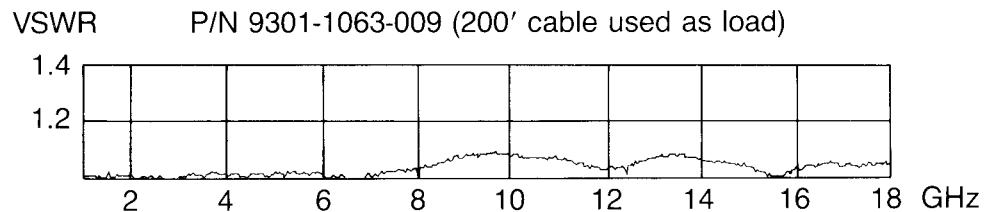
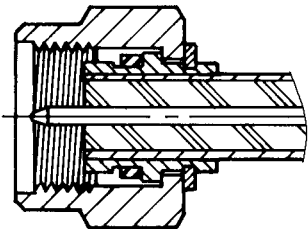


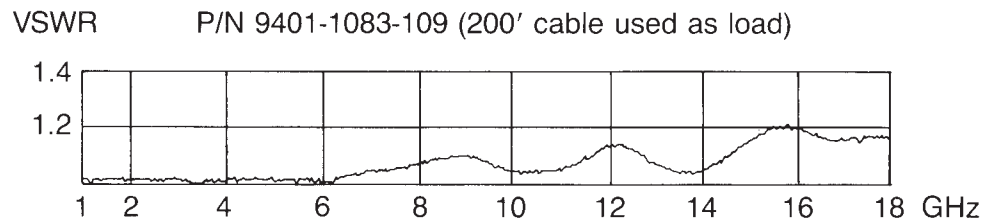
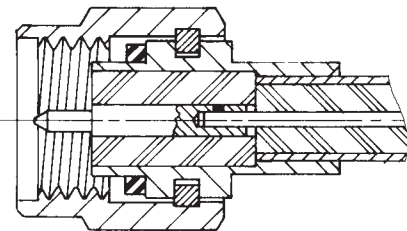
# SMA Cable Attachment Methods

## Semi-Rigid Cable

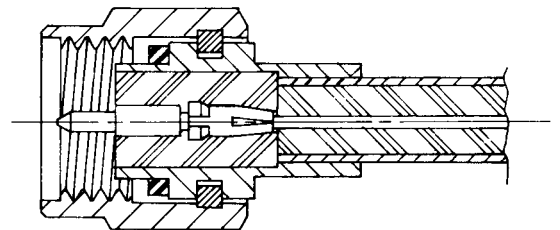
**Direct Solder (cable center conductor used as contact):** This type of cable attachment ensures the best possible electrical performance because there are no discontinuities introduced by contact geometry changes. It is best used in applications **not** requiring frequent mating and unmating, because the pointed center conductor and exposed cable jacket will shed metal chips when mated with SMA female connectors.



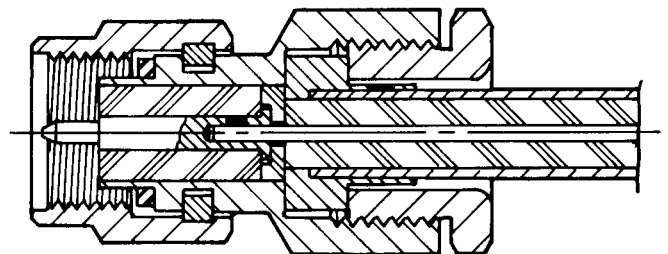
**Direct Solder (with contact and insulator):** Although this cable attachment exhibits higher VSWR than types without contacts, it provides an outer conductor that does not have the copper cable jacket exposed to mating forces. This, along with the beryllium-copper contact, ensures clean interfaces through many mating cycles.



**Direct Solder (with captive contact):** These connectors have electrical performance similar to types with non-captive contacts, but with faster and easier cable assembly. The cable is simply stripped and inserted into the connector, and the cable jacket soldered to the connector. The proper contact gap is automatically maintained, and no contact soldering is required.



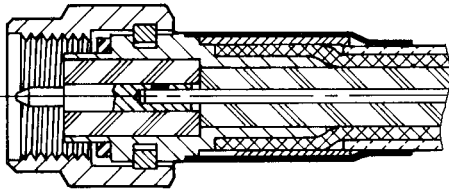
**Solder-clamp:** This attachment is most useful for right angle plugs and bulkhead jacks. After the connector is assembled to the cable jacket, it can be repositioned relative to the cable by loosening the clamp nut. Electrical performance is similar to direct-solder plugs with contacts.



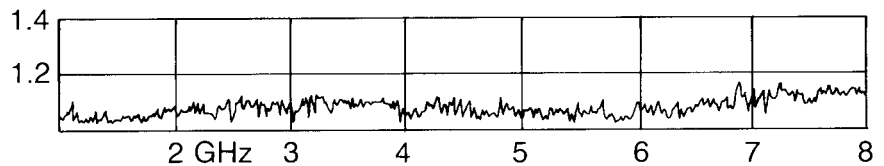
# SMA Cable Attachment Methods

## Flexible Cable

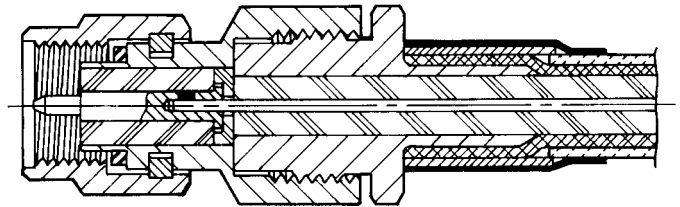
**Crimp (non-captive contact):** This attachment method provides the best possible electrical performance, and the fastest assembly. **Solder type** connectors for flexible cable have the same construction, but add a hole in the side of the crimp sleeve for soldering the cable braid to the connector. We do **not** recommend the use of solder type connectors with flexible cable—the heat from soldering may damage the cable dielectric.



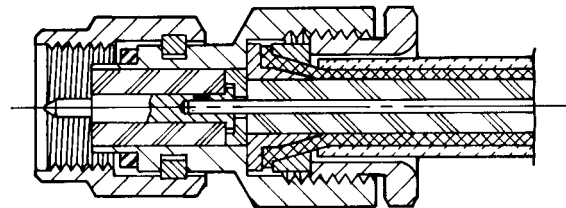
VSWR P/N 9001-1023-001 (200' RG-223 used as load)



**Crimp (captive contact):** This attachment method mechanically captivates the center contact to eliminate movement during cable flexure or thermal stress.

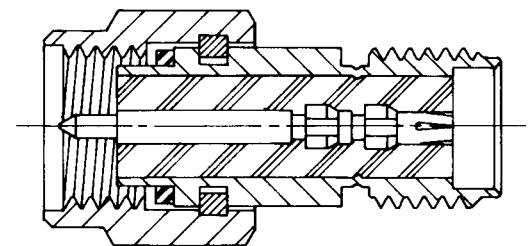


**Clamp (captive contact):** These connectors can be assembled without special tooling, and are field replaceable.

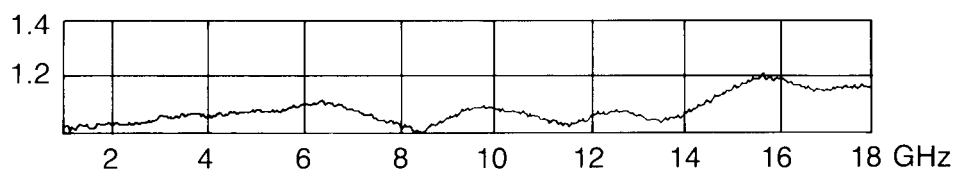


## SMA Captivation

All AEP SMA receptacles and adapters use our unique mechanical captivation for contacts and insulators. This method provides retention strength to meet MIL-PRF-39012 requirements, and eliminates RF leakage from epoxy fill holes. The contact barbs and body staking are designed and located to provide electrical performance that equals or exceeds epoxy-captivated types.



VSWR P/N 5916-1103-603 terminated with 9301-1063-009 on 200' .141 semi-rigid.



