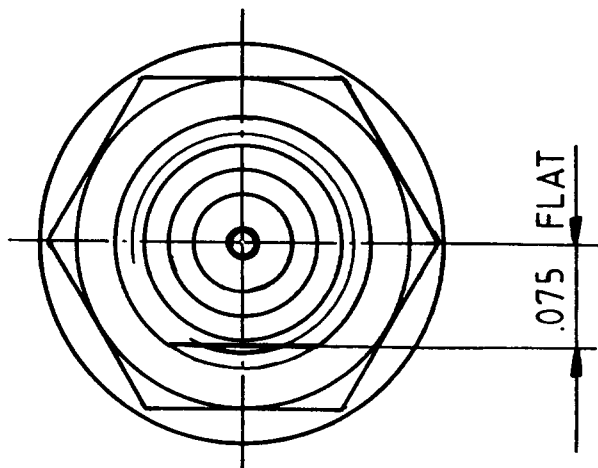
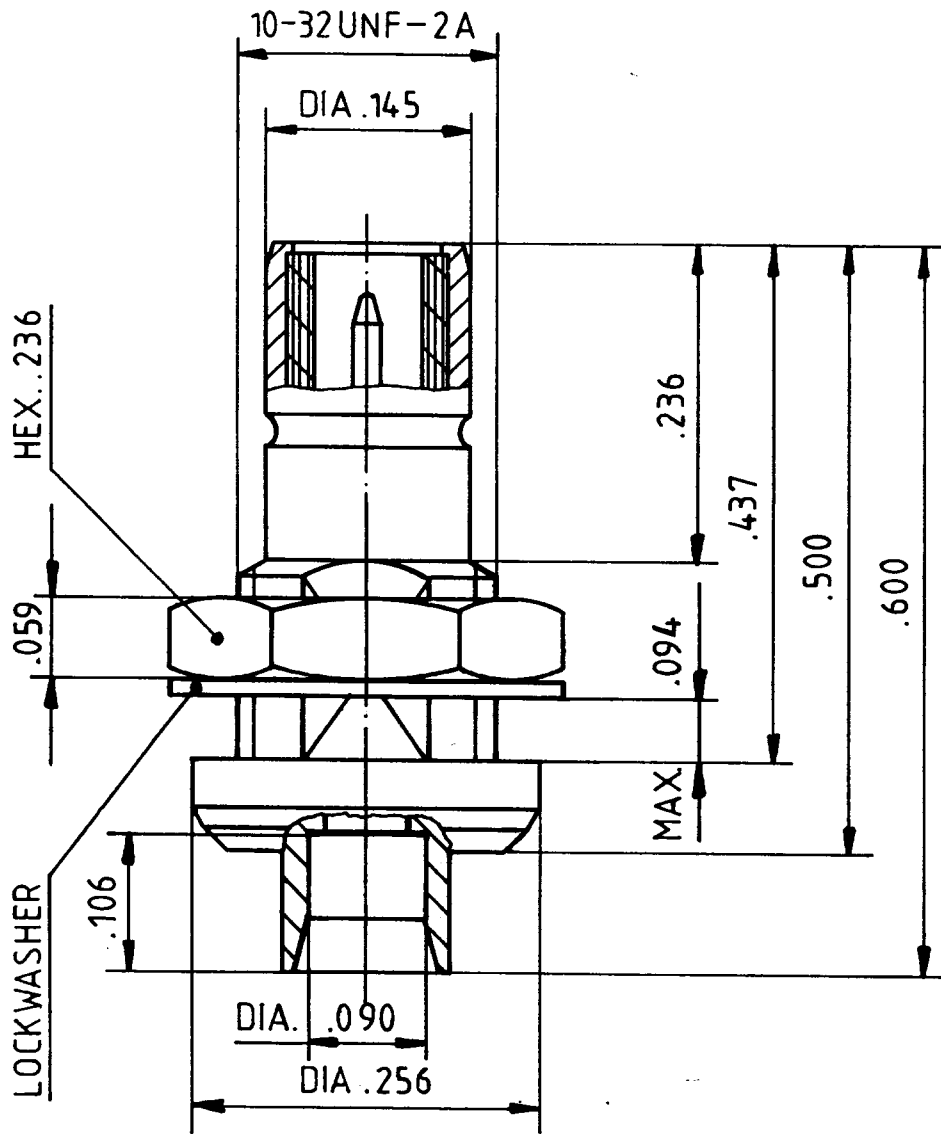


