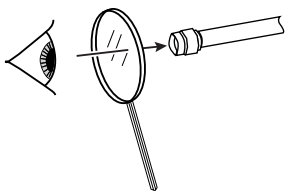
Instruction Sheet

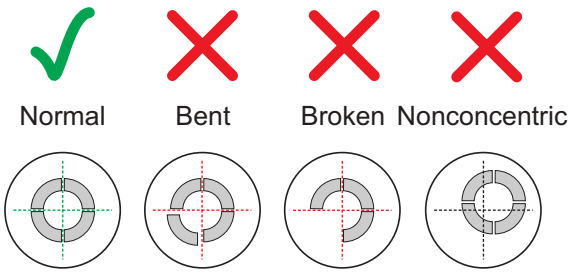
Connector Care

Inspecting Connectors



Use adequate magnification when inspecting connectors. The minimum magnification ranges from 2X to 10X magnification.

- N connectors: 2X
- K (2.92 mm) connectors: 7X
- V (1.85 mm) connectors: 7X
- W1 (1.0 mm) connectors: 10X
- 0.8 (0.8 mm) connectors: 10X

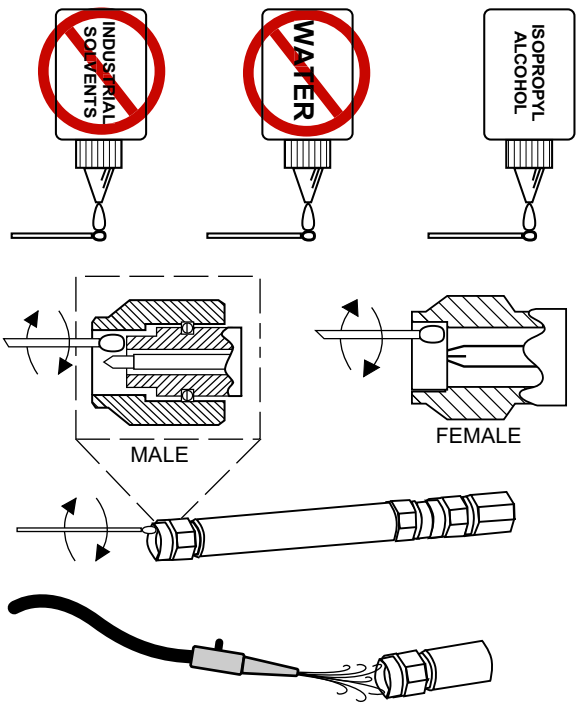


Inspect connectors for:

- Bent and misaligned center pins (pins should be concentric)
- Flaking or blistering plating
- Thread defects and deep scratches and dents on mating surfaces

Discard and replace any connectors with any of the above defects.

Cleaning Connectors



Keep connectors clean and free of dirt and other debris.

1. Blow out any debris from the connector using low-pressure, clean, dry, compressed air.
2. Apply a small amount of Isopropyl Alcohol (IPA) to a lint-free cotton swab.
3. Rotate the cotton swab around the connector, avoiding lateral pressure.
4. Blow out any remaining debris.
5. Inspect connector under magnification.

Notes: Most cotton swabs are too large to fit into the ends of the smaller connector types. In this case, peel off most of the cotton and then twist the remaining cotton tight. Be sure that no cotton gets caught in the connector.

Do not use industrial solvents or water to clean the connector. Use isopropyl alcohol only. **Do not** spray alcohol directly onto connector surfaces.

Teflon Tuning Washers: The center conductor on some RF components contains a small Teflon tuning washer located near the point of mating (interface). Be careful not to disturb the Teflon tuning washer during cleaning.

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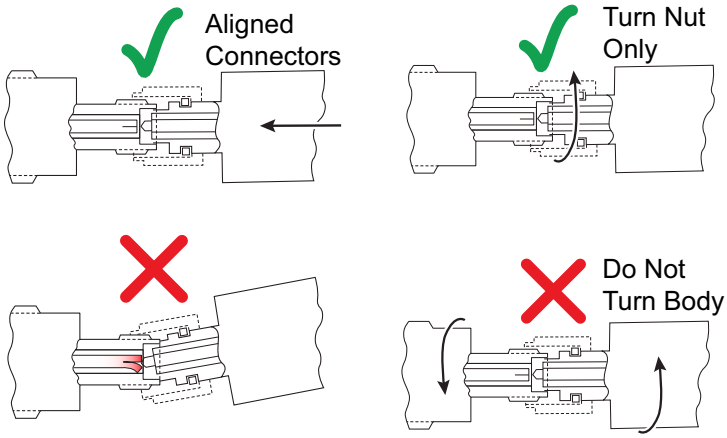
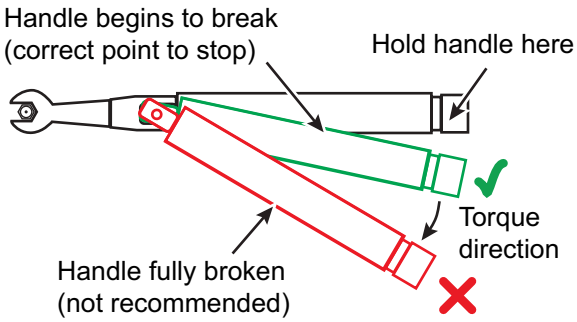
Part Number: 10100-00060
Revision: A
Published: October 2019

Making the Connection





Carefully align the connectors so they are parallel to each other. The male connector center pin must slip concentrically into the contact fingers of the female connector.

Never apply excessive force and **do not** twist while pushing the connectors together.

Finger-tighten the connection first by turning the connector nut. **Do not** turn the connector body.

The final tightening is done using the appropriate torque wrench set to the correct torque setting for your connector.

Never use pliers to tighten connectors. For connectors with flats, use the appropriate torque wrench. For connectors without flats, such as some Type N connectors, finger-tight is sufficient.

Torque Specifications and Tools

Connector Type/Size	Wrench Size	Torque Setting	Recommended Tools
7/16 DIN	32 mm 1-1/4 in	25 N·m 18.43 lbf·ft	01-513 Torque Wrench 01-510 Adjustable Wrench
	25.4 mm 1 in	25 N·m 18.43 lbf·ft	01-512 Torque Wrench 01-510 Adjustable Wrench
Type N	19 mm 3/4 in	1.35 N·m 12 lbf·in	01-200 3/4 in Torque Wrench *Do not use a wrench or pliers to tighten twist-on (no flats) style connectors.*
7 mm	19.2 mm 3/4 in	1.35 N·m 12 lbf·in	01-200 3/4 in Torque Wrench
SMA 3.5 mm WSMA K (2.92 mm) 2.4 mm V (1.85 mm)	8 mm 5/16 in	0.9 N·m 8 lbf·in	01-201 5/16 in Torque Wrench 01-204 5/16 in 8 mm Wrench
W1 (1 mm)	6 mm	0.45 N·m 4 lbf·in	01-504 6 mm Torque End Wrench 01-505 6 mm x 7 mm Combination Wrench
0.8 (0.8 mm)	6 mm	0.45 N·m 4 lbf·in	01-524 6 mm Torque End Wrench 01-525 6 mm x 7 mm Combination Wrench

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