

Assembly instruction Series C,N

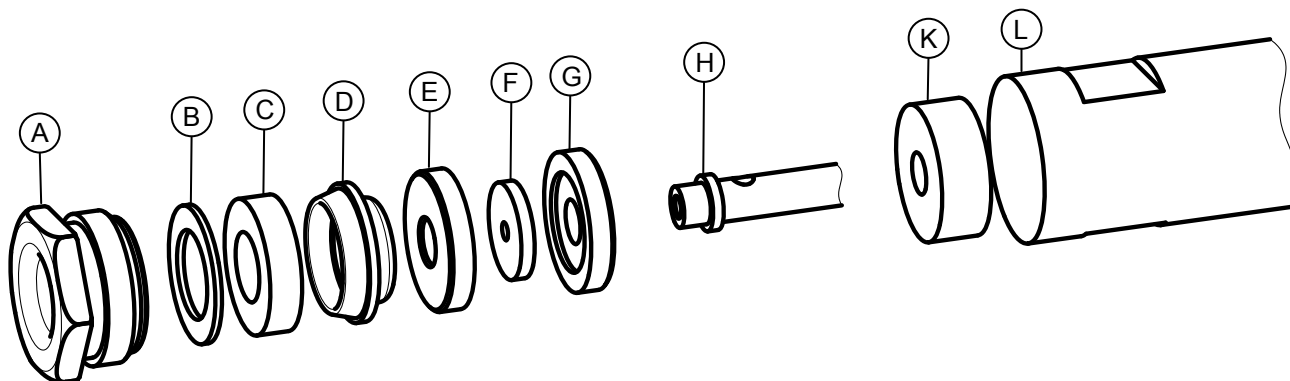
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Old instruction No. 3017



Connector type: (e.g.)	25_C-50-3-4 / 25_N-50-3-4 / 11_N-50-3-5	Inner conductor contact:	soldered
Suitable cables: (e.g.)	RG_58_C/U / RG_223_U / K_02252_D	Outer conductor contact:	screwed

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	Slide nut A, washer B and gasket C onto cable. Prepare cable according to diagram.	Do not damage braid!	Stanley blade Scissors
	Push braid back slightly to expose dielectric and cut back dielectric 5.5 mm perpendicular to cable axis. Taper braid towards inner conductor. Position braid clamp D so that its shoulder fits against cable sheath. Fold back braid over clamp D and trim overlapping braid.	Do not damage inner conductor. Check dimension of 1.5 ± 0.3 mm.	Stanley blade Scissors
	Position bushing E, insulator F and G. Heat inner contact H using a soldering iron and flow small amount of solder into bore X. Push cable inner conductor into bore, immediately remove soldering iron to prevent melting of the dielectric.		Soldering iron (150 W) Solder
	Push prepared cable into connector body L, with front part of insulator K and tighten nut A.	Torque 4 Nm. Do not rotate cable in connector body.	Spanner 11 mm (74_Z-0-0-2)

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	C
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