APPLIED ENGINEERING PRODUCTS

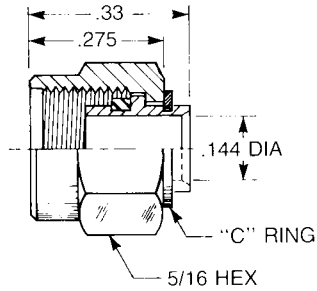
(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Cable Plugs for Semi-Rigid Cable

Click on part number to go directly to cable assembly instructions

## Straight Plugs



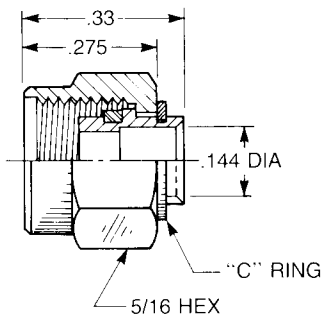
- Direct solder attachment
- Retractable coupling nut
- Cable center conductor used as contact

For .141" semi-rigid:

**9301-1063-009** (Gold plated)

**9301-7063-009** (Nickel plated)

QPL version available (M39012/92)



- Direct solder attachment
- Retractable coupling nut
- Cable center conductor used as contact
- Stepped body for use in applications requiring frequent mating and unmating

For .141" semi rigid:

**9301-1063-109** (Gold plated)

**9301-7063-109** (Nickel plated)

- Direct solder attachment
- Provided with contact and insulator
- Noncaptive contact

For .085" semi-rigid (A = .089):

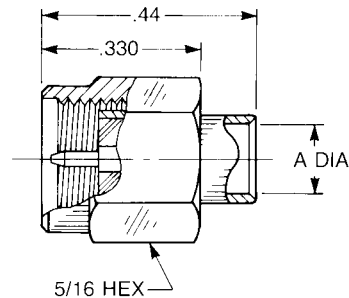
**9401-1083-010** (Gold plated)

**9401-7083-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9401-1083-109** (Gold plated)

**9401-7083-109** (Nickel plated)



- Direct solder attachment
- Provided with contact and insulator
- Captive contact for one-step cable assembly

For .085" semi-rigid (A = .089):

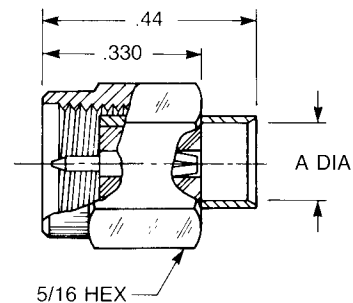
**9401-1583-010** (Gold plated)

**9401-7583-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9401-1583-109** (Gold plated)

**9401-7583-109** (Nickel plated)



Continued on next page



APPLIED ENGINEERING PRODUCTS

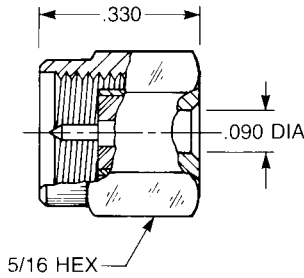
(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Cable Plugs for Semi-Rigid Cable

Click on part number to go directly to cable assembly instructions

## Straight Plugs



- Direct solder attachment
- Provided with contact and insulator
- Noncaptive contact
- Short body length allows very tight cable bend in dense packaging applications

For .085" semi-rigid:

**9401-1083-210** (Gold plated)

**9401-7083-210** (Nickel plated)

- Solder-clamp attachment
- Captive contact

For .085" semi-rigid:

**9501-1593-010** (Gold plated)

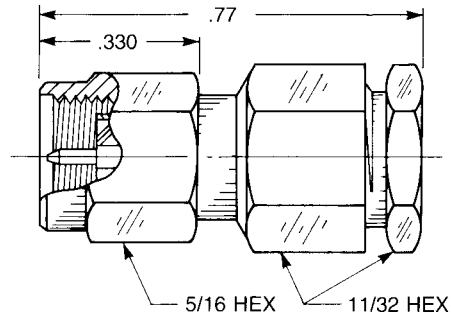
**9501-9593-010** (Passivated)

For .141" semi-rigid:

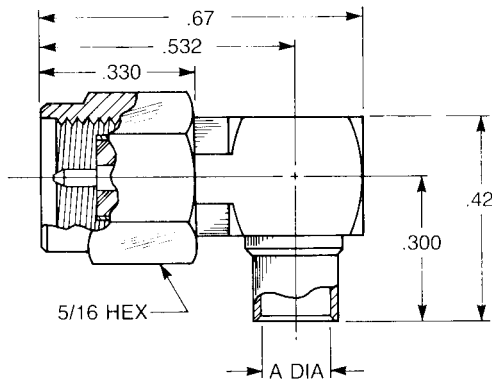
**9501-1593-009** (Gold plated)

**9501-9593-009** (Passivated)

QPL version available (M39012/79)



## Right Angle Plugs



- Direct solder attachment

For .085" semi-rigid (A = .089):

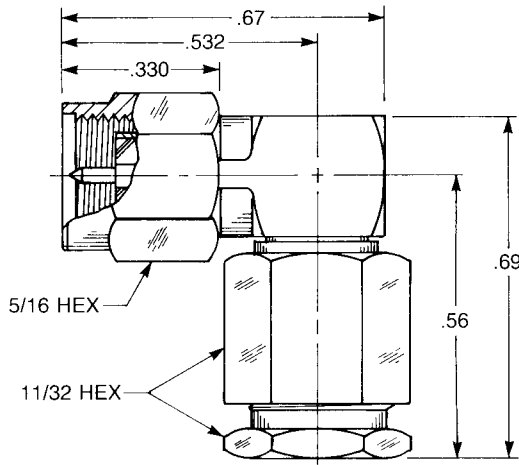
**9443-1563-010** (Gold plated)

**9443-7563-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9443-1563-009** (Gold plated)

**9443-7563-009** (Nickel plated)



- Solder-clamp attachment

For .085" semi-rigid:

**9543-1593-010** (Gold plated)

**9543-9593-010** (Passivated)

For .141" semi-rigid:

**9543-1593-009** (Gold plated)

**9543-9593-009** (Passivated)



APPLIED ENGINEERING PRODUCTS

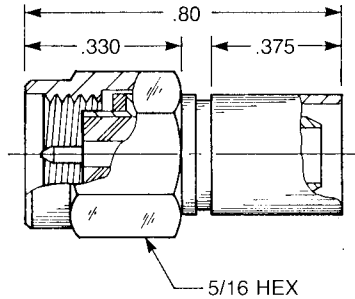
(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Cable Plugs for Flexible Cable

Click on part number to go directly to cable assembly instructions

## Straight Plugs



### Straight Plug

- Noncaptive contact

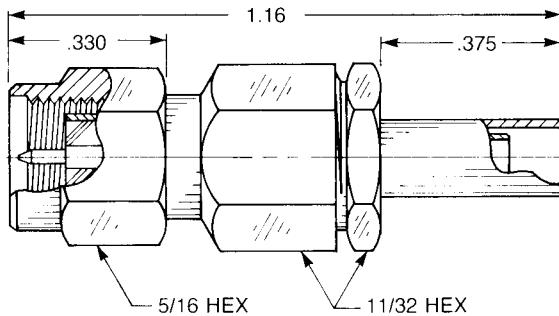
Crimp type:

**9001-1023-0XX** (Gold plated)

**9001-9023-0XX** (Passivated)

Solder type:

**9001-1033-0XX** (Gold plated)



### Straight Plug

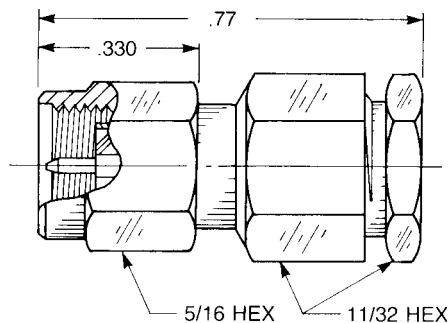
- Captive contact

Crimp type:

**9101-1573-0XX** (Gold plated)

**9101-9573-0XX** (Passivated)

QPL version available (M39012/55)



### Straight Plug

- Captive contact

Clamp type:

**9201-1553-0XX** (Gold plated)

**9201-9553-0XX** (Passivated)

QPL version available (M39012/55)

Substitute the appropriate cable group number for "XX" when ordering:

