

# Assembly instruction Series MCX No. 9000

## Tools and materials required:

Soldering iron, 80to100Watts/220to240°C  
 Small soldering iron, 40Watts/220to240°C  
 Solder Sn/Pb 60/40, activated rosin flux  
 Alcohol, brush, Stanley blade, abrasive paper

### For manual assembling:

-Assembly tool 74 Z-0-0-30  
 -Locating tool 74 Z-0-0-146

### For table press:

-Assembly tool 74 Z-0-0-205

Angle plug for copper jacket cable

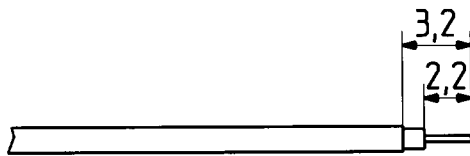
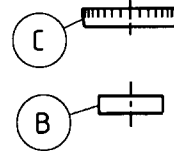
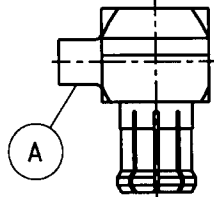
Cable entry: soldered

Connector types: e.g.

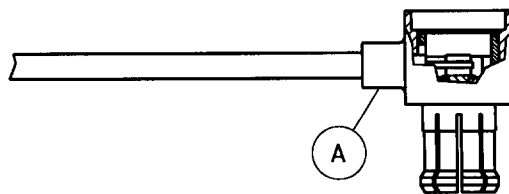
16 MCX - 50 - 1 - 3

16 MCX - 50 - 2 - 3

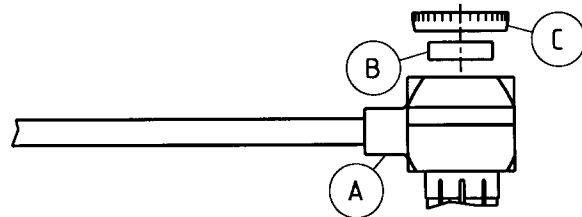
This connector is supplied in 3 parts	Suitable cables e.g.	EZ 47 (.047")	EZ 86 (.086")
	Centre contact: captive	soldered	soldered
	Braid:	soldered	soldered



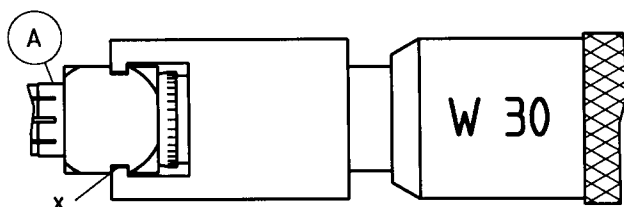
Lightly cut into copper jacket 3.2mm from cable end (use Stanley blade) in a plane perpendicular to cable axis. Separate copper jacket by gentle flexing action and remove. Cut back 2.2mm of dielectric, do not damage inner conductor of cable (use Stanley blade). De-burr inner conductor of cable, clean copper jacket with abrasive paper and remove all filings.



Slide prepared cable into connector body A. Solder connector body A to copper jacket. Promptly swab soldered area with alcohol to cool joint and remove any residual flux (use brush). Solder inner conductor to contact pin (use small soldering iron).



Push insulator B into body A and place cover C on rear opening of body A.



Place cover insertion tool 74 Z-0-0-30 in groove x of body A. Drive cover into rear opening of body A by rotating the handle of the cover insertion tool. For body A grip tool W 146.

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

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