

# Assembly instruction Series TNC No. 27269

## 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 60  
 Locator tool No. W 61  
 Tip trimmer No. W 164  
 Trim tool No. 74 Z - 0 - 2 - 6  
 Positioner NO. W 81 ( for W 164 )  
 Spanner 9 mm  
 Contact holder No. W 287  
 solder gauge No. W 117 ( 0,6 mm )

Connector types : ( e.g. )

24 TNC - 50 - 2 - 31

Straight connectors for copper jacket cables

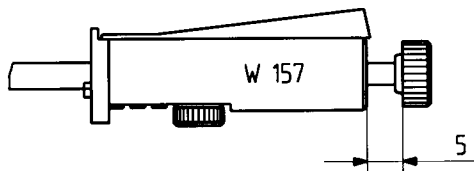
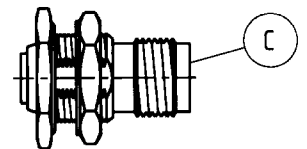
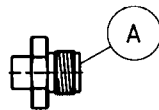
Cable entry : soldered

Suitable cables e.g: EZ 86 (.0865")

Centre contact : soldered

Outer conductor : soldered

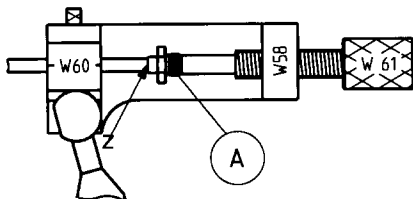
This connector is supplied in 3 parts



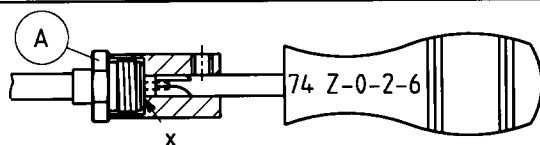
Cut cable end perpendicular to cable axis.  
 Cut back copper jacket using cable stripping tool W 157.  
 The tool must be set for 5 mm stripping dimension.  
 See instruction sheet No. 9144 for detailed description.



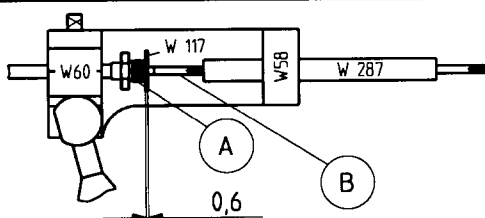
Remove dielectric flush with copper jacket using a blade.  
 Form tip of inner conductor to a 90° cone using tip trimmer W 164 and W 81. Caution: Do not distort the cable centre contact! Check dimension 5 mm.



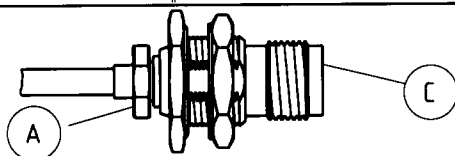
Slide connector part A over cable. Fix cable in soldering fixture W 58 using inserts W 60. Tighten locator tool W 61 fully against cable. Push connector part A against locator tool W 61 and solder in this position ( z ).  
 Immediately cool down and clean with alcohol.



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 60.  
 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 and 17 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

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