GROUP	CABLE TYPES	GROUP	CABLE TYPES	GROUP	CABLE TYPES
01	RG142, RG223, M17/60, M17/84, M17/158	04	RG180, RG195, M17/95	06	RG58, RG141, RG303, M17/111, M17/155
02	RG178, RG196, M17/93, M17/169	05	RG178DS, RG196DS	19	RG174DS, RG316DS, M17/151, M17/152, Times RD-316
03	RG174, RG179, RG316, M17/113, M17/119, M17/172, M17/189				



APPLIED ENGINEERING PRODUCTS

(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Cable Plugs for Flexible Cable

Click on part number to go directly to cable assembly instructions

## Right Angle Plugs

### Right Angle Plug

- Captive contact

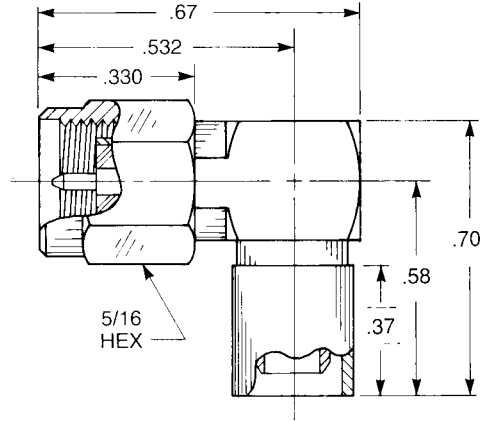
Crimp type:

**9043-1523-0XX** (Gold plated)

**9043-9523-0XX** (Passivated)

Solder type:

**9043-1533-0XX** (Gold plated)



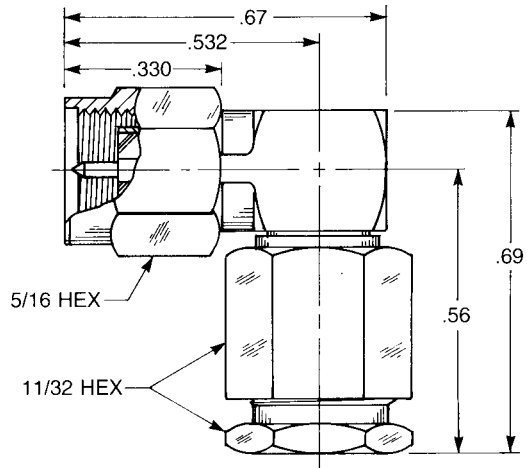
### Right Angle Plug

- Captive contact

Clamp type:

**9243-1553-0XX** (Gold plated)

**9243-9553-0XX** (Passivated)



Substitute the appropriate cable group number for "XX" when ordering:

GROUP	CABLE TYPES	GROUP	CABLE TYPES	GROUP	CABLE TYPES
01	RG142, RG223, M17/60, M17/84, M17/158	04	RG180, RG195, M17/95	06	RG58, RG141, RG303, M17/111, M17/155
02	RG178, RG196, M17/93, M17/169	05	RG178DS, RG196DS	19	RG174DS, RG316DS, M17/151, M17/152, Times RD-316
03	RG174, RG179, RG316, M17/113, M17/119, M17/172, M17/189				



APPLIED ENGINEERING PRODUCTS

(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Cable Jacks for Semi-Rigid Cable

Click on part number to go directly to cable assembly instructions

## Straight Jacks

### Straight Jack

- Direct solder attachment
- Noncaptive contact

For .085" semi-rigid (A = .089):

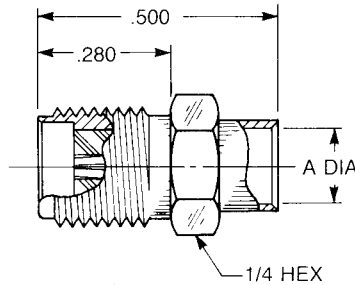
**9402-1083-010** (Gold plated)

**9402-7083-010** (Nickel plated)

For .141" semi rigid (A = .144):

**9402-1083-009** (Gold plated)

**9402-7083-009** (Nickel plated)



### Straight Jack

- Direct solder attachment
- Captive contact for one-step cable assembly

For .085" semi-rigid (A = .089):

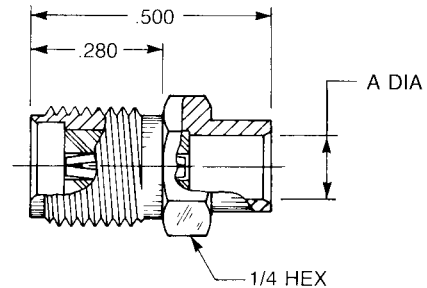
**9402-1583-010** (Gold plated)

**9402-7583-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9402-1583-009** (Gold plated)

**9402-7583-009** (Nickel plated)



### Straight Jack

- Solder-clamp attachment
- Captive contact

For .085" semi-rigid:

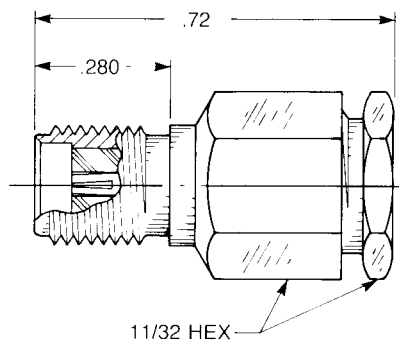
**9502-1593-010** (Gold plated)

**9502-9593-010** (Passivated)

For .141" semi-rigid:

**9502-1593-009** (Gold plated)

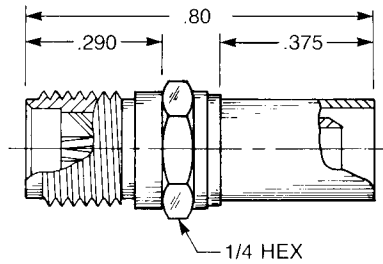
**9502-9593-009** (Passivated)



# SMA Cable Jacks for Flexible Cable

Click on part number to go directly to cable assembly instructions

## Straight Jacks



### Straight Jack

- Noncaptive contact

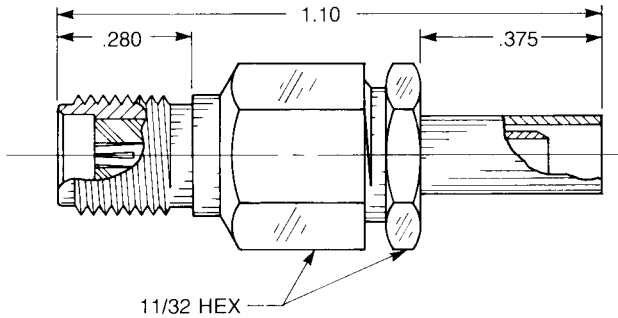
Crimp type:

**9002-1023-0XX** (Gold plated)

**9002-9023-0XX** (Passivated)

Solder type:

**9002-1033-0XX** (Gold plated)



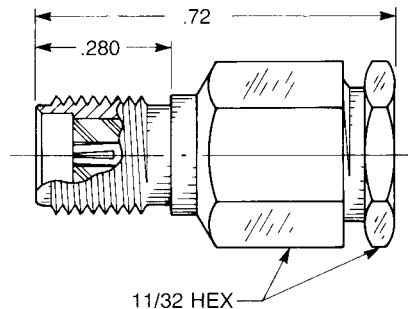
### Straight Jack

- Captive contact

Crimp type:

**9102-1573-0XX** (Gold plated)

**9102-9573-0XX** (Passivated)



### Straight Jack

- Captive contact

Clamp type:

**9202-1553-0XX** (Gold plated)

**9202-9553-0XX** (Passivated)

Substitute the appropriate cable group number for "XX" when ordering:

GROUP	CABLE TYPES	GROUP	CABLE TYPES	GROUP	CABLE TYPES
01	RG142, RG223, M17/60, M17/84, M17/158	04	RG180, RG195, M17/95	06	RG58, RG141, RG303, M17/111, M17/155
02	RG178, RG196, M17/93, M17/169	05	RG178DS, RG196DS	19	RG174DS, RG316DS, M17/151, M17/152, Times RD-316
03	RG174, RG179, RG316, M17/113, M17/119, M17/172, M17/189				



