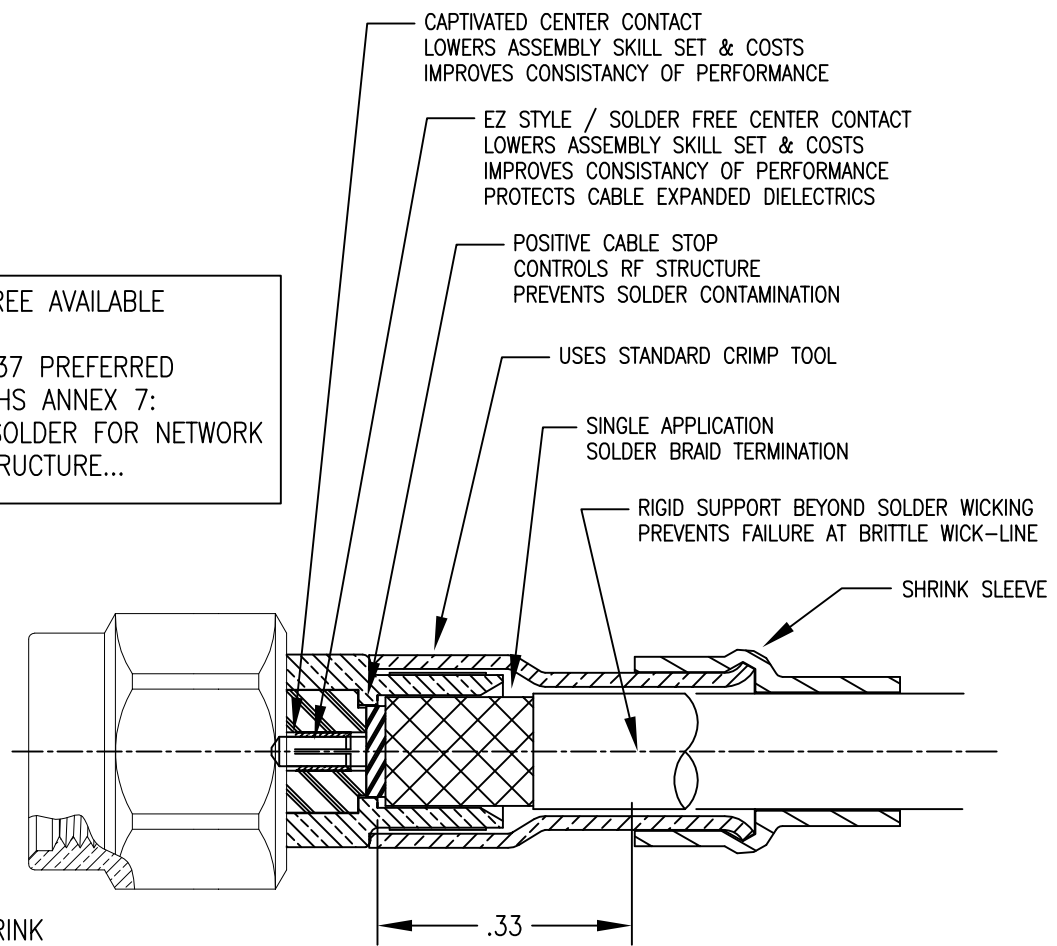


LEAD FREE AVAILABLE  
 Sn63Pb37 PREFERRED  
 PER RoHS ANNEX 7:  
 Pb IN SOLDER FOR NETWORK  
 INFRASTRUCTURE...

ASSEMBLY INSTRUCTIONS:

- 1) WINDOW STRIP JACKET AT 0.10 THRU 0.34
- 2) PRE-TIN THE BRAID USING MINIMUM SOLDER
- 3) STRIP BRAID AT 0.148
- 4) STRIP CENTER CONDUCTOR LEAVING .025 DIELECTRIC
- 5) POINT CENTER CONDUCTOR
- 6) FIXTURE SMA INTERFACE WITH 1209-03-P
- 7) INSERT CABLE FULLY INTO CONNECTOR BODY
- 8) APPLY HEAT TO CONNECTOR BODY ONLY AND SOLDER BRAID
- 9) LIMIT SOLDER WICKING TO 0.33
- 10) POSITION CRIMP FERRULE AND CRIMP .231 HEX
- 11) ALIGN HEAT SHRINK IN MIDDLE OF FERRULE SADDLE AND SHRINK



c2	remove note	mix	7/20/16	fsh	fsh
c1	REALIGN LEADER TO HEAT SHRINK	mix	5/29/15	fsh	fsh
c	.127 min was .105	mix	5/15/12	fsh	fsh
B	update to support RF performance goals	mix	9/8/11	fsh	fsh
A	RELEASE	NEW	7/24/06		
Rev.	Revisions	Disp.	Date	Dwn.	Appd.
	Ref.: SK-	REMOVE ALL BURRS AND SHARP EDGES .005 MAX.	INTERPRET PER ASME Y14.5M-1994		

THIS DRAWING CONTAINS CONFIDENTIAL INFORMATION PROPRIETARY TO SAN-TRON, INC. IT MUST NOT BE REPRODUCED OR DISCLOSED TO OTHERS OR USED IN ANY OTHER WAY, IN WHOLE OR PART EXCEPT AS AUTHORIZED IN WRITING BY SAN-TRON, INC.

UNLESS OTHERWISE SPECIFIED:  
 ALL DIMENSIONS ARE IN INCHES.  
 ALL DIMENSIONS ARE AFTER PLATING.  
 .XXX = ±.005 ALL MACHINED SURFACES 63/ MAX.  
 .XX = ±.01 ANG. ±1/2' FRACTIONAL = ±1/64

⓪ .004 MAX. TIR.      ⊥ AXIS .001

THIRD ANGLE PROJECTION

DWN	FSH	7/24/06
CHKD	SJS	/
APPR	FSH	7/24/06

**SAN-TRON, INC.**  
 4 NEWBURYPORT TPK. IPSWICH MA USA 01938  
 TEL: 978 - 356 -1585 FAX: 978 - 356 -1573  
 WWW.SANTRON.COM E MAIL: santron@santron.com

**San-Tron**

TITLE eSERIES CABLE ASSEMBLIES TERMINATION INSTRUCTIONS

MATERIAL: COUPLING NUT: SS-303 BODY: BRASS CONTACT: BeCu      FINISH: COUPLING NUT: PASSIVATE BODY: GOLD/Cu CONTACT: GOLD/Ni

CAGE CODE: 50896      DWG NO. CA-9967 eSERIES      REV. c2

SCALE X:X