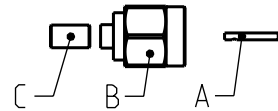


Montageanleitung:

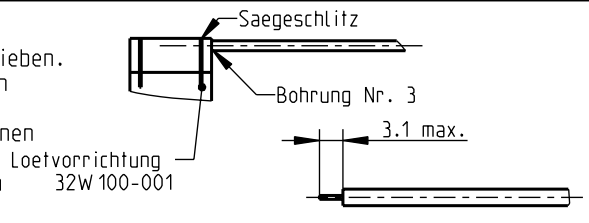
MA_32A6

Serie: SMA

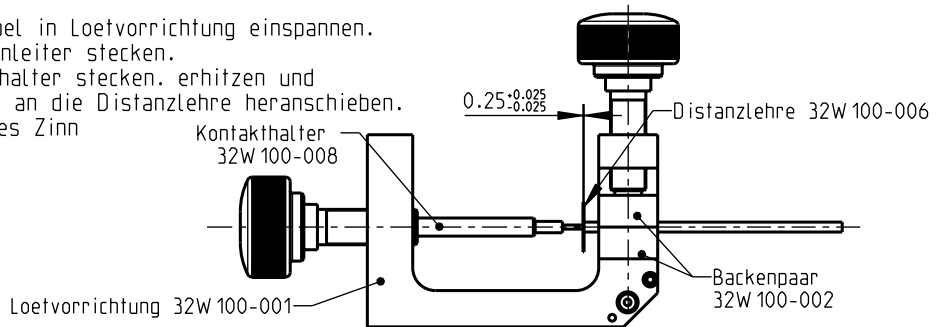
Stecker gerade fuer Kupfermantelkabel
Kabelbefestigung: geloetet



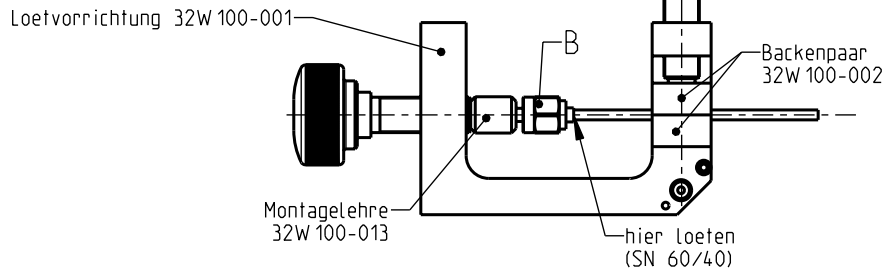
- 1) Kabelende rechtwinklig zur Achse schneiden, Grat entfernen.
- 2) Das Kabelende in die Bohrung Nr. 3 der Loetvorrichtung schieben. Mit einer Juweliersaäge den Kabelaussenleiter, durch Drehen des Kabels durchtrennen.
- 3) Das Kabel aus der Loetvorrichtung entfernen und das Abtrennen des Dielektrikums mit einem geeigneten Messer beenden.
- 4) Nun den Kabelinnenleiter durch Abziehen des abgeschnittenen Kabelaussenleiters und des Dielektrikums freilegen.



