

Assembly instruction Series C,N

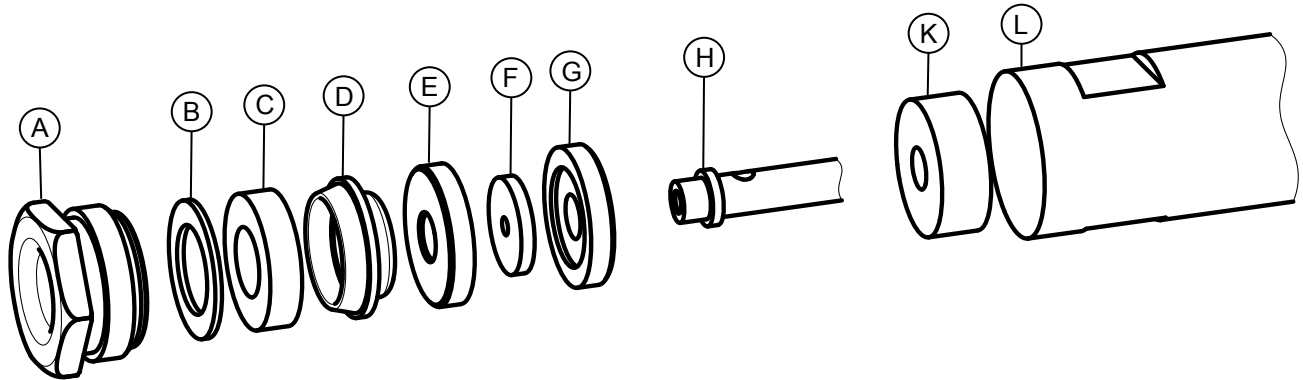
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Old instruction No. 3017



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|-------------------------|---|--------------------------|----------|
| 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.

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| Revision | C |
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