

CABLE TYPE	PLUG PART NO.	JACK PART NO.	BULKHEAD JACK PART NO.	CONTACT CERTI-CRIMP® II TOOL 2161720-1 (CRIMP POSITION)	HEX CRIMP TOOL 2161732-1 CRIMP HEIGHT
RG-174, 188, 316	SMA-PS-1F	SMA-JS-1F	SMA-JB-1F	A	3.25 [.128] Hex
RD-316, K02252D	SMA-PS-1B	SMA-PS-1B	SMA-JB-1B	A	3.84 [.151] Hex
RG-58, 141, 142, 223, 400	SMA-PS-1G	SMA-PS-1G	SMA-JB-1G	B	5.41 [.213] Hex

Figure 1

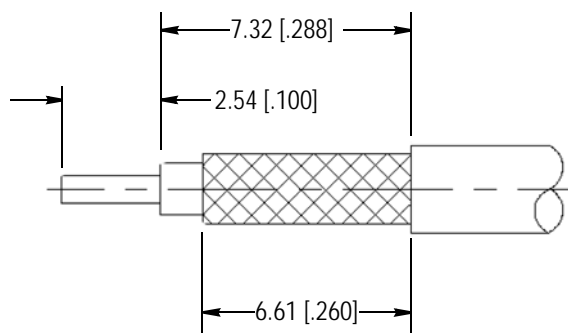
1. INTRODUCTION

This instruction sheet covers KOAXXA Series 50 Ohm Connectors for flexible cable.

NOTE All dimensions are in millimeters [with inch equivalents in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

2. ASSEMBLY PROCEDURE

1. Select the appropriate cable type, connector, and crimp tool given in the table in Figure 1.
2. Strip the cable to the dimensions provided in Figure 2.



Recommended Strip Lengths

Figure 2

3. CENTER CONTACT ATTACHMENT

The KOAXXA center contacts can either be soldered or crimped for applications specified in Figure 1. For crimping, refer to Section 4, CONTACT CRIMPING PROCEDURE.

NOTE For solid center conductors or stranded wire sizes less than 24 AWG, soldering is the preferred method as crimping may produce un-acceptable crimp quality.

1. Pre-tin the stranded center conductor.
2. Position the contact and the center conductor with the contact seated against the coaxial dielectric and centered within the crimp barrel. If a dielectric disk is supplied with the kit, the disk is placed over the center conductor first and the contact then seats firmly against the disk to prevent electrical shorting.
3. Apply solder to the crimp barrel, ensuring proper wetting and filling of the entire barrel.

4. CONTACT CRIMPING PROCEDURE

1. Hold the tool so that the FRONT side is facing you.
2. Ensure that the tool ratchet is released by squeezing the tool handles and allowing them to open FULLY.
3. Be sure the flip locator is in the load position (see Figure 3).

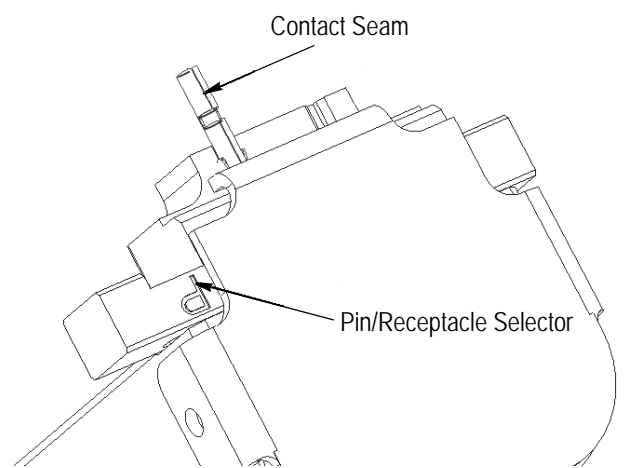


Figure 3

4. Slide the contact indicator to either “R” for socket or “P” for pin contacts.

5. Hold the contact by the wire barrel and push the contact retaining plate while inserting the contact receptacle into the flip locator so that the top of the contact (opening for the wire) faces away from the tool with the contact seam towards the retaining plate.