24 SMB 50-2-13c

17.7.89 *fs.*



DIMENSIONS ARE IN INCHES



HUBER + SUHNER AG
9100 Herisau

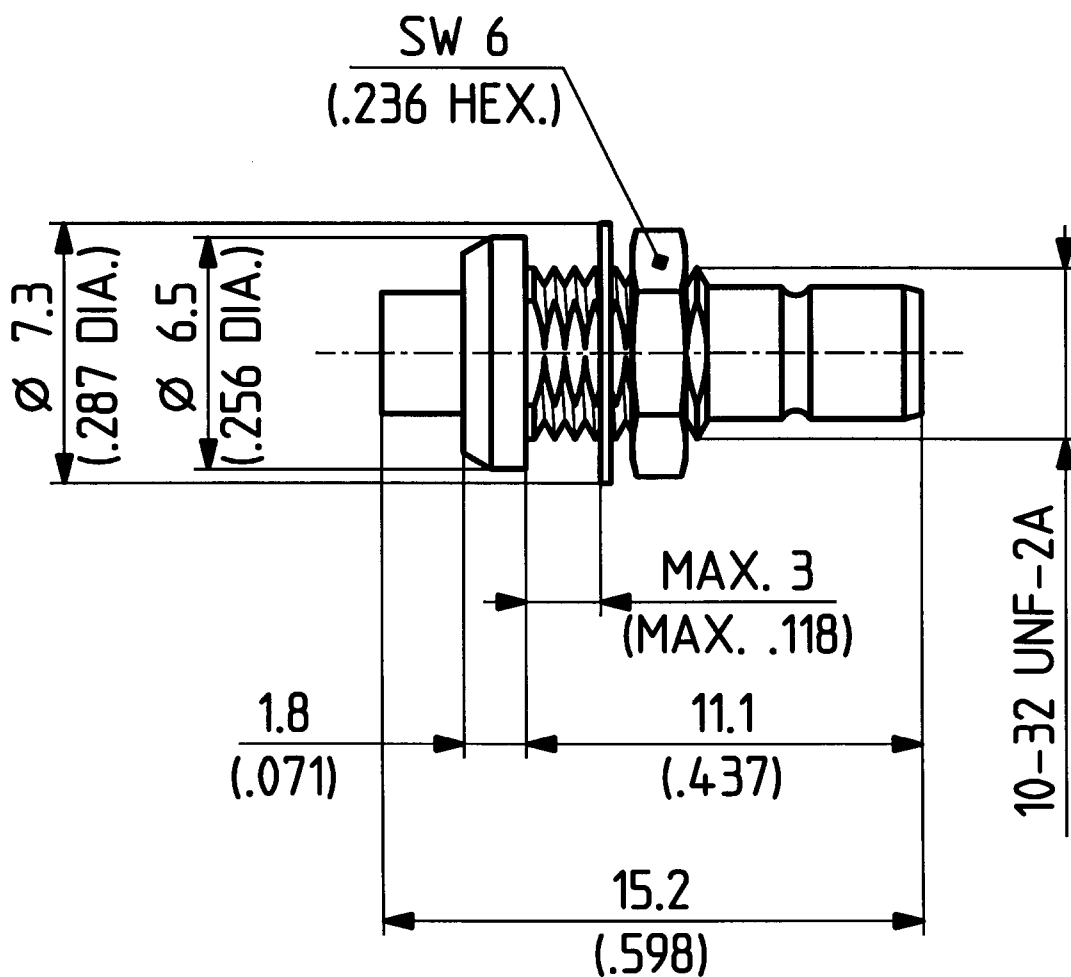
4.13.18041

b

This drawing is copyright. Information contained thereon is supplied in confidence and must not be used for any other purpose than which it was supplied, or be reproduced without written permission of the owners.

24 SMB 50 - 2 - 13c ML 11

	Datum	Kurzz./Visum
Erstellt	21.09.95	023/TuB TUB
Geprueft	29.9.95	F26/M.SQ.
Freigabe	29.9.95	F26/M.SQ.



Diese Zeichnung ist unser geistiges Eigentum und darf ohne unsere ausdrückliche Einwilligung weder kopiert, vervielfältigt, noch Dritten oder Konkurrenzfirmen zugänglich gemacht werden. (Art. 12 B.G.)