APPLIED ENGINEERING PRODUCTS

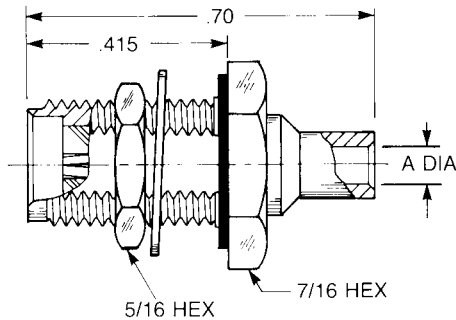
(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Bulkhead Jacks for Semi-Rigid Cable

Click on part number to go directly to cable assembly instructions

## Straight Jacks



- Direct solder attachment
- With mounting gasket
- Noncaptive contact

For .085" semi-rigid (A = .089)

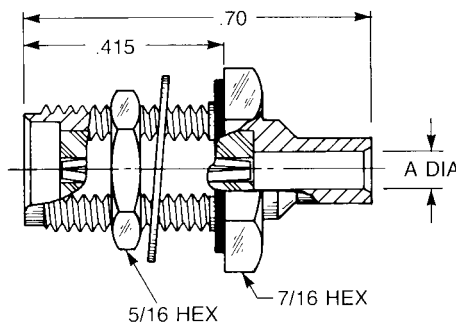
**9453-1083-010** (Gold plated)

**9453-7083-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9453-1083-009** (Gold plated)

**9453-7083-009** (Nickel plated)



- Direct solder attachment
- With mounting gasket
- Captive contact for one-step cable assembly

For .085" semi-rigid (A = .089):

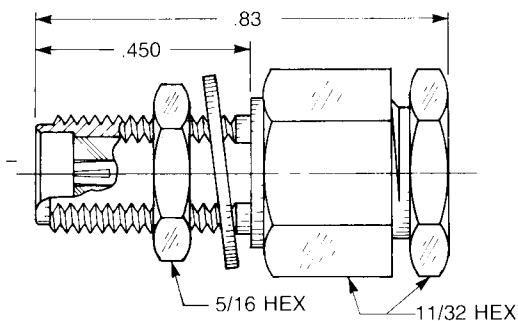
**9453-1583-010** (Gold plated)

**9453-7583-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9453-1583-009** (Gold plated)

**9453-7583-009** (Nickel plated)



- Solder-clamp attachment
- Captive contact

For .085" semi-rigid:

**9530-1593-010** (Gold plated)

**9530-9593-010** (Passivated)

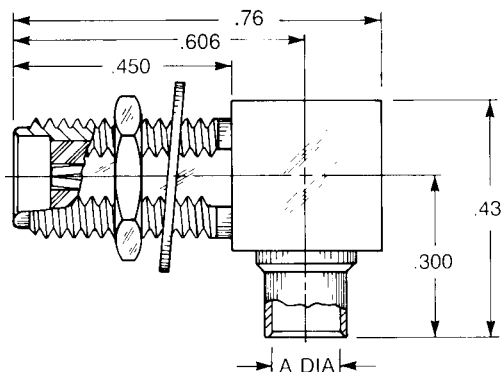
For .141" semi-rigid:

**9530-1593-009** (Gold plated)

**9530-9593-009** (Passivated)

QPL version available (M39012/83)

## Right Angle Jack



- Direct solder attachment

For .085" semi-rigid (A = .089):

**9613-1563-010** (Gold plated)

**9613-7563-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9613-1563-009** (Gold plated)

**9613-7563-009** (Nickel plated)



APPLIED ENGINEERING PRODUCTS

(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Bulkhead Jacks for Flexible Cable

Click on part number to go directly to cable assembly instructions

## Straight Jacks

### Straight Bulkhead Jack

- Noncaptive contact

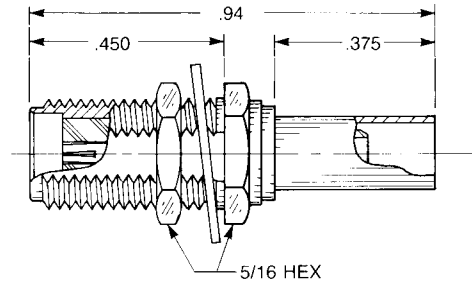
Crimp type:

9030-1023-0XX (Gold plated)

9030-9023-0XX (Passivated)

Solder type:

9030-1033-0XX (Gold plated)



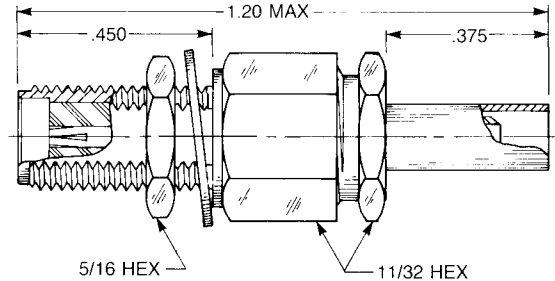
### Straight Bulkhead Jack

- Captive contact

Crimp type:

9130-1573-0XX (Gold plated)

9130-9573-0XX (Passivated)



### Straight Bulkhead Jack

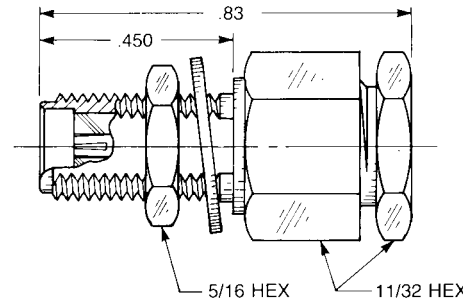
- Captive contact

Clamp type:

9230-1553-0XX (Gold plated)

9230-9553-0XX (Passivated)

QPL version available (M39012/59)



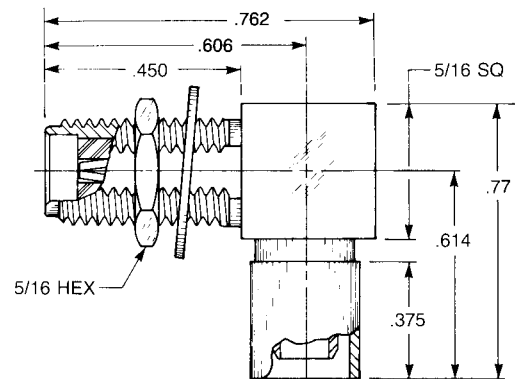
## Right Angle Jack

### Right Angle Bulkhead Jack

Crimp type:

9613-1523-0XX (Gold plated)

9613-9523-0XX (Passivated)



Substitute the appropriate cable group number for "XX" when ordering:

GROUP	CABLE TYPES	GROUP	CABLE TYPES	GROUP	CABLE TYPES
01	RG142, RG223, M17/60, M17/84, M17/158	04	RG180, RG195, M17/95	06	RG58, RG141, RG303, M17/111, M17/155
02	RG178, RG196, M17/93, M17/169	05	RG178DS, RG196DS	19	RG174DS, RG316DS, M17/151, M17/152, Times RD-316
03	RG174, RG179, RG316, M17/113, M17/119, M17/172, M17/189				



APPLIED ENGINEERING PRODUCTS

(203) 776-2813 • FAX (203) 776-8294

www.aepconnectors.com • aepsales@aepconnectors.com

# SMA Panel Jacks for Semi-Rigid Cable

Click on part number to go directly to cable assembly instructions

## Straight Jacks

- Direct solder attachment
- Square flange
- Noncaptive contact

For .085" semi-rigid (A = .089):

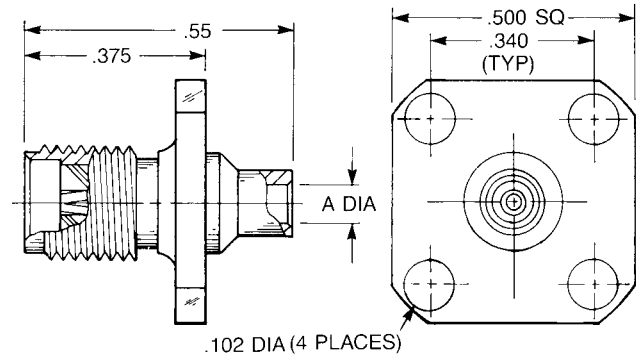
**9431-1083-010** (Gold plated)

**9431-7083-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9431-1083-009** (Gold plated)

**9431-7083-009** (Nickel plated)



- Direct solder attachment
- Square flange
- Captive contact for one-step cable assembly

For .085" semi-rigid (A = .089):

