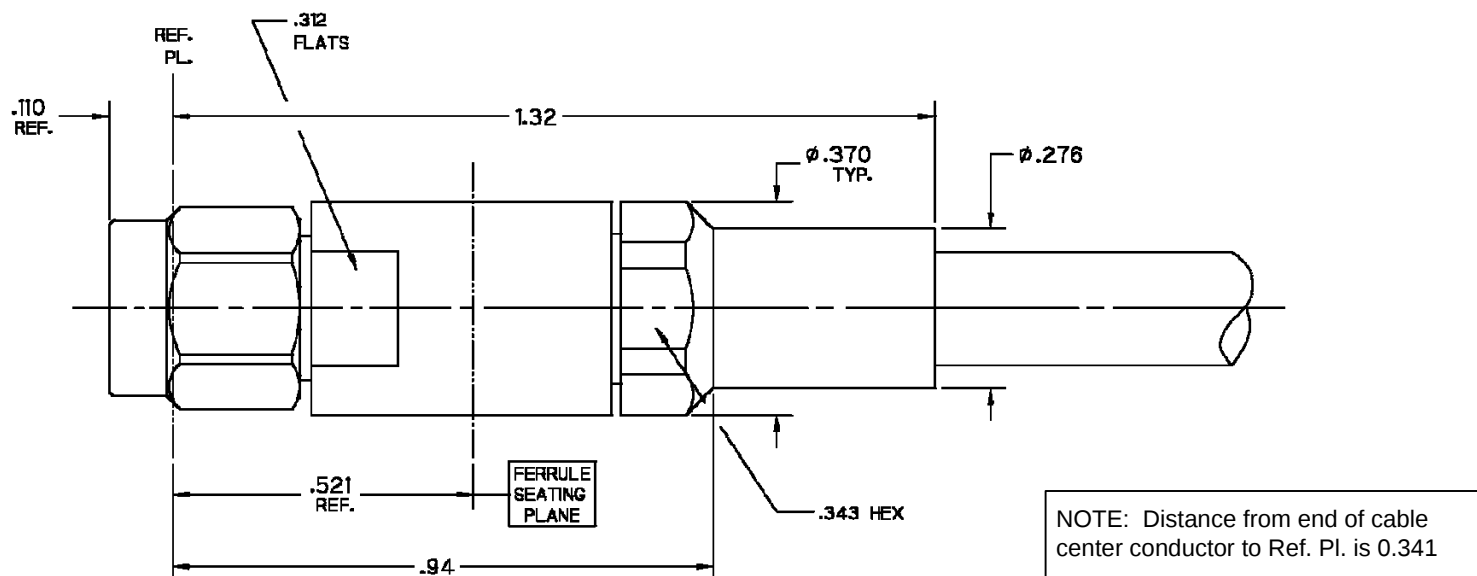


## SMA Plug, Solder Clamp for Harbour LL142 Cable



### NOTES:

#### 1.0 Materials

- 1.1 Body, Coupling, and Clamp Nuts: Steel. Corrosion Resistant per ASTM-A582. UNS No. S30300.
- 1.2 Center Conductor: Beryllium Copper per ASTM-B196. UNS C17300.
- 1.3 Solder Ferrule: Brass per ASTM-B16. UNS C36000.
- 1.4 Lock Ring: Beryllium Copper per ASTM-B197. UNS C17200.
- 1.5 Gasket: Silicone Rubber per A-A-59588.
- 1.6 Insulators: PTFE Fluorocarbon per ASTM-D1710.

#### 2.0 Finishes

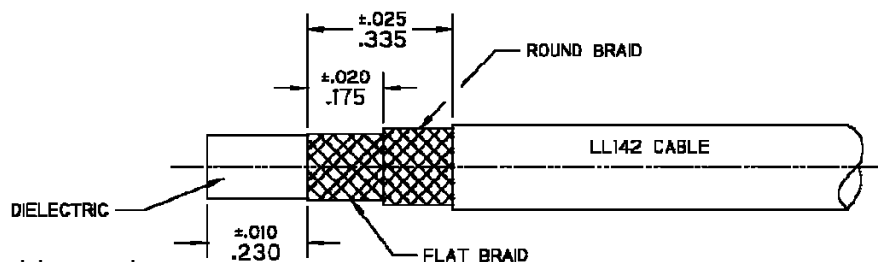
- 2.1 Center Contact and Solder Ferrule: Gold Plate per ASTM-B488 50 Microinches Min. thickness over Electrolytic Nickel Plate per ASTM-B689 50 Microinches Min. thickness.
- 2.2 Body, Coupling, and Clamp Nuts: Passivated per SAE-AMS-2700.
- 2.3 Gasket, Lock Ring, and Dielectrics: None.