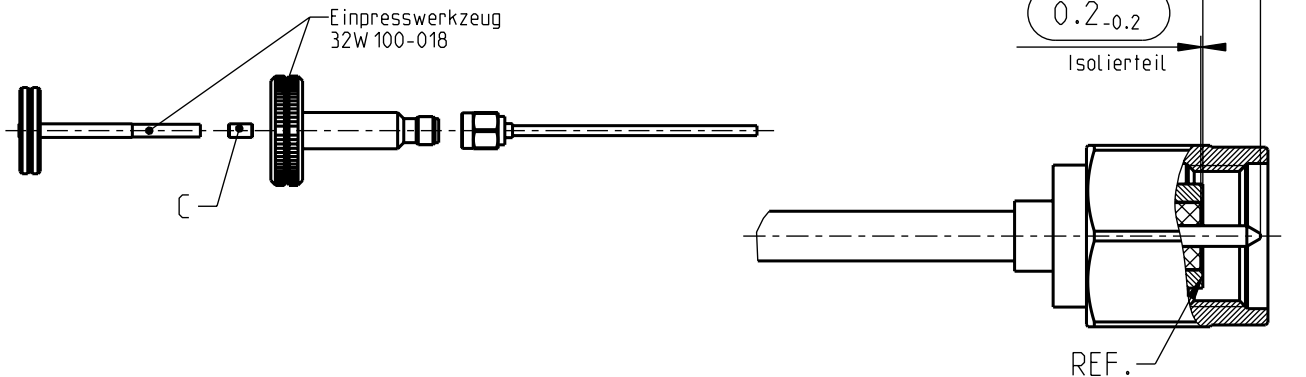
- 5) Kabelinnenleiter verzinnen. Kabel in Loetvorrichtung einspannen.
- 6) Distanzlehre auf den Kabelinnenleiter stecken.
- 7) Innenleiter "A" in den Kontakthalter stecken, erhitzen und ueber den Kabelinnenleiter bis an die Distanzlehre heranschieben.
- 8) Distanzlehre und ueberfluessiges Zinn entfernen.



- 9) Steckerkoerper "B" auf das vormontierte Kabel schieben.
- 10) Montagelehre ueber Innenleiter "A" bis ans Kabel heranschrauben.
- 11) Nun Steckerkoerper "B" ueber die Montagelehre schieben und mit dem Kabel verlöten.



- 12) Einpresswerkzeug bis zum Anschlag in den Steckerkoerper einschrauben.
- 13) Das Isolierteil "C" mit dem Stempel durch das Einpresswerkzeug druecken, bis der Flansch aufliegt.
- 14) Anschlussmasse kontrollieren!



				date	name	scale:	Werkzeuge:		
				drawn	06.07.2015	M_Wallner	1:1	Montagekoffer 32W 100-000
				check	27.07.2015	E_Schwangler	sheet:	Loetausruestung
				appr.	27.07.2015	E_Schwangler	1/2	Juweliersaäge
d00	15-0821	M_Wallner	27.07.2015				
c00	03-0378	J_Gramsamer	11.06.2003				
b00	01-0266	V_Spitzauer	12.06.2001				
rev.	change-no	name	date				

Rosenberger

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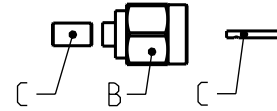
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Version: 2.2

-METRIC-
ISO-Projektion
Methode 1

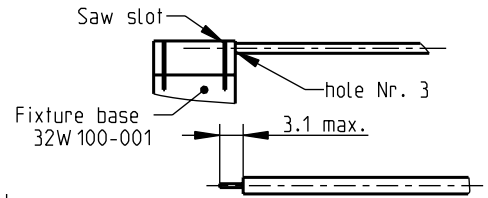
Assembly Instruction: MA_32A6

Series: SMA

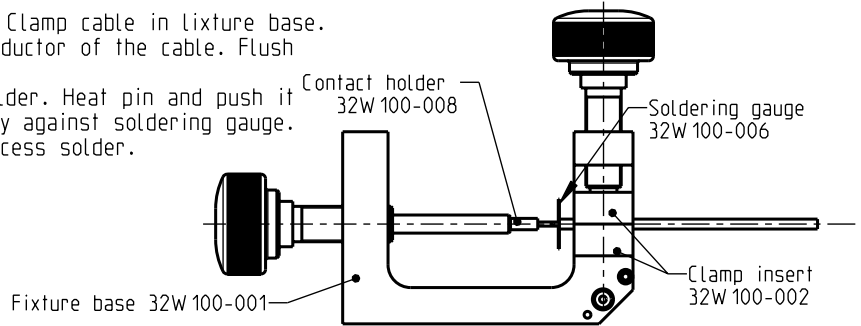
Straight connector for semi-rigid cable
Cable entry: soldered



