TYPE SMA CONNECTOR NO. 901-155



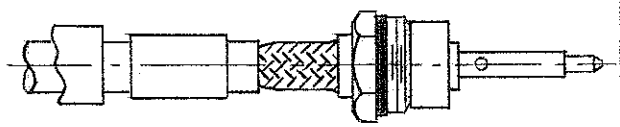


CONNECTOR	A	B	C	TOOL & DIE
901-155	7/32	11/32	1/8	TOOL 227-944
901-155-16 901-156 901-476	9/32	7/64	9/64	DIE SET 227-1221-03
901-109-15	9/32	7/64	9/64	TOOL 227-944 DIE SET 227-1221-11

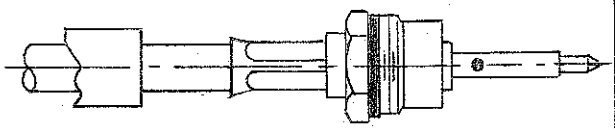
SLIDE HEAT SHRINK TUBING AND OUTER FERRULE ONTO CABLE. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.



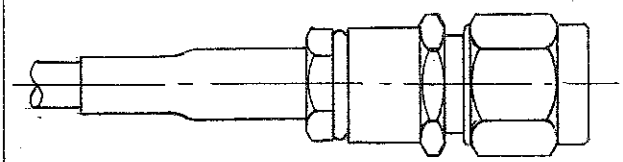
FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE, CONTACT ASSEMBLY. IMPORTANT: DO NOT COMB OUT BRAID.



INSTALL FERRULE-CONTACT ASS'Y. ONTO CABLE. SOLDER CENTER CONTACT TO CABLE. NOTE CENTER CONDUCTOR SHOULD BE VISIBLE THROUGH SOLDER ACCESS HOLE IN CONTACT, PRIOR TO SOLDERING. CABLE MUST BUTT FIRMLY AGAINST CONTACT WHILE SOLDERING.

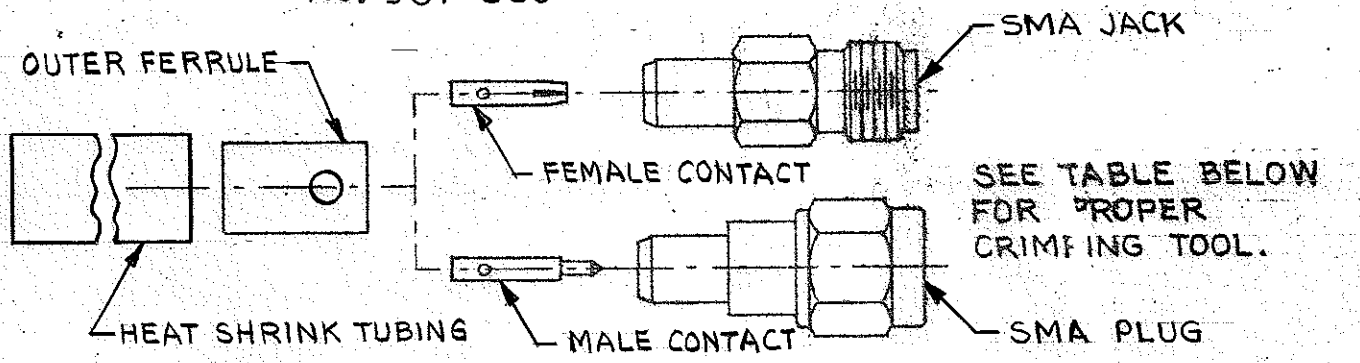


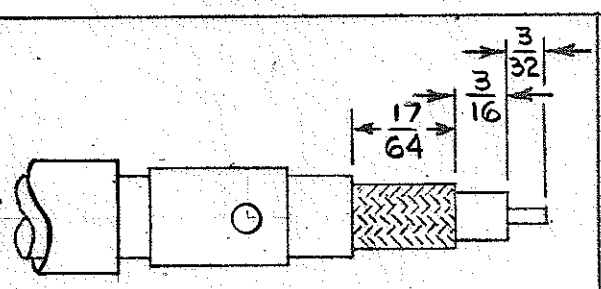
SLIDE OUTER FERRULE IN PLACE AND CRIMP WITH THOMAS & BETTS TOOL PER ABOVE TABLE



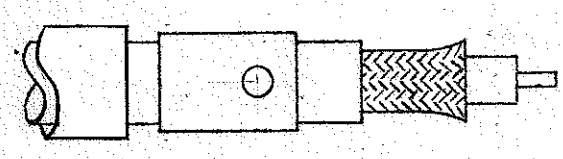
SCREW FERRULE-CONTACT ASSEMBLY INTO BODY AND TIGHTEN TO 20-25 IN./LBS. TORQUE. SLIDE HEAT SHRINK TUBING OVER FERRULE, UP AGAINST CLAMP NUT AND APPLY HEAT.