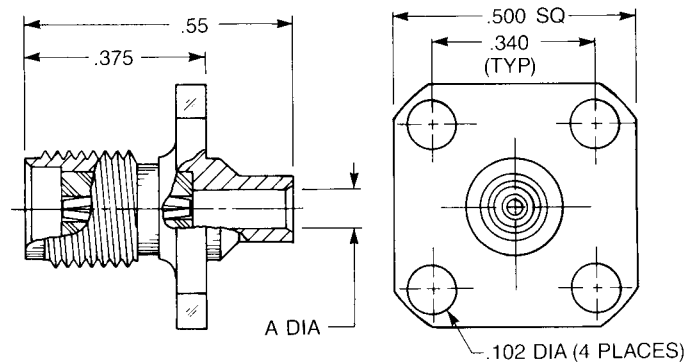
**9431-1583-010** (Gold plated)

**9431-7583-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9431-1583-009** (Gold plated)

**9431-7583-009** (Nickel plated)



- Direct solder attachment
- 2-hole flange
- Noncaptive contact

For .085" semi-rigid (A = .089):

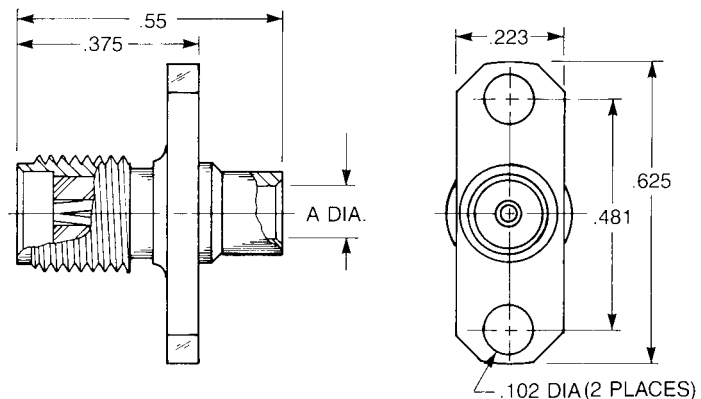
**9441-1083-010** (Gold plated)

**9441-7083-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9441-1083-009** (Gold plated)

**9441-7083-009** (Nickel plated)



- Direct solder attachment
- 2-hole flange
- Captive contact for one-step cable assembly

For .085" semi-rigid (A = .089):

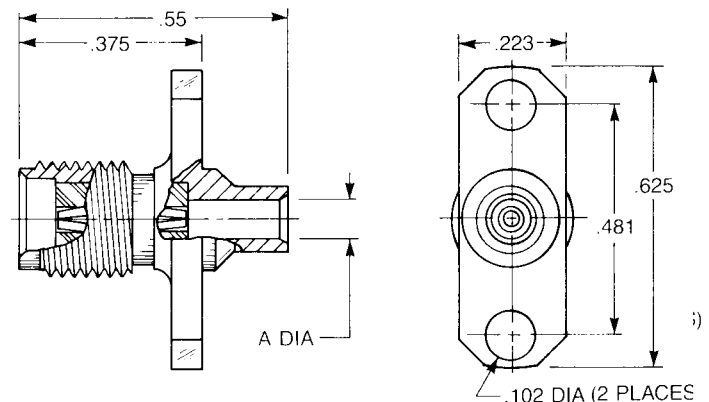
**9441-1583-010** (Gold plated)

**9441-7583-010** (Nickel plated)

For .141" semi-rigid (A = .144):

**9441-1583-009** (Gold plated)

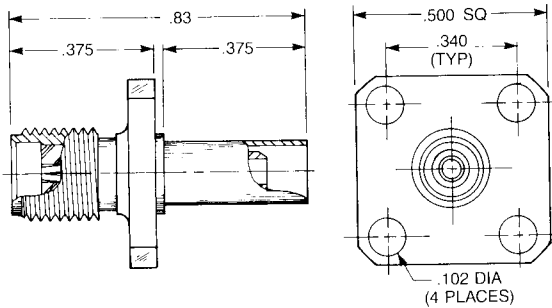
**9441-7583-009** (Nickel plated)



# SMA Panel Jacks for Flexible Cable

Click on part number to go directly to cable assembly instructions

## Straight Jacks



### Straight Panel Jack

- Noncaptive contact
- Square flange

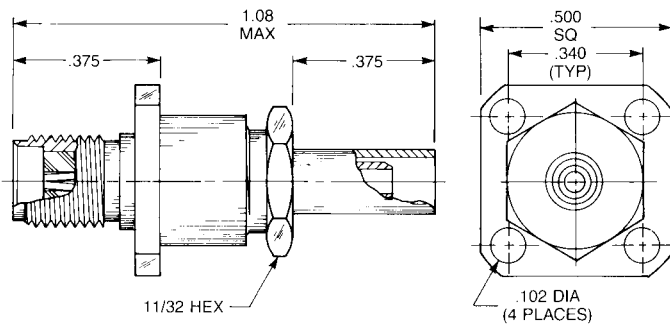
Crimp type:

**9031-1023-0XX** (Gold plated)

**9031-9023-0XX** (Passivated)

Solder type:

**9031-1033-0XX** (Gold plated)



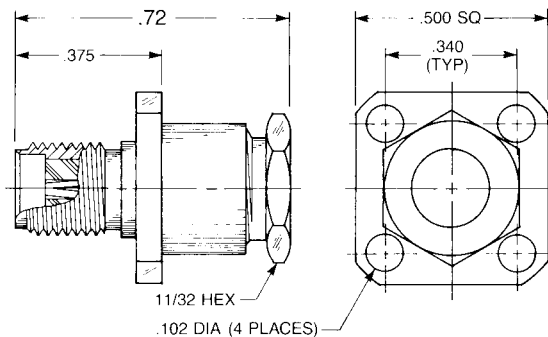
### Straight Panel Jack

- Captive contact
- Square flange

Crimp type:

**9131-1573-0XX** (Gold plated)

**9131-9573-0XX** (Passivated)



### Straight Panel Jack

- Captive contact
- Square flange

Clamp type:

**9231-1553-0XX** (Gold plated)

**9231-9553-0XX** (Passivated)

Substitute the appropriate cable group number for "XX" when ordering:

GROUP	CABLE TYPES	GROUP	CABLE TYPES	GROUP	CABLE TYPES
01	RG142, RG223, M17/60, M17/84, M17/158	04	RG180, RG195, M17/95	06	RG58, RG141, RG303, M17/111, M17/155
02	RG178, RG196, M17/93, M17/169	05	RG178DS, RG196DS	19	RG174DS, RG316DS, M17/151, M17/152, Times RD-316
03	RG174, RG179, RG316, M17/113, M17/119, M17/172, M17/189				



APPLIED ENGINEERING PRODUCTS

(203) 776-2813 • FAX (203) 776-8294

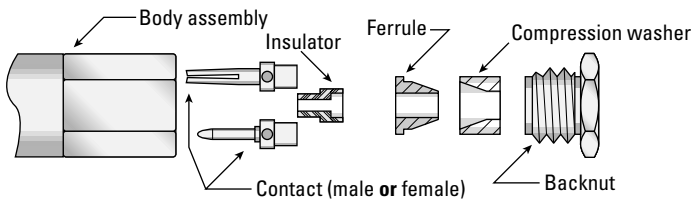
www.aepconnectors.com • aepsales@aepconnectors.com

# Cable Assembly Instructions

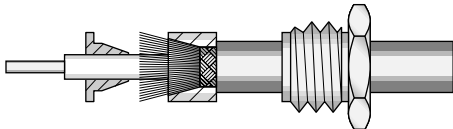
## Clamp type connectors for flexible cable

### Straight Connectors—Flexible Cable

#### Parts list

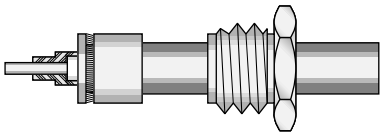


**1**



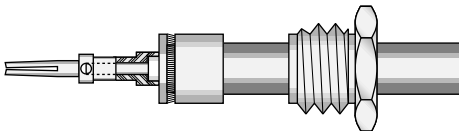
- Trim cable per trim code below; tin end of center conductor.
- Slide backnut onto cable. Slide compression washer onto cable in the orientation shown until it stops against cable jacket.
- Flare cable braid by rotating dielectric and slide ferrule under braid.

