

# Assembly instruction

Series MCX

AB 09.05.00  
4726/KRI

No. 27308

## 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-50-2-104

This connector  
is supplied  
in 2 parts

Suitable cables: (e.g.)

EZ 86 (.086")

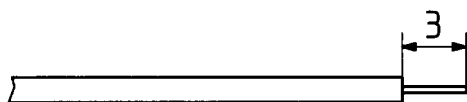
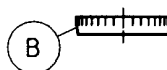
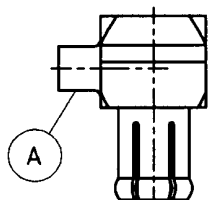
Centre contact:

soldered

Braid:

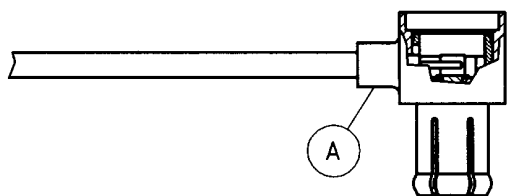
soldered

Preconditioned, pretinned cables are recommended.

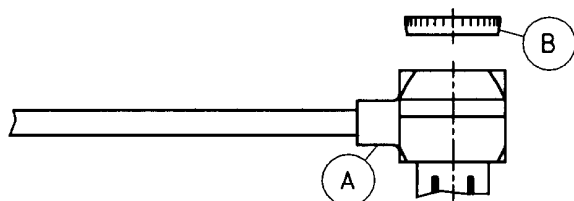


Strip cable according to diagram.

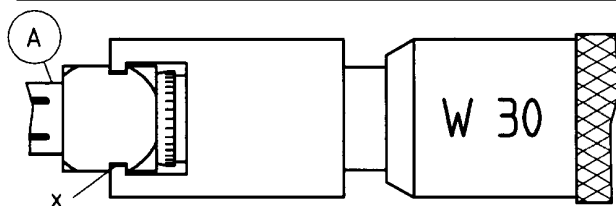
CAUTION: Do not damage inner conductor of cable!



Push prepared cable into connector body A.  
Solder connector body A to copper jacket.  
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).



Place cover B loosely on rear opening of body A.



Insert assembly tool 74 Z-0-0-30 into groove X and press cover B into body A by rotating the handle of the assembly tool.  
For body A use grip tool W 14.6.

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



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Deutscher Text: siehe Rückseite