ASSEMBLY PROCEDURE FOR CRIMP TYPE SMA CONNECTOR NO. 901-360

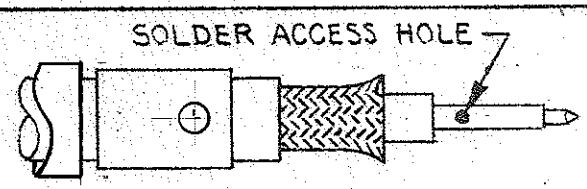




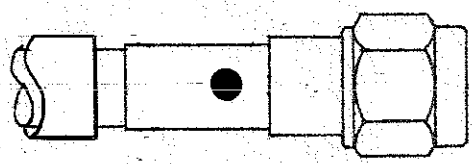
SLIDE HEAT SHRINK TUBING AND OUTER FERRULE ONTO CABLE AS SHOWN. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.



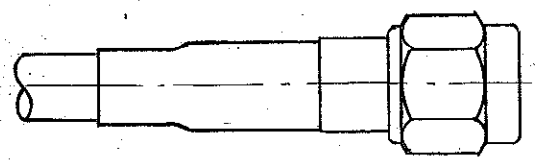
FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE. IMPORTANT: DO NOT COMB OUT BRAID.



SOLDER CENTER CONTACT TO CABLE. NOTE: CENTER CONDUCTOR SHOULD BE VISIBLE THROUGH SOFT SOLDER ACCESS HOLE IN CONTACT, PRIOR TO SOLDERING.

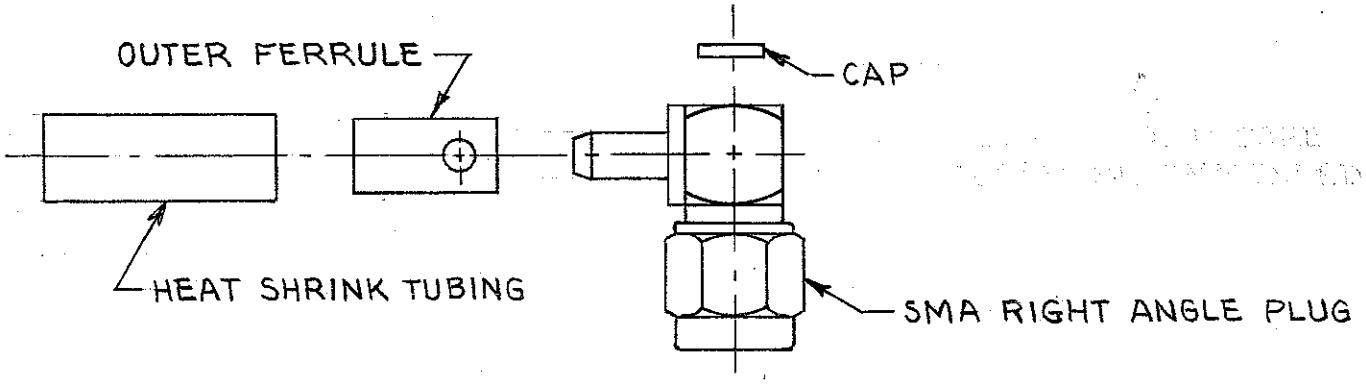


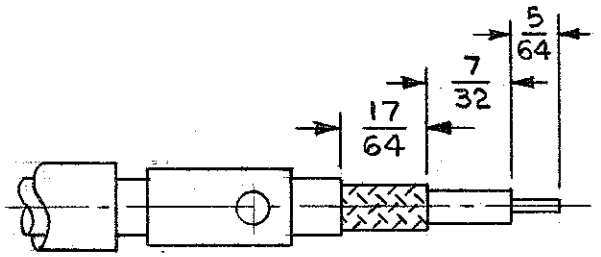
INSTALL BODY ONTO CABLE SO THAT FERRULE PORTION SLIDES UNDER BRAID AND INSULATOR BUTTS FLUSH AGAINST CABLE DIELECTRIC. SLIDE OUTER FERRULE OVER BRAID AND UP AGAINST BODY. MAKE SURE NO SLACK EXISTS IN BRAID. SOLDER THRU ACCESS HOLE SO THAT BODY, BRAID AND FERRULE ARE SECURELY ATTACHED.



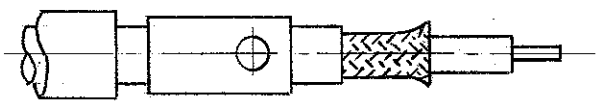
SLIDE HEAT SHRINK TUBING UP AGAINST SHOULDER OF BODY AND APPLY MODERATE HEAT.