M. 5:1



HUBER + SUHNER AG
9100 Herisau

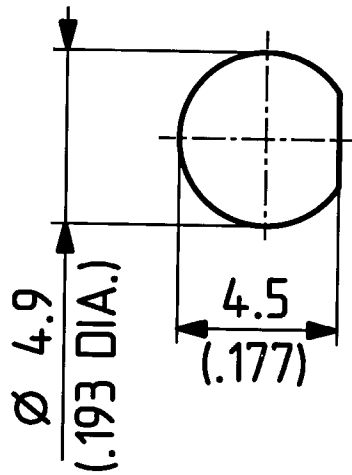
4.13.24121_1

a

This drawing is copyright. Information contained thereon is supplied in confidence and must not be used for any other purpose than which it was supplied, or be reproduced without written permission of the owners.

Montageloch ML 11
Mounting hole ML 11

	Datum	Kurzz./Visum
Erstellt	24.08.95	726/SMA/JS
Geprueft	10.11.95	726 / 3 am
Freigabe	10.11.95	726 / 3 am



Diese Zeichnung ist unser geistiges Eigentum und darf ohne unsere ausdrückliche Einwilligung weder kopiert, vervielfältigt, noch Dritten oder Konkurrenzfirmen zugänglich gemacht werden. (Art. 12 B.G.)

M. 5 : 1



HUBER + SUHNER AG
9100 Herisau

4.13.06535_1

b

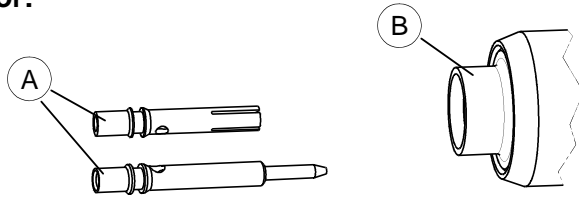
Assembly instruction Series SMB/SMC 0000179074

Old instruction No. 09002



Connector type:	11_SMB-50-2-13, 24_SMB-50-2-13, 24_SMC-50-2-13	Inner conductor contact:	Soldered
Suitable cables:	EZ_86 ; Sucoform_86 ; Multiflex_86	Outer conductor contact:	Soldered

Parts list connector:



For MULTIFLEX cable it is recommended to use a Shrink tube. The Shrink tube is not included in the connector.

Assembly steps:

Picture	Process	Feature / Check	Tools required
<p>EZ cable</p>	<p><u>For EZ and SM cable :</u> Prepare cable according to diagram. Dimension 14 mm applies to SUCOFORM with jacket. Form tip of inner conductor to 90° cone.</p>	<p>Cut cable end perpendicular to cable axis. Do not damage inner conductor, dielectric and braid.</p>	<p>Stripping tool W 157. See instruction sheet DOC-0000199604 for detailed description.</p> <p>Blades 74 Z-0-0-68 Tip trimmer tool W 164</p>
<p>SUCOFORM</p>	<p><u>For Multiflex cable :</u> Dive the on length cuttet cable in flux and tin. Remove cable dielectric and tinned braid according to diagram. Form tip of inner conductor to 90° cone.</p>	<p>The solder must flow at behind for min. 8 mm.</p> <p>If the cable does not fit into the cable entry, use a flat-nose pliers to calibrate the braid.</p>	<p>Blades 74 Z-0-0-68 Flat-nose pliers Tip trimmer tool W 164</p>
<p>MULTIFLEX</p>	<p>Fix cable in soldering fixture W 58 or W 442. Heat inner contact A using a soldering iron and flow small amount of solder into bore. Press inner contact A against soldering gauge W 55 and solder to conductor.</p>	<p>Avoid excessive heat.</p> <p>Clean contact pin A and cable dielectric.</p> <p>Remove soldering gauge W 55.</p>	<p>Soldering iron Solder Soldering gauge : W 55 Soldering fixture : W 58 or W 442 Inserts : W 60</p>
	<p>Push prepared cable into connector body B to the positive stop.</p> <p>Solder connector body B to copper jacket at Z.</p>	<p>After that solder immediately cool down and clean with alcohol.</p>	<p>Alcohol Solder iron Solder</p>
<p>Shrink tube</p>	<p>Slide shrink tube over connector body B and shrink with Hot-air fan.</p> <p>Dimension X max. 1mm.</p>	<p>Avoid excessive heat.</p>	<p>Hot-air fan</p>

The cable assembly of R.F. connectors can only be done by well trained assembly staff and suitable assembly equipment. Huber+Suhr'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.

Revision	D
Date	02.03.12
Initiator	4779/JPE