- 3.0 Interface: Type SMA Plug per Crystek Interface Specification CC-SMAP (Meets MIL-STD-348. Fig 310-1)

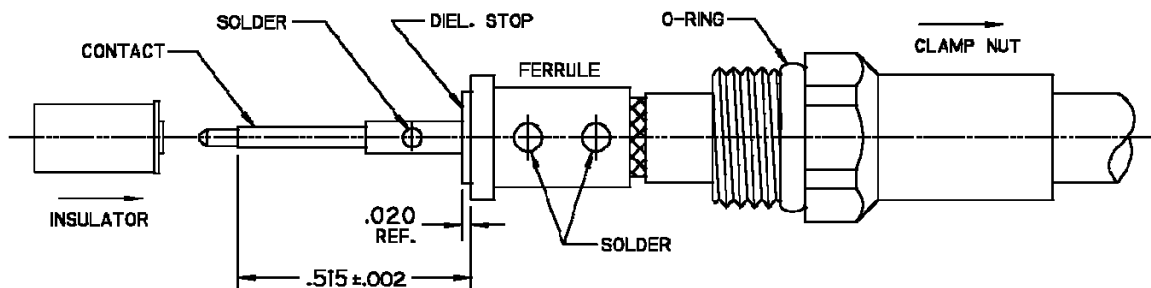




# SMA Plug, Solder Clamp for Harbour LL142 Cable

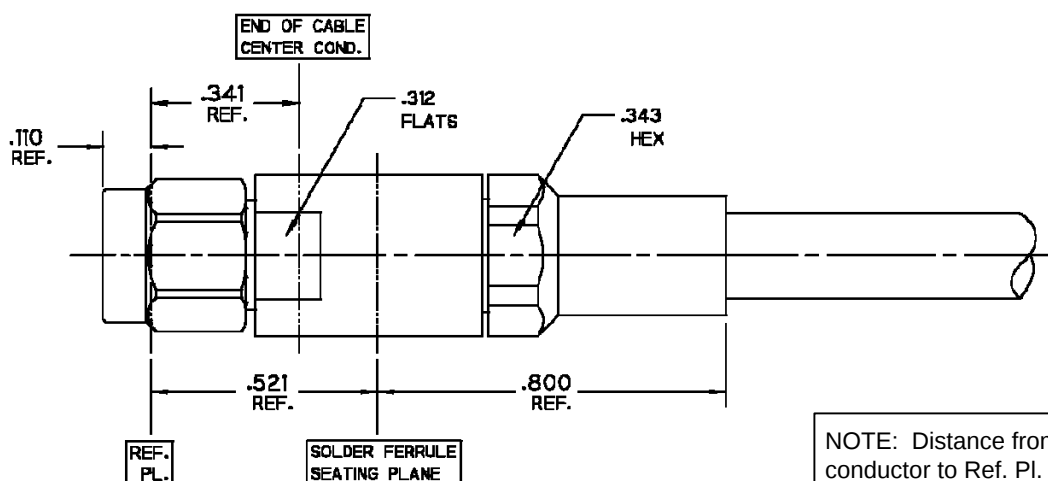


Step 1 1.1 Trim Cable as shown.



- 2.1 Slide clamp nut over cable in orientation shown.
- 2.2 Insert cable into solder ferrule until inner braid seats and solder to braids where shown.
- 2.3 Trim cable dielectric flush with face of ferrule.
- 2.4 Slide dielectric stop over cable center conductor and solder contact flush to stop to dimension shown.
- 2.5 Slide insulator onto contact against shoulder.

Step 2



NOTE: Distance from end of cable center conductor to Ref. Pl. is 0.341 (Ref)

- 3.1 Insert cable/contact sub-assembly into connector until seated and tighten clamp nut to 25-35 in-lbs.

Step 3

## Product Control:

|                      |           |               |               |
|----------------------|-----------|---------------|---------------|
| Crystek Part Number: | CS-SM-MHA | Release Date: | 04-Jan-11     |
| Revision Level:      | A         | Responsible:  | K. Piotrowicz |

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