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-361

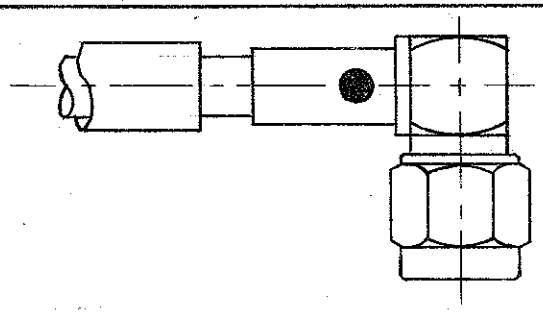




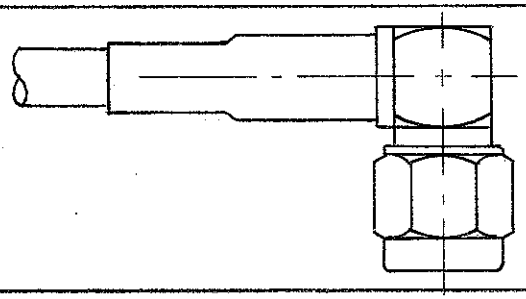
SLIDE HEAT SHRINK TUBING AND OUTER FERRULE ONTO CABLE AS SHOWN. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.



FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE. IMPORTANT: DO NOT COMB OUT BRAID.



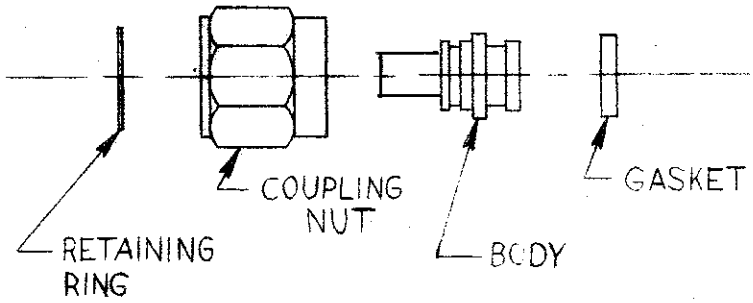
INSTALL BODY ONTO CABLE SO THAT FERRULE SLIDES UNDER BRAID. CENTER CONDUCTOR SHOULD OCCUPY SLOT IN CENTER CONTACT BUT NOT PROTRUDE ABOVE. DIELECTRIC SHOULD EXTEND APPROX. 1/64 INTO CAVITY. SOLDER CENTER CONDUCTOR TO CONTACT. SOLDER THRU ACCESS HOLE IN FERRULE SO THAT IT IS SECURELY ATTACHED TO BRAID AND BODY. SOLDER CAP TO BODY.

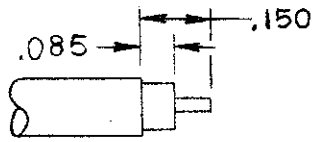


SLIDE HEAT SHRINK TUBING UP AGAINST SHOULDER OF BODY AND APPLY MODERATE HEAT.

SPEC. NO. 349-50114
SHEET NO. 19 CONT'D ON 20

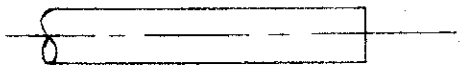
ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-390



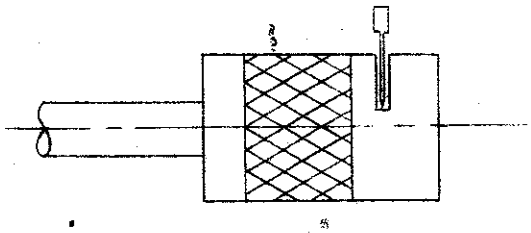


STRIPPING DIM'S SHOWN FOR REF. ONLY

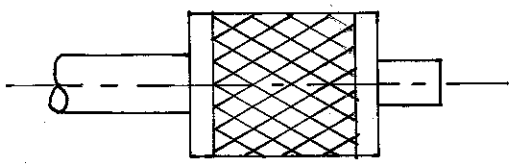
TOOLS REQ'D: 901-A & 901-8



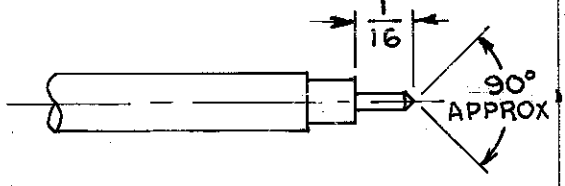
TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.



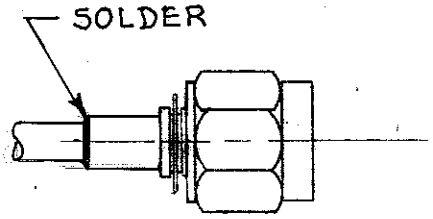
USING TOOL 901-A AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.



USING DIELECTRIC TRIM TOOL 901-8 AND RAZOR BLADE, REMOVE EXPOSED DIELECTRIC. CUT MUST BE SQUARE. DO NOT NICK CENTER CONDUCTOR.



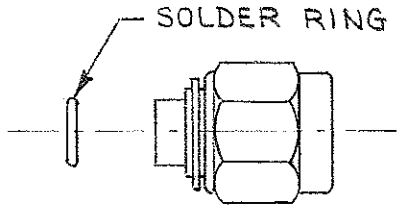
CUT CENTER CONTACT TO LENGTH AND POINT AS SHOWN.