NOTE


Be sure to insert the contact in the proper nest according to the crimp position on the front of the tool.

6. Once the contact is loaded, release the contact retaining plate and flip the locator up 90°. See Figure 4.

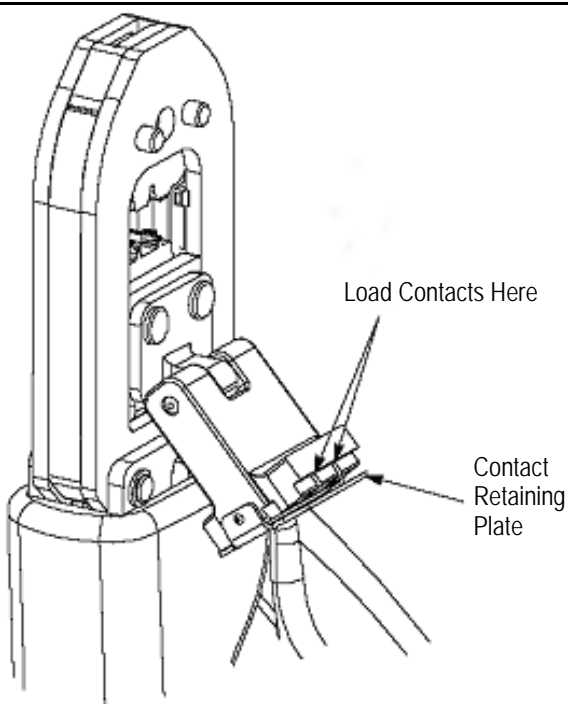


Figure 4

7. Squeeze the tool handles together until the positioner anvil starts entry into the crimp transition (usually two ratchet clicks). Do NOT deform the wire barrel.

8. Insert the stripped wire into the wire barrel of the contact until the insulation butts against the insulation stop.

9. Holding the wire in place, crimp contact to the wire by squeezing the tool handles together until the ratchet releases.

10. Allow tool handles to open FULLY. Depress the contact retaining plate and remove the contact.

5. ASSEMBLY AND BRAID CRIMP

1. Insert the crimp ferrule over the coax jacket and flare the cable braid.

2. Insert the crimped contact into the connector assembly, observing the insertion depth on the interface end. The socket contact should be inserted until it just contacts the inside of the dielectric. The pin contact should be inserted to a final height of 1.09 mm [.075 in.].

3. Slide the ferrule over the cable braid making sure the braid is positioned over the connector barrel until it rests against the connector housing as shown in Figure 5.

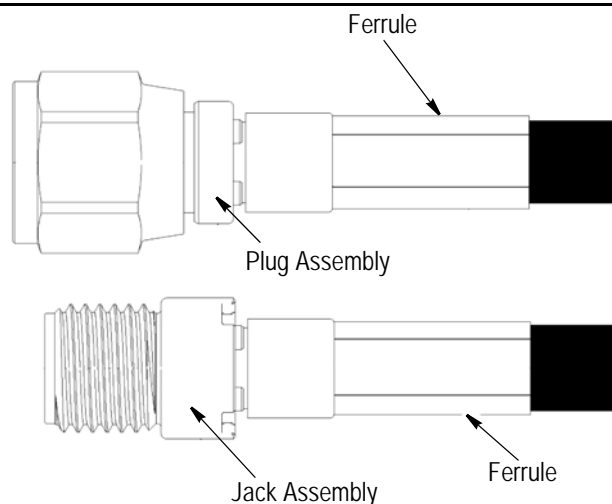


Figure 5

4. Crimp using the proper crimp height for the connector and coax configuration as provided in the table in Figure 1.

6. REVISION SUMMARY

- Initial release of document