**2**



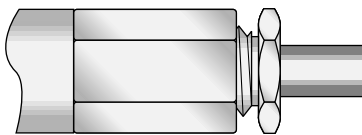
- Press ferrule against compression washer.
- Trim excess braid flush with outer diameter of compression washer and ferrule.
- Assemble insulator over cable center conductor and dielectric.

**3**



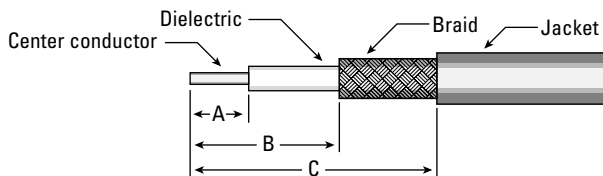
- Assemble contact onto cable center conductor.
- Solder contact to center conductor by heating rear of contact (do not feed additional solder through inspection hole in contact).

**4**



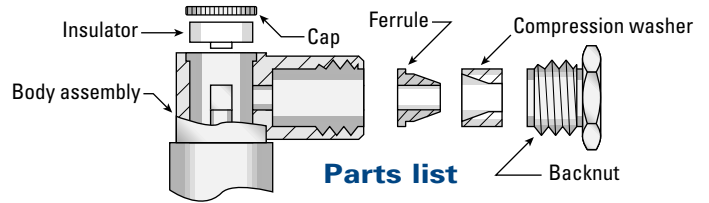
- Insert cable assembly into body assembly. Tighten to 140–150 inch-ounces torque. (Hold cable/hardware assembly stationary and rotate body when tightening.)

### Cable Trim Dimensions

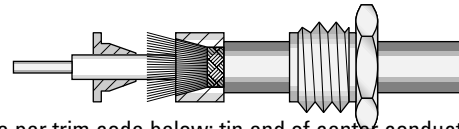


CONNECTOR TYPE	A	B	C
STRAIGHT CONNECTORS	.100	.100	.230
RIGHT ANGLE CONNECTORS	.100	.275	.400

### Right Angle Connectors—Flexible Cable

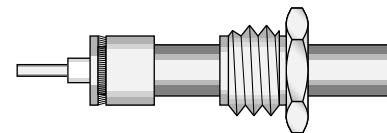


**1**



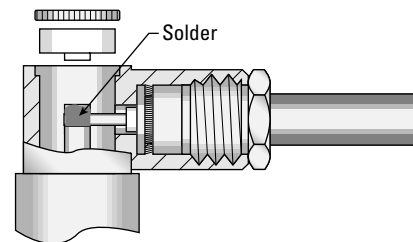
- Trim cable per trim code below; tin end of center conductor.
- Slide backnut onto cable. Slide compression washer onto cable in the orientation shown until it stops against cable jacket.
- Flare cable braid by rotating dielectric and slide ferrule under braid.

**2**



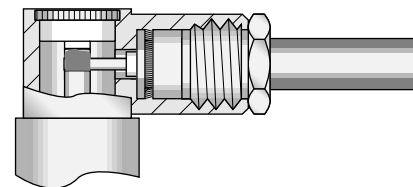
- Press ferrule against compression washer.
- Trim excess braid flush with outer diameter of compression washer and ferrule.
- Assemble insulator over cable center conductor and dielectric.

**3**



- Insert cable assembly into body assembly. Tighten to 140–150 inch-ounces torque. (Hold cable/hardware assembly stationary and rotate body when tightening.)
- Solder center conductor into notch in rear of contact with .025–.032" diameter chisel-tip soldering iron.
- Solder should cover center conductor, but not extend over top of notch in contact, or exceed contact diameter.

**4**



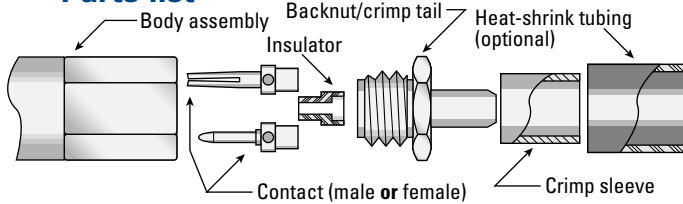
- Place insulator in body cavity, and press cap into place. Properly assembled cap will be slightly below end of body assembly.

# Cable Assembly Instructions

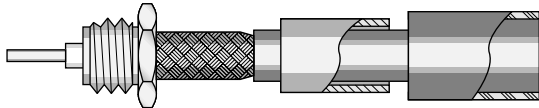
## Crimp type connectors for flexible cable

### Straight Connectors—Captive Contact

#### Parts list

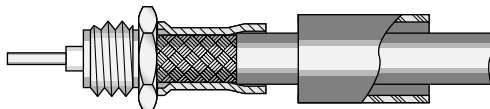


**1**



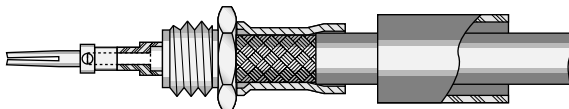
- Trim cable per trim code below; tin end of center conductor.
- Slide heat-shrink tubing and crimp sleeve over cable.
- Flare cable braid by rotating dielectric and slide cable into crimp tail.

**2**



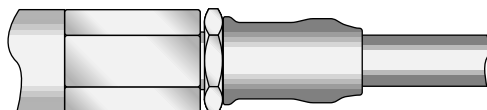
- Position cable so braid touches rear of back nut.
- Slide crimp sleeve forward to touch rear of back nut.
- Crimp braid with appropriate die size from chart below.

**3**



- Assemble insulator and contact onto cable dielectric and center conductor.
- Solder contact to center conductor by heating rear of contact (do not feed additional solder through inspection hole in contact).

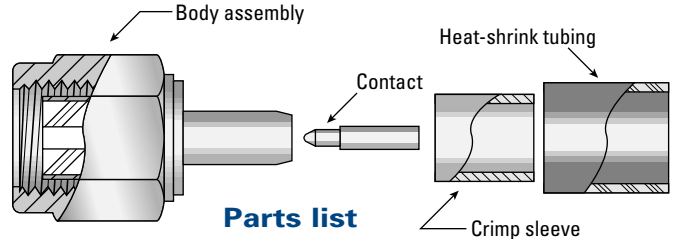
**4**



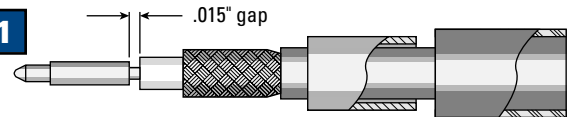
- Insert cable assembly into body assembly. Tighten to 140–150 inch-ounces torque. (Hold cable/hardware assembly stationary and rotate body when tightening.)
- Slide shrink tubing over crimp sleeve and shrink to fit.

### Straight Connectors—Non-captive Contact

#### Parts list

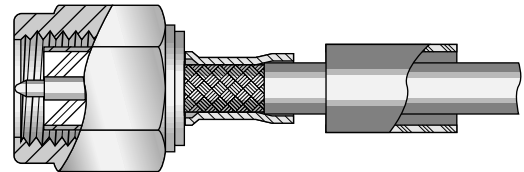


**1**



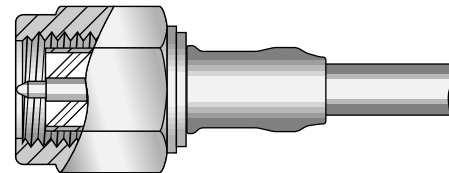
- Trim cable per trim code below; tin end of center conductor.
- Slide heat-shrink tubing and crimp sleeve over cable.
- Assemble contact onto center conductor, shim to maintain .015" gap between rear of contact and cable dielectric.
- Solder contact to center conductor by heating rear of contact (do not feed additional solder through inspection hole in contact).

**2**



- Flare cable braid by rotating dielectric and slide cable into tail of body assembly.
- Position cable so braid touches rear step of body assembly.
- Slide crimp sleeve forward to touch rear of body assembly.
- Crimp braid with appropriate die size from chart below.

**3**

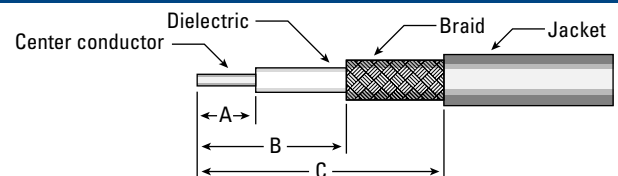


- Slide shrink tubing over crimp sleeve and shrink to fit.