INSERT PREPARED CABLE INTO CONNECTOR ASSEMBLY. CENTER CONDUCTOR MUST ENTER SOCKET IN CENTER CONTACT, PRESS IN FIRMLY AND SOLDER. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.

CONTINUED ON SHEET 21

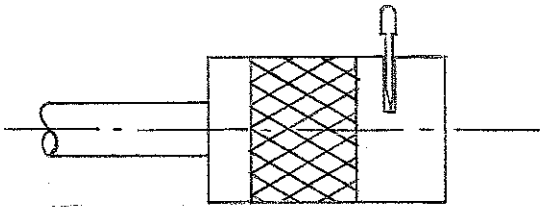
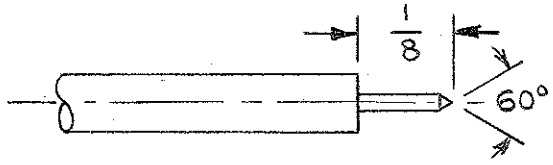
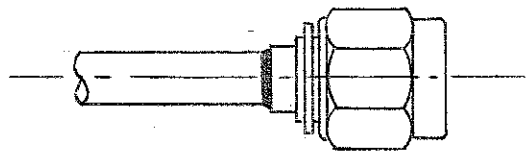
ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NO. 901-390



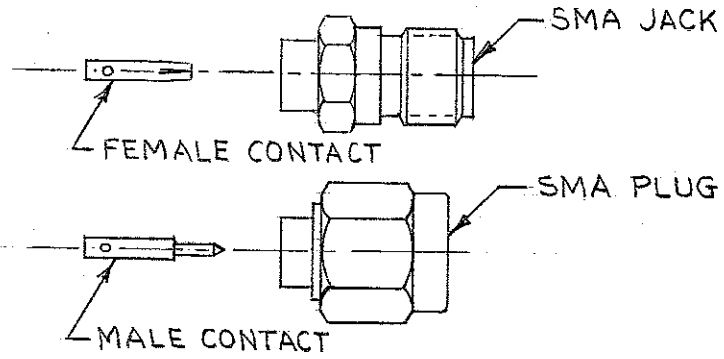
901-390 COMPLETE ASSEMBLY (PLUG)

DIMENSIONS AFTER STRIPPING

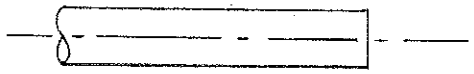
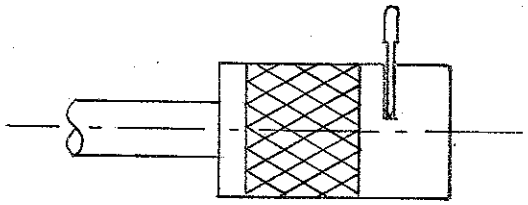
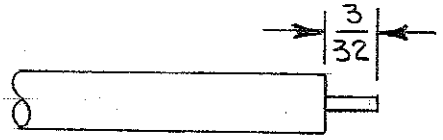
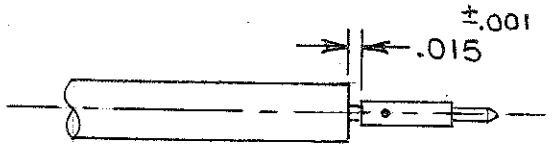
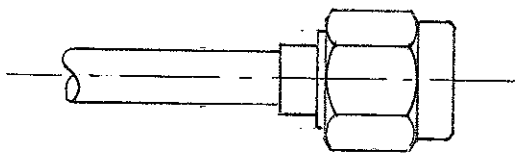
TOOLS REQ'D: TOOL NO. 901-E FROM AMPHENOL TOOL KIT NO. 901-2500

	TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-E AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	TRIM DIELECTRIC EVEN WITH JACKET DO NOT NICK CENTER CONDUCTOR. CUT CENTER CONDUCTOR TO LENGTH SHOWN AND POINT END APPROXIMATELY 60°.
	SLIDE SOLDER RING OVER CABLE. INSERT CABLE INTO CONNECTOR. MAKE SURE CENTER CONDUCTOR IS STRAIGHT. USE CARE IN PUSHING CENTER CONDUCTOR INTO SPRING CONTACT. MAKE SURE JACKET BOTTOMS IN CONNECTOR. MAINTAIN END PRESSURE WHILE SOLDERING. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NOS. 901-339, -340, -342, -408.



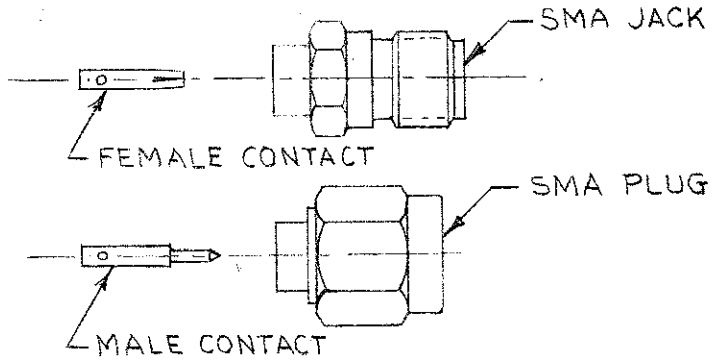
TOOLS REQ'D.
901-E FOR .085 CUJAK CABLE
901-A FOR .141 CUJAK CABLE
FROM TOOL KIT 901-2500.

	TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A OR 901-E AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	CUT DIELECTRIC BACK EVEN WITH JACKET. DO NOT NICK CENTER CONDUCTOR. CUT CENTER CONDUCTOR TO DIMENSION SHOWN.
	SOLDER CENTER CONTACT TO CENTER CONDUCTOR. USE .015 SHIM TO MAINTAIN SPACE ACCURATELY BETWEEN CONTACT AND JACKET.
	INSERT CABLE INTO CONNECTOR ASSEMBLY MAKE SURE JACKET BOTTOMS IN CONNECTOR. MAINTAIN END PRESSURE WHILE SOLDERING. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.

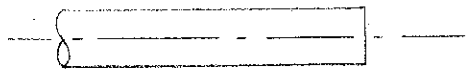
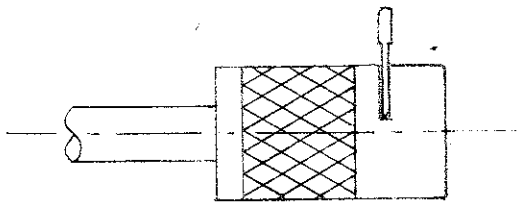
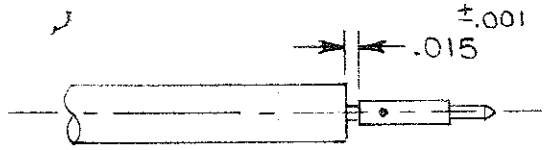
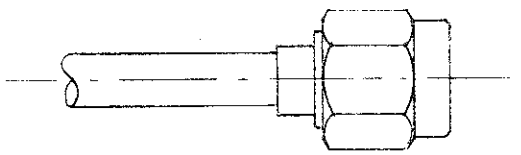
J. A. H. 10-4-72

SPEC. NO. 349-50114
SHEET NO. 22 - CONT. ON 23 -

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR NOS. 901-380, -381, -386



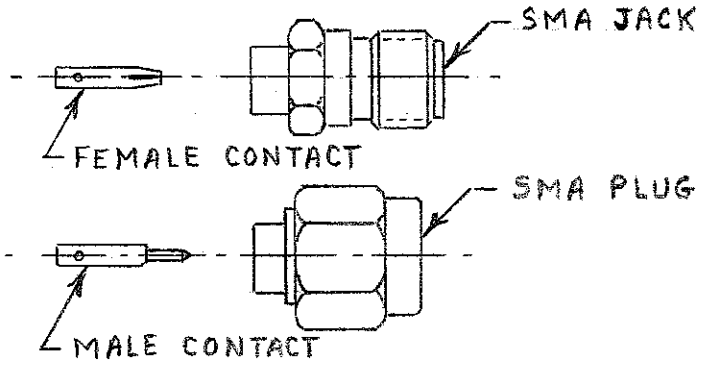
TOOLS REQ'D.
901-E FOR .085 CUJAK CABLE
901-A FOR .141 CUJAK CABLE
FROM TOOL KIT 901-2500.

	TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-A OR 901-E AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	CUT DIELECTRIC BACK EVEN WITH JACKET. DO NOT NICK CENTER CONDUCTOR. CUT CENTER CONDUCTOR TO DIMENSION SHOWN.
	SOLDER CENTER CONTACT TO CENTER CONDUCTOR. USE .015 SHIM TO MAINTAIN SPACE ACCURATELY BETWEEN CONTACT AND JACKET.
	INSERT CABLE INTO CONNECTOR ASSEMBLY MAKE SURE JACKET BOTTOMS IN CONNECTOR. MAINTAIN END PRESSURE WHILE SOLDERING. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.

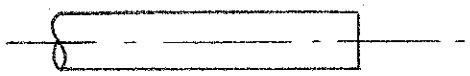
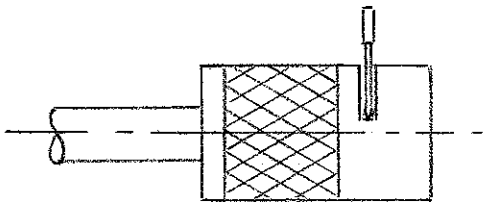
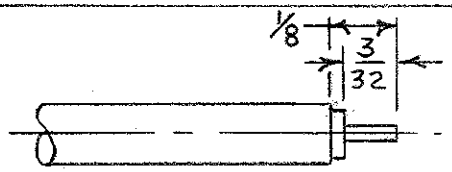
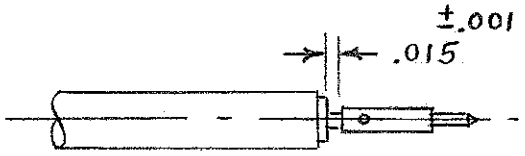
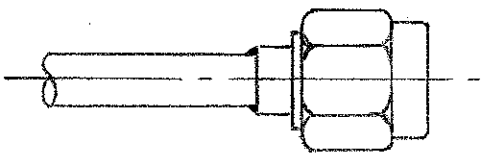
D.H.R. 10-18-72