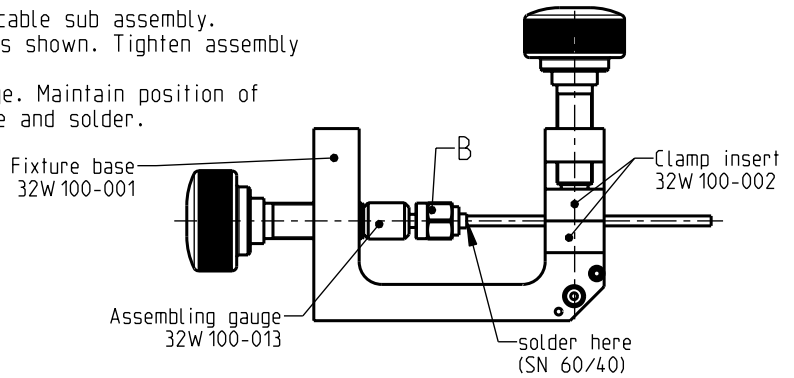
- 1) Trim the cable end square and de-burr.
- 2) Insert cable end into fixture base hole pattern Nr. 3. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.
- 3) Remove cable from fixture base and finish cutting dielectric with cutting blade.
- 4) Bare inner conductor by prying out outer conductor and dielectric from cable. Complete trimming of cable inner conductor to dimension shown.



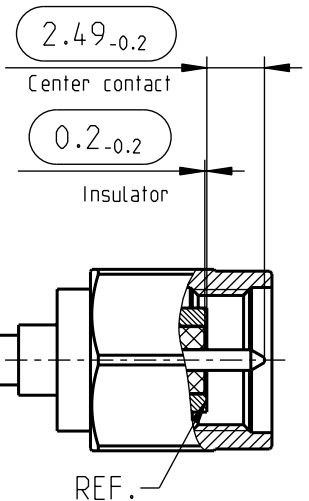
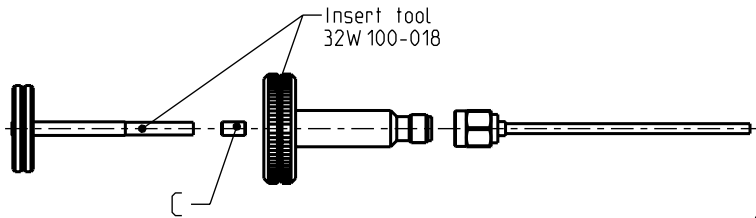
- 5) Tin well inner conductor of cable. Clamp cable in lixture base.
- 6) Place soldering gauge on inner conductor of the cable. Flush with end of outer conductor.
- 7) Place center pin "A" in contact holder. Heat pin and push it over inner conductor to rest firmly against soldering gauge.
- 8) Remove the soldering gauge and excess solder.



- 9) Place connector housing "B" on end of cable sub assembly.
- 10) Place loose assembly in fixture base as shown. Tighten assembly gauge to seat cable firmly.
- 11) Slide housing "B" over assembling gauge. Maintain position of housing firmly against assembling gauge and solder.



- 12) Thread insert tool onto connector housing "B".
- 13) Insert insulator "C" in rear opening of insert tool housing. Place the insert tool plunger into position and press until the flange boots on the tool housing.
- 14) Check the interface dimensions!



			date	name	scale:	Tools:	
			drawn 06.07.2015	M_Wallner	1:1	Tool case 32W 100-000
			check. 27.07.2015	E_Schwangler	sheet:	Soldering equipment
			appr. 27.07.2015	E_Schwangler	2/2	Jeweller saw
d00	15-0821	M_Wallner	27.07.2015			Cutter
c00	03-0378	J_Gramsamer	11.06.2003		
b00	01-0266	V_Spitzauer	12.06.2001		
rev.	change-no	name	date		

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Version: 2.2

ISO-Projektion
Methode 1