### Crimp Die Sizes

CABLE GROUP	HEX DIE SIZE
01	.213
02	.128
03	.128
04	.156
05	.128
06	.213
19	.156

### Cable Trim Dimensions

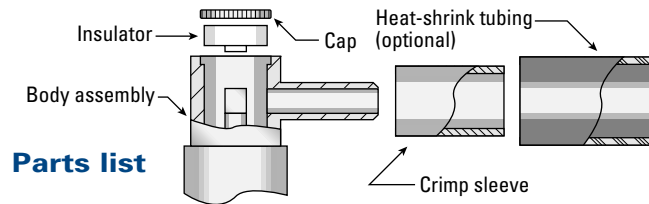


CONNECTOR TYPE	A	B	C
Captive contact	.100	.470	.720
Non-captive contact	.100	.160	.390

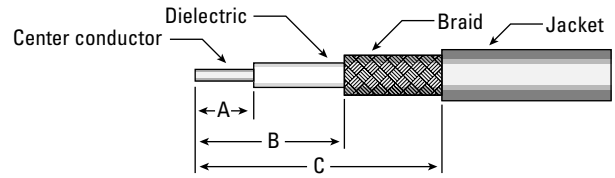
# Cable Assembly Instructions

## Crimp type connectors for flexible cable

### Right Angle Connectors—Flexible Cable



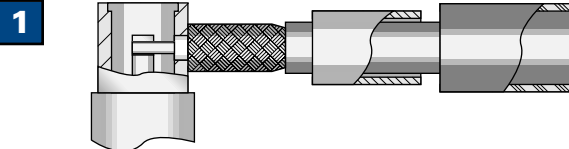
### Cable Trim Dimensions



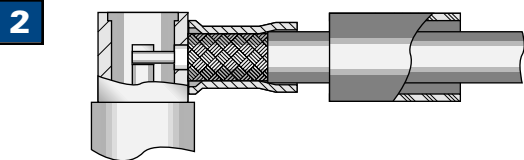
CONNECTOR TYPE	A	B	C
RIGHT ANGLE CONNECTORS	.100	.230	.500

### Crimp Die Sizes

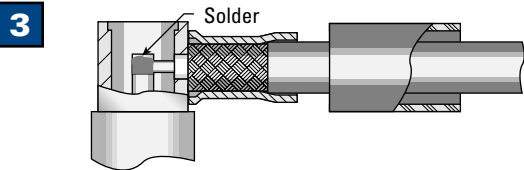
CABLE GROUP	HEX DIE SIZE
01	.213
02	.128
03	.128
04	.156
05	.128
06	.213
19	.156



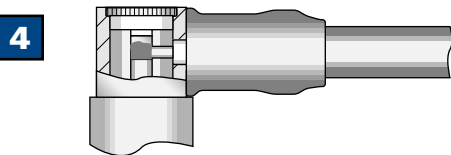
- Trim cable per trim code below; tin end of center conductor.
  - Slide heat-shrink tubing and crimp sleeve over cable.
  - Flare cable braid by rotating dielectric and slide cable into crimp tail.



- Position cable so braid touches rear of body assembly.
  - Slide crimp sleeve forward to touch rear of body assembly.
  - Crimp braid with appropriate die size from chart below.



- Solder center conductor into notch in rear of contact with .025–.032" diameter chisel-tip soldering iron.
  - Solder should cover center conductor, but not extend over top of notch in contact, or exceed contact diameter.



- Place insulator in body cavity, and press cap into place. Properly assembled cap will be slightly below end of body assembly.
  - Slide shrink tubing over crimp sleeve and shrink to fit.

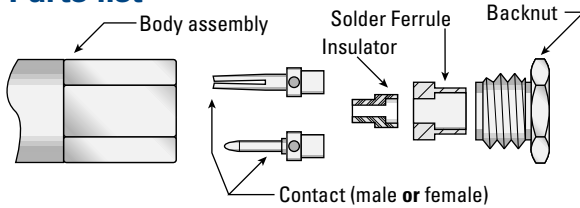


# Cable Assembly Instructions

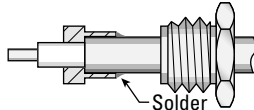
## Solder-clamp connectors for semi-rigid cable

### Straight Connectors—Semi-Rigid Cable

#### Parts list

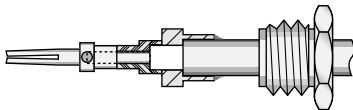


**1**



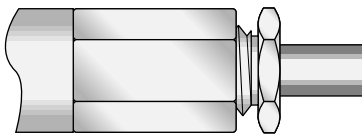
- Trim cable per trim code below; tin end of center conductor.
- Slide backnut over cable. Slide solder ferrule over cable until it stops against cable jacket.
- Solder cable jacket to ferrule.

**2**



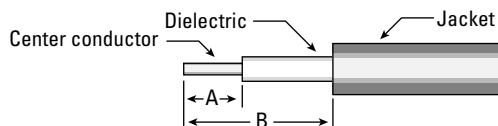
- Assemble insulator and contact onto cable dielectric and center conductor. If insulator is not flush against solder ferrule due to dielectric extrusion, retrim dielectric.
- Solder contact to center conductor by heating rear of contact (do not feed additional solder through inspection hole in contact).

**3**



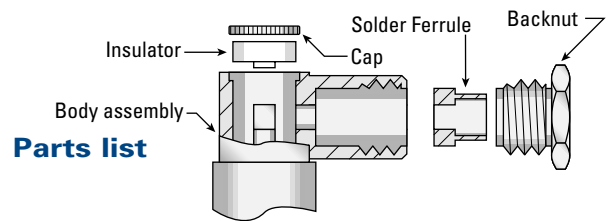
- Insert cable assembly into body assembly. Tighten to 90–100 inch-ounces torque. (Hold cable/hardware assembly stationary and rotate body when tightening.)

### Cable Trim Dimensions

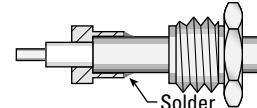


CONNECTOR TYPE	A	B
Straight connectors	.100	.135
Right angle connectors— <b>.085"</b> cable	.080	.170
Right angle connectors— <b>.141"</b> cable	.125	.290

### Right Angle Connectors—Semi-Rigid Cable

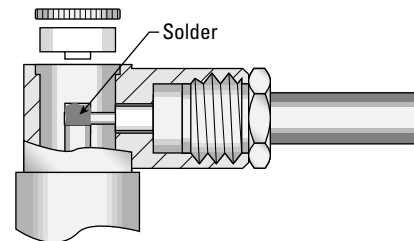


**1**



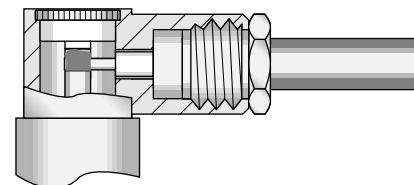
- Trim cable per trim code below; tin end of center conductor.
- Slide backnut over cable. Slide solder ferrule over cable until it stops against cable jacket.
- Solder cable jacket to ferrule.

**2**



- Insert cable assembly into body assembly. Tighten to 90–100 inch-ounces torque. (Hold cable/hardware assembly stationary and rotate body when tightening.)
- Solder center conductor into notch in rear of contact with .025–.032" diameter chisel-tip soldering iron.
- Solder should cover center conductor, but not extend over top of notch in contact, or exceed contact diameter.

**3**



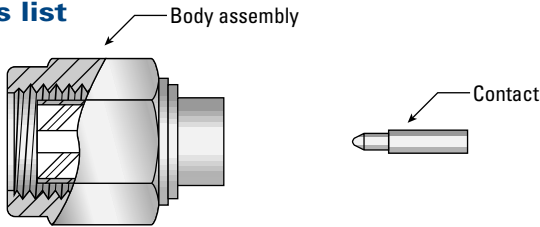
- Place insulator in body cavity, and press cap into place. Properly assembled cap will be slightly below end of body assembly.