SPEC. NO. 349-50114
SHEET NO. 23 - FINAL -

ASSEMBLY PROCEDURE FOR SOLDER TYPE SMA CONNECTOR 901-9005



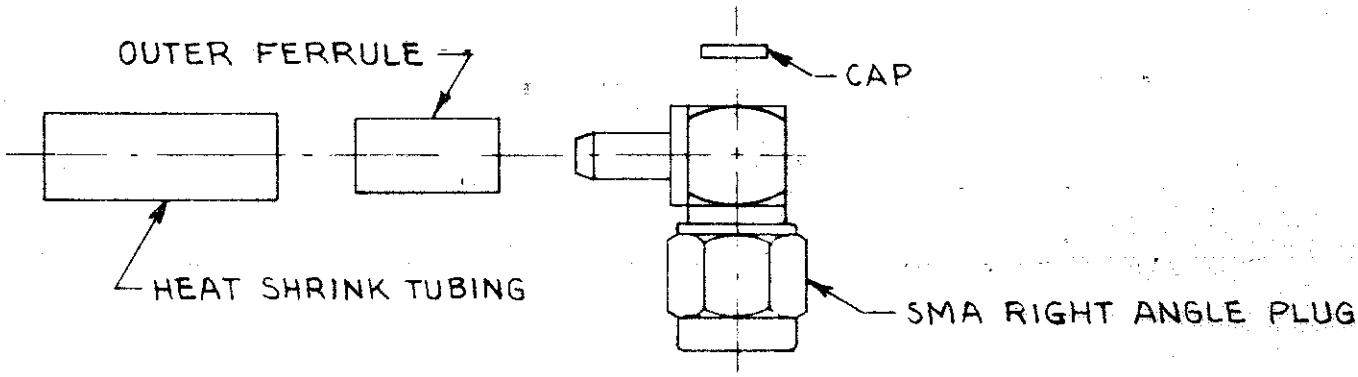
TOOLS REQ'D.
901-E FOR .086 RG-405/U CABLE

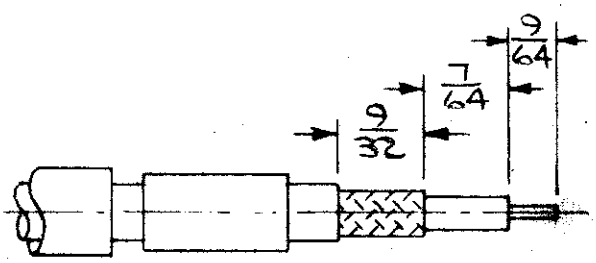
	TRIM CABLE SQUARE, DEBURR AND CLEAN COPPER JACKET 5/8 MIN.
	USING TOOL 901-E AND RAZOR BLADE, SCORE COPPER JACKET UNTIL BLADE BOTTOMS IN TOOL. RETRACT CABLE TO SCORE LINE. APPLY LIGHT BENDING ALTERNATELY UNTIL COPPER JACKET SEPARATES AT SCORE LINE AND REMOVE.
	CUT CENTER CONTACT TO DIMENSION SHOWN.
	SOLDER CENTER CONTACT TO CENTER CONDUCTOR. USE .015 SHIM TO MAINTAIN SPACE ACCURATELY BETWEEN CONTACT AND DIELECTRIC.
	INSERT CABLE INTO CONNECTOR ASSEMBLY MAKE SURE JACKET BOTTOMS IN CONNECTOR. MAINTAIN END PRESSURE WHILE SOLDERING. AVOID EXCESSIVE HEAT WHICH MAY DISTORT DIELECTRIC.

SPEC. NO. 349-50114
SHEET NO. 24 - FINAL

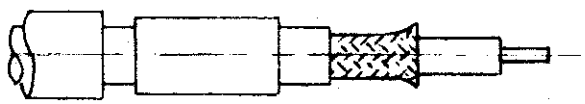
RV 9-21-79

ASSEMBLY PROCEDURE FOR CRIMP TYPE SMA CONNECTOR 901-3090; 3091; 3092

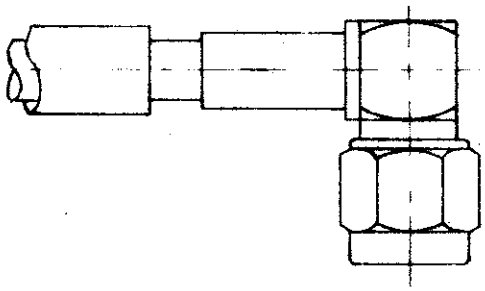




SLIDE HEAT SHRINK TUBING AND OUTER FERRULE ONTO CABLE AS SHOWN. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.

