

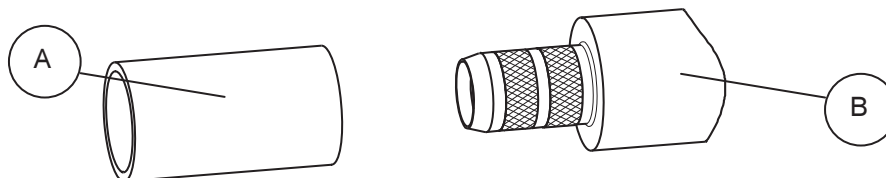
Assembly instruction Series SMA 0000179057

Old instruction No. 09189



Connector type:	11_N-50-4-55, 24_N-50-4-53, 11_PC35-50-4-4, 21_PC35-50-4-4, 11_SMA-50-4-53, 21_SMA-50-4-52, 11_TNC-50-4-52, 24_TNC-50-4-52	Inner conductor contact:	Plugged-in
Suitable cables:	S 04272 B	Outer conductor contact:	Crimped (Cavity 6,5)

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	Slide ferrule A onto cable. Prepare cable according to diagram. (Do not remove foil!)	Do not damage braid, dielectric and inner conductor of cable	Stanley blade scissors
	Form tip of inner conductor of cable to a 60° cone.	Ensure that the inner conductor of cable is straight. Ensure that the cone end is well formed.	Tip trimmer tool W 264
	Splay out braid and insert cable in connector body B.	Ensure that braid lies above the crimp neck and the foil enters the body B.	
	Slide ferrule A over braid and crimp as close to connector body B as possible.	During the crimping push the cable against the body B.	Crimp tool: For large crimp tool and table press use insert 76_Z-0-4-18.

The cable assembly of R.F. connectors can only be done by well trained assembly stuff and suitable assembly equipment. Huber+Suhr's skilled stuff and specialised equipment are available to carry out complete R.F. lead-assembly on your behalf. We mount your connectors on cables at economic prices! Please contact our representative for further details of this service.

Revision	D
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Initiator	4952/srm

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