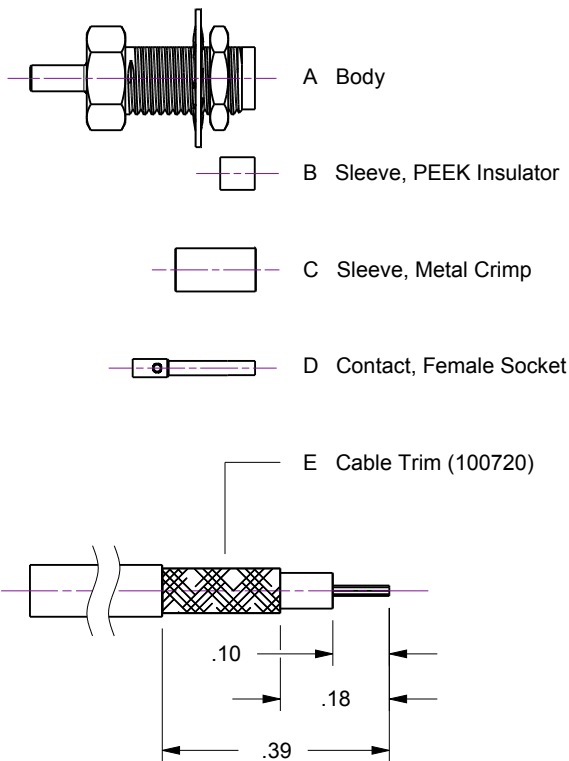


Notes

111028 Parts List



Tools List

All listed wiring tools and supplies are available from our website at...

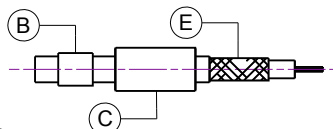
www.accuglassproducts.com

- 110797 Flux
- 110796 Solder, UHV Grade
- 110800 Soldering Iron, High Temperature
- 111029 Crimp Tool, Hex
- 100192 Wire Stripper Tool

110804 Butane Refill, Optional

Wiring Instructions

Step-1
Slide PEEK sleeve (B), and Metal sleeve (C) onto wire (E). Will be moved into final position in Step-9



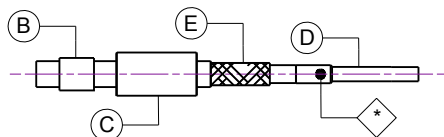
Step-2
Trim / strip coaxial cable (E) to specifications shown at left. Set wire stripper (100192) at No. 40

Step-3
Slide gold socket contact (D) onto stripped wire (E) to check fit, then remove contact.

Caution - Back of contact 'MUST' rest lightly on Kapton insulation... this helps stabilize contact and prevents side-to-side movement.

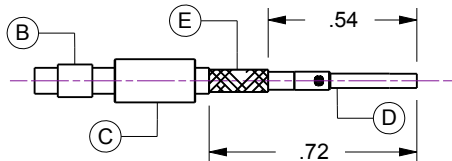
Step-4
Dip exposed wire tip from cable (E) into flux (110797), and then slide contact (D) back onto wire.

Step-5
Solder contact (D) through hole (*) to wire (E) with UHV solder (110796), and high temperature soldering iron (110800).



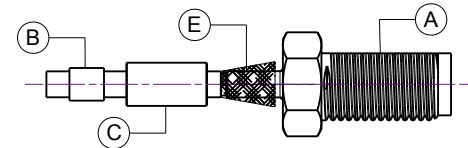
Caution - If solder overfills contact (D) hole, connector wiring cannot proceed. Reheat and scrape off any excess solder with a clean razor blade.

Step-6
After soldering, contact position dimensions will measure close to these specifications.

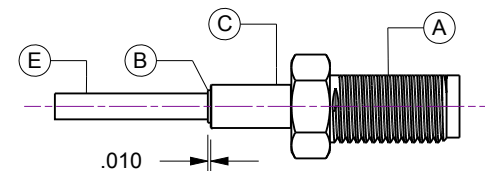


Rev.	Description	Date	Made By	Approval
A	Initial Release			

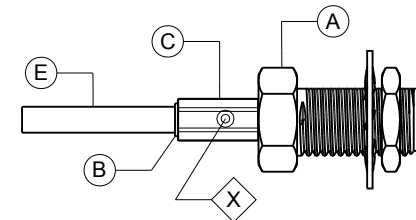
Step-7
Unbraid and flare out coaxial braided shielding, then slide body (A) until it is stopped by the contact socket.



Step-8
Slide metal sleeve (C) up to body (A), covering cable's unbraided shielding... then slide PEEK sleeve (B) under / into metal sleeve (C), leaving about .010 of PEEK exposed.



Step-9
Crimp metal sleeve (C) at location (X) using size .128 Hex crimping tool (111029)



Step-10
Test finished cable / connector assembly for end-to-end electrical continuity on both conductor and shielding paths.

Step-11
Clean finished coaxial cable assembly by immersion in an ultrasonic bath of Isopropyl Alcohol for a minimum of 5 minutes.

UNCONTROLLED WEB DRAWING

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Material See Individual Components	
Tolerances, unless otherwise specified	
.X ± .030	Angles ± 0.5° Finish 63Ra
.XX ± .010	
.XXX ± .005	

Title SMA Bulkhead Jack Wiring Instructions			
Drawn by Date	Ligeti 11/30/2018	No. A111028	Rev. A
Approved			Sheet



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