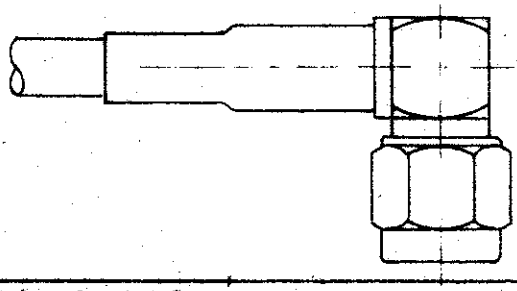


FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE. IMPORTANT: DO NOT COMB OUT BRAID.



INSTALL BODY ONTO CABLE SO THAT FERRULE SLIDES UNDER BRAID. CENTER CONDUCTOR SHOULD OCCUPY SLOT IN CENTER CONTACT BUT NOT PROTRUDE ABOVE. CRIMP FERRULE WITH PROPER TOOL. (SEE CHART BELOW) SOLDER CENTER CONDUCTOR TO CONTACT.

SOLDER CAP TO BODY. DO NOT USE EXCESSIVE HEAT.



SLIDE HEAT SHRINK TUBING UP AGAINST SHOULDER OF BODY AND APPLY MODERATE HEAT.

PART Nº
901-3090
901-3091
901-3092

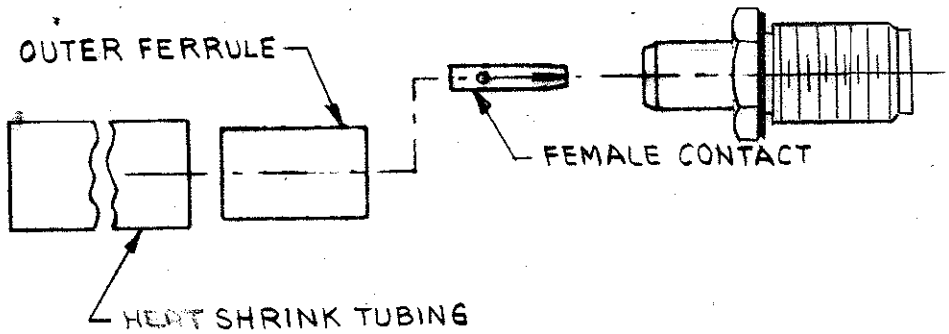
AMPHENOL HEX CRIMP TOOL FOR RG-/U CABLE	AMPHENOL TOOL Nº	AMPHENOL DIE Nº	DIE CAVITY
58,55,141,142,223	227-944	227-1221-11	A
180, 195	227-944	227-1221-09	A
316,174,179,187	227-944	227-1221-03	A

SPEC. NO. 349-50114

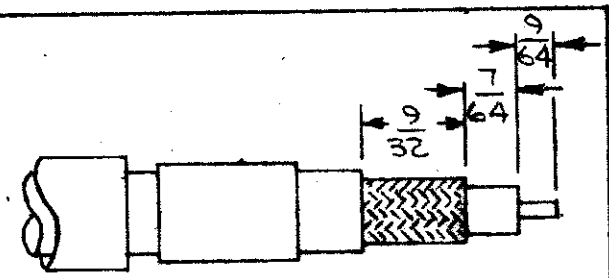
SHEET NO. 25 CONT'D ON 26

ASSEMBLY PROCEDURE FOR CRIMP TYPE SMA CONNECTOR

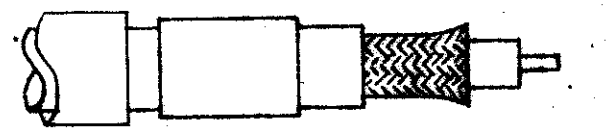
NO. 901-3073; 3074; 3075; 3076; 3077; 3078.
-SMA JACK



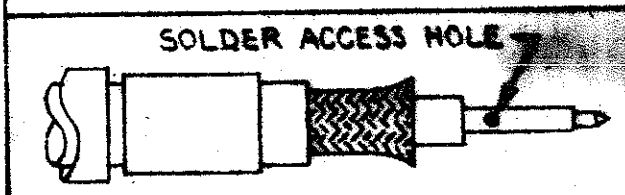
SEE TABLE BELOW FOR PROPER CRIMPING TOOL.



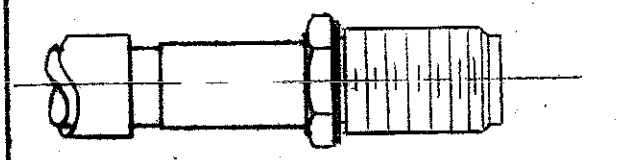
SLIDE HEAT SHRINK TUBING AND OUTER FERRULE ONTO CABLE AS SHOWN. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC, OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.



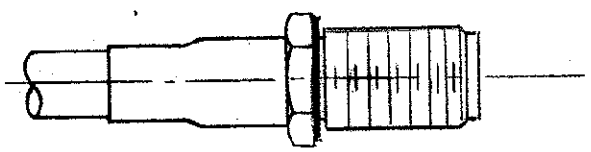
FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE. IMPORTANT: DO NOT COMB OUT BRAID.