# Cable Assembly Instructions

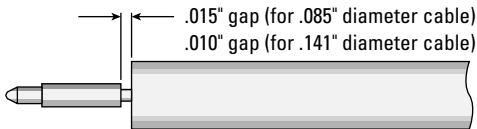
## Direct solder connectors for semi-rigid cable

### Straight Connectors—Non-captive Contact

#### Parts list

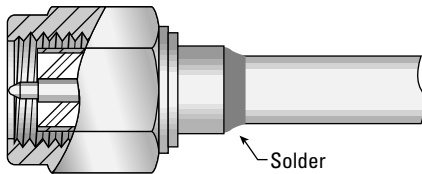


**1**



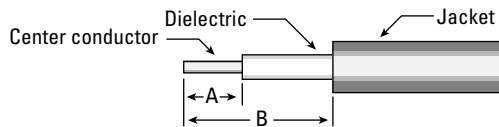
- Trim cable per trim code below; tin end of center conductor.
- Shim to maintain proper gap between rear of contact and cable dielectric.
- Solder contact to center conductor by heating rear of contact (do not feed additional solder through inspection hole in contact).

**2**



- Slide cable into connector until it stops.
- Solder cable jacket to connector body.

### Cable Trim Dimensions

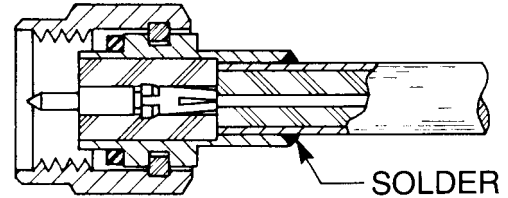


CONNECTOR TYPE	A	B
Straight connectors	.090	.090
Right angle connectors	.080	.170

### Straight Connectors—Captive Contact

**1**

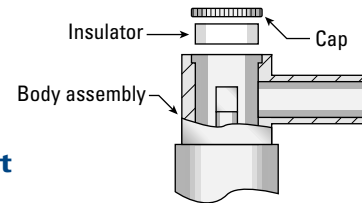
- Trim cable per trim code below; chamfer end of center conductor 70–90°.



**2**

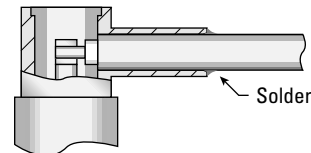
- Insert cable into body assembly until it stops.
- Solder cable jacket to connector body.

### Right Angle Connectors



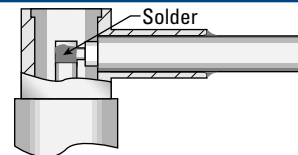
#### Parts list

**1**



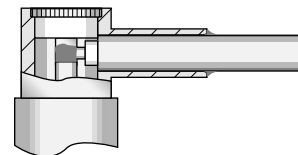
- Trim cable per trim code below; tin end of center conductor.
- Insert trimmed cable into body until jacket bottoms on step inside body and center conductor is in contact slot.
- Solder cable jacket to body assembly.

**2**



- Solder center conductor into notch in rear of contact with .025–.032" diameter chisel-tip soldering iron.
- Solder should cover center conductor, but not extend over top of notch in contact, or exceed contact diameter.

**3**



- Place insulator in body cavity, and press cap into place. Properly assembled cap will be slightly below end of body assembly.

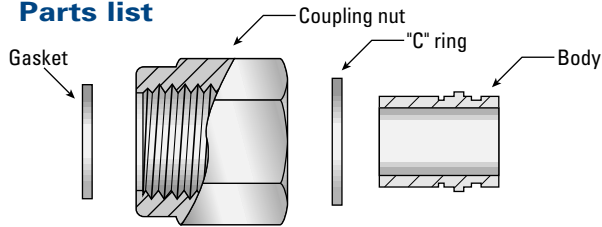


# Cable Assembly Instructions

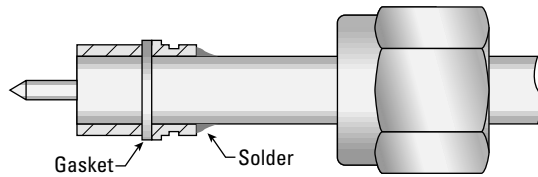
## Direct solder connectors for semi-rigid cable

### P/N 9301-1063-009

#### Parts list

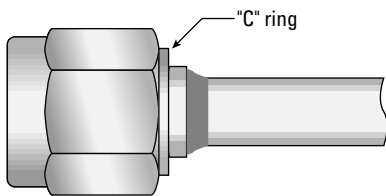


**1**



- Trim cable per trim code below; point end of center conductor to 45° as shown.
- Slide backnut over cable. Slide body over cable until trimmed end of cable is flush with front of body.
- Solder cable jacket to body. Retrim cable dielectric flush with body if it has extruded due to heat from soldering.
- Assemble gasket into groove on body.

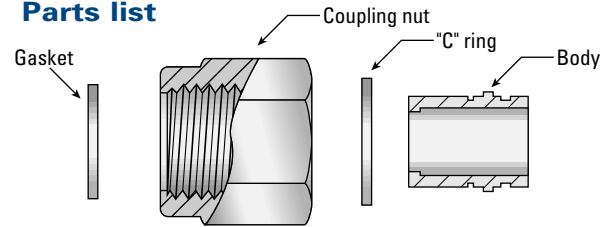
**2**



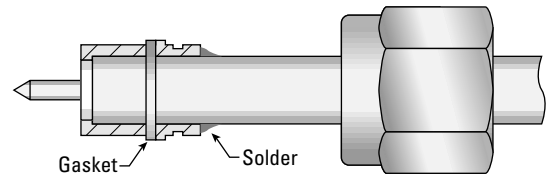
- Slide coupling nut forward until it stops and assemble "C" ring into groove.

### P/N 9301-1063-109

#### Parts list

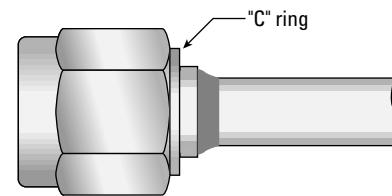


**1**



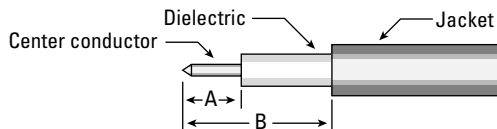
- Trim cable per trim code below; point end of center conductor to 45° as shown.
- Slide backnut over cable. Slide body over cable until trimmed end of cable jacket stops against step in body.
- Solder cable jacket to body. Retrim cable dielectric flush with body if it has extruded due to heat from soldering.
- Assemble gasket into groove on body.

**2**



- Slide coupling nut forward until it stops and assemble "C" ring into groove.

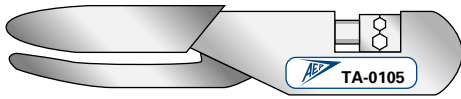
### Cable Trim Dimensions



CONNECTOR TYPE	A	B
9301-1063-009	.090	.090
9301-1063-109	.090	.180

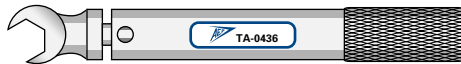
# Assembly Tooling

## Crimp tools



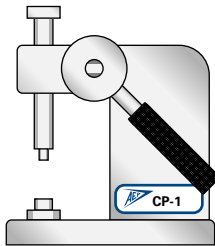
DESCRIPTION	AEP P/N
Crimp tool with .128" and .213" hex dies	TA-0007
Crimp tool with .156" hex die	TA-0071
Crimp tool with .105" and .128" hex dies	TA-0105
Crimp tool with .255" and .068" hex dies	TA-0190
Crimp tool with .255" hex die	TA-0234

## Torque Wrench



DESCRIPTION	AEP P/N
Torque wrench with 5/16" jaw for SMA coupling nuts; 8 inch-pounds torque	TA-0397

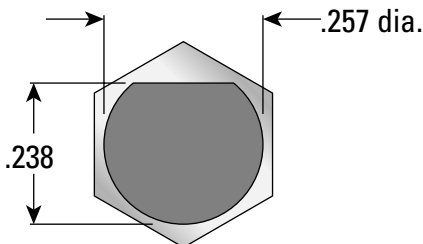
## Capping Press



DESCRIPTION	AEP P/N
Capping tool (arbor press) with base for SMA right angle plugs	Contact Factory
Capping tool (arbor press) with base for SMA right angle jacks	Contact Factory

# Mounting Dimensions

## Bulkhead Receptacles



## P.C. Board Receptacles

