

Assembly instruction Series TNC No. 27220

Tools and materials required:

Soldering iron 80 to 100 Watts / 220 to 240°C
 Solder Sn / Pb 60 / 40, 0,8 mm Ø, activated rosin flux
 Alcohol, brush, blade (74 Z-0-0-68)
 SR cable stripping tool No. W 157
 Soldering fixture No. W 58
 Inserts No. W 59
 Locator tool No. W 66
 Tip trimmer No. W 164
 Trim tool No. W 3-4
 Solder gauge No. W 335 (0,7 mm)
 Spanner 9 mm
 Contact holder No. W 287
 Positioner No. W 81 (for W 164)

Connector types : (e.g.)

24 TNC - 50 - 3 - 30

Straight connectors for copper jacket cables

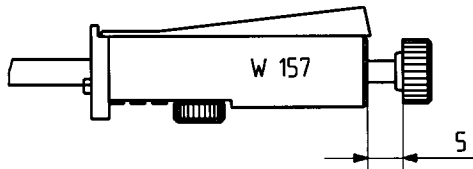
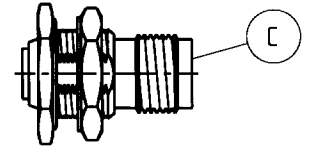
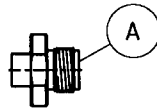
Cable entry : soldered

Suitable cables e.g: EZ 141 (.141")

Centre contact : soldered

Outer conductor : soldered

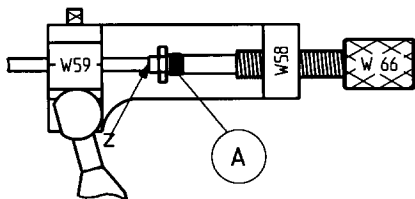
This connector is supplied in 3 parts



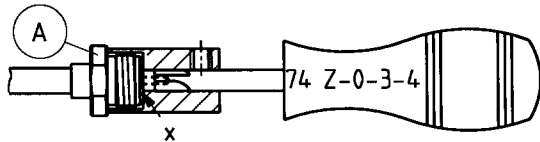
Cut cable end perpendicular to cable axis.
 Cut back copper jacket using cable stripping tool W 157.
 The tool must be set for 5 mm stripping dimension.
 See instruction sheet No. 9144 for detailed description.



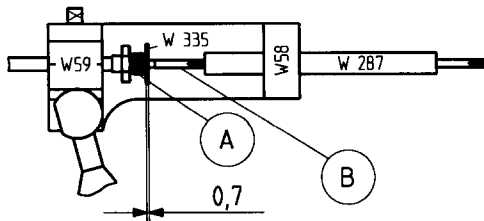
Remove dielectric flush with copper jacket using a blade.
 Form tip of inner conductor to a 90° cone using tip trimmer W 164 and W 81.
 Check dimension 5 mm.



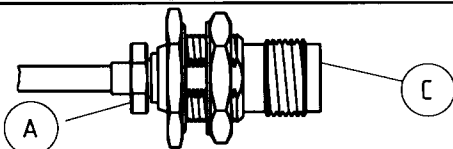
Slide connector part A over cable. Fix cable in soldering fixture W 58 using inserts W 59. Tighten locator tool W 66 fully against cable. Push connector part A against locator tool W 66 and solder in this position (z).
 Immediately cool down and clean with alcohol.



Place prepared cable in trim tool W 3-4 as illustrated.
 Rotate trim tool to remove protruding dielectric and copper jacket until flush with body (x).
IMPORTANT: Prior to this operation the cable must be cooled down to room temperature.



Push contact B onto contact holder W 287 and fix cable in soldering fixture W 58 as illustrated.
 Use inserts W 59.
 Place soldering gauge on inner conductor as illustrated.
 Push contact holder against soldering gauge and solder.
 Remove cable from fixture and clean solder joint with alcohol.



Carefully screw body A into connector housing C using a 9 mm spanner.
 (torque 4 Nm)

SUHNER's skilled staff 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.



HUBER + SUHNER AG CH-9100 HERISAU

Deutscher Text : siehe Rückseite