

Assembly instruction

Series N

No. 3095

Tools and materials required:

Soldering iron
Solder Sn/Pb 60/40, 0.8 mm ϕ , activated rosin flux
Alcohol, brush
Blade (74 Z-0-0-68)
SR cable stripping tool No. W 157
Soldering fixture No. W 58
Locator tool No. W 66
Inserts No. W 59
Dielectric trim-jig No. W 3-2
Dielectric insert tool No. W 29
Tip trimmer No. W 164
Contact holder No. W 67
Positioner No. W 81 (for W 164)

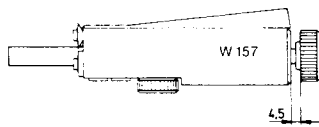
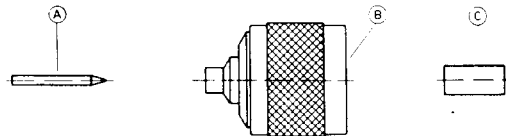
Straight connectors for copper jacket cable

Cable entry: soldered

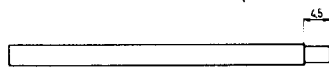
Connector types: (e. g.)

11 N-50-3-13 Cable EZ 141 (.141")

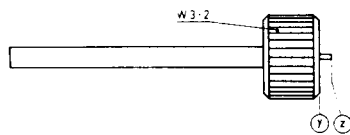
This connector is supplied in 3 parts



Cut cable end perpendicular to cable axis.
Cut back copper jacket using cable stripping tool W 157.
See instruction sheet No. 9144 for detailed description.
The tool must be set for 4,5 mm stripping dimension.



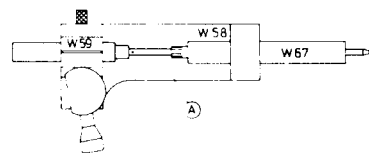
Check dimension 4,5 mm.



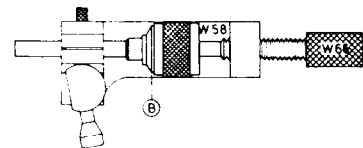
Slide trim-jig W 3-2 on to cable.
Cut back dielectric along plane y, do not damage inner conductor of cable (use blade).
Remove trim-jig, form tip of inner conductor to a 90° cone, using tip trimmer W 164 and W 81.



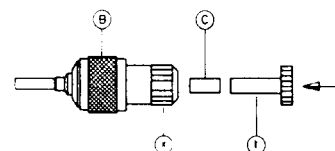
Check dimensions.



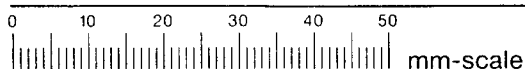
Push contact A onto contact holder W 67 and fix cable in soldering fixture W 58 as illustrated.
Use inserts W 59.
Heat contact pin A using a dry soldering iron.
Flow small amount of solder into bore hole of contact pin, introduce inner conductor of cable and solder to contact pin.
Clean contact pin A and cable dielectric, remove excess solder.



Slide connector housing B over cable and fix cable in fixture.
Tighten locator tool W 66 fully against connector body B.
Solder connector housing B to cable, avoid excessive heat, immediately cool down and clean with alcohol.



Screw body x of dielectric insert tool onto connector B.
Insert insulator C.
Push firmly with plunger t until flange bottoms on shoulder of body x.



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