SOLDER CENTER CONTACT TO CABLE. NOTE: CENTER CONDUCTOR SHOULD BE VISIBLE THROUGH SOFT SOLDER ACCESS HOLE IN CONTACT, PRIOR TO SOLDERING.



INSTALL BODY ONTO CABLE SO THAT FERRULE PORTION SLIDES UNDER BRAID AND INSULATOR BUTTS FLUSH AGAINST CABLE DIELECTRIC. SLIDE OUTER FERRULE OVER BRAID AND UP AGAINST BODY. MAKE SURE NO SLACK EXISTS IN BRAID. CRIMP FERRULE WITH PROPER CRIMP TOOL.

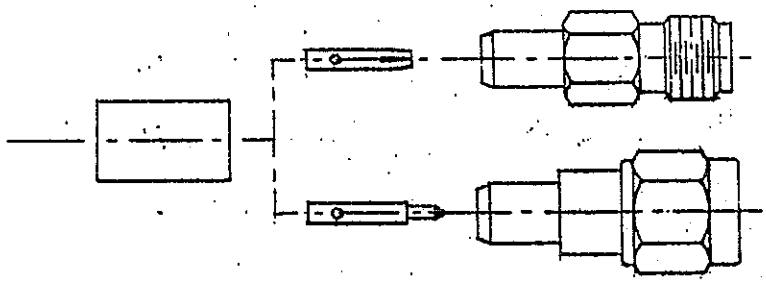


SLIDE HEAT SHRINK TUBING UP AGAINST SHOULDER OF BODY AND APPLY MODERATE HEAT.

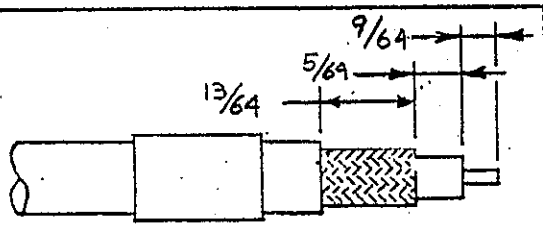
AMPHENOL HEX CRIMP TOOL FOR USE WITH RG/U CABLE	AMPHENOL TOOL Nº	AMPHENOL DIE Nº	DIE CAVITY
55, 58, 141, 142, 223	227-944	227-1221-11	A
180, 195	227-944	227-1221-09	A
316, 174, 179, 187	227-944	227-1221-03	A

SHEET NO. 26 CONTINUED ON FINAL

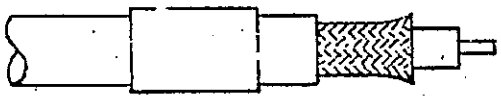
ASSEMBLY PROCEDURE FOR CRIMP TYPE SMA CONNECTOR
NOS. 901-8-5503-2075



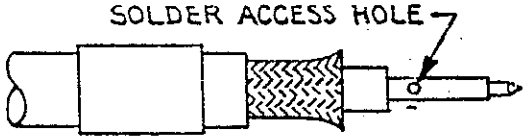
SEE TABLE BELOW FOR PROPER CRIMPING TOOL.



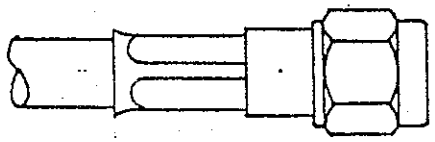
SLIDE OUTER FERRULE ONTO CABLE AS SHOWN. STRIP CABLE JACKET, BRAID AND DIELECTRIC TO DIMENSIONS SHOWN. ALL CUTS ARE TO BE SHARP AND SQUARE. IMPORTANT: DO NOT NICK BRAID, DIELECTRIC OR CENTER CONDUCTOR WHEN CUTTING. TIN CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF CABLE DIELECTRIC.



FLARE END OF CABLE BRAID SLIGHTLY AS SHOWN TO FACILITATE INSERTION ONTO INNER FERRULE. IMPORTANT: DO NOT COMB OUT BRAID.



SOLDER CENTER CONTACT TO CABLE. NOTE: CENTER CONDUCTOR SHOULD BE VISIBLE THROUGH SOFT SOLDER ACCESS HOLE IN CONTACT, PRIOR TO SOLDERING.



INSTALL BODY ONTO CABLE SO THAT FERRULE PORTION SLIDES UNDER BRAID AND INSULATOR BUTTS FLUSH AGAINST CABLE DIELECTRIC. SLIDE OUTER FERRULE OVER BRAID AND UP AGAINST BODY. MAKE SURE NO SLACK EXISTS IN BRAID. CRIMP OVER FERRULE WITH TOOL SPECIFIED BELOW, KEEPING CABLE DIELECTRIC BOTTOMED AGAINST INSULATOR.

HEX CRIMP SIZE	AMPHENOL TOOL No.	AMPHENOL DIE No.	DIE CAVITY DESIGNATION
.128	227-944	227-1221-03	A