

# Assembly instruction

Series CT

AA 11.07.00  
4515/H.G.

No. 27412

## Tools and materials required :

Stanley blade, scissors  
Crimping tool (see table)  
Small soldering iron, 40 Watts / 220° - 240°C  
Solder Sn/Pb 60/40 Ø 0,6 mm  
activated rosin flux  
Cover insertion tool SUHNER 74 Z-0-0-9  
Soft hammer

PCB right angle cable receptacles

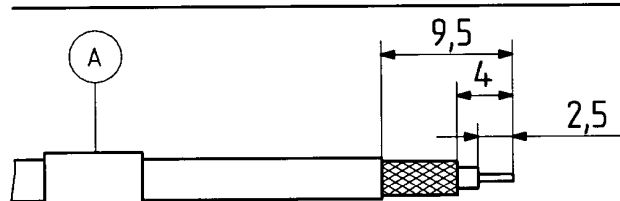
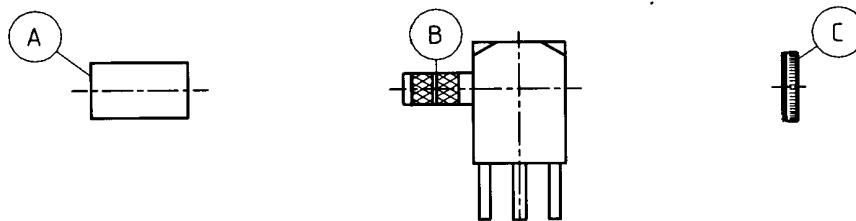
Cable entry : SUHNER Crimp

Connector types : (e.g.)

86 CT-0-1-2	86 CT-0-2-2	86 CT-0-2-3
RG 178 B/U RG 196 A/U	RG 174/U RG 188 A/U RG 316/U	K 02252 D
Centre contact : captive	soldered	soldered
Braid :	cavity A	cavity A
Crimp tool :	1,2,A (red)	1,2,A (red)

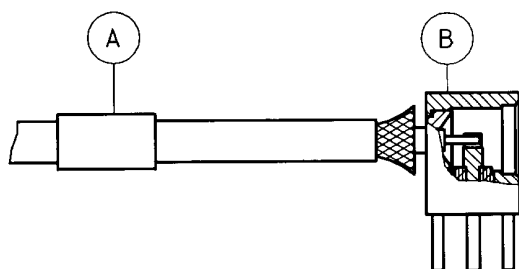
This connector  
is supplied  
in 3 parts

**Important :** Cable assembly must be completed prior to PC board mounting !



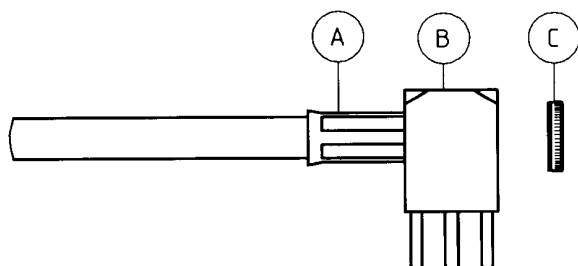
Slide ferrule A onto cable.  
Prepare cable according to diagram.

**CAUTION :** Do not damage braid, dielectric  
and inner conductor of cable !



Splay out braid and insert cable in connector body B.

**CAUTION :** Ensure that braid lies above the crimp neck.



Slide ferrule A over braid to abut connector body B  
and crimp as close to connector body as possible.

Solder inner conductor, and carefully drive cover C  
into connector body B. Use SUHNER tool 74 Z-0-0-9  
and soft hammer.

Solder onto PC board.

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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