

Assembly instruction Series BNC, TNC, N Nr. 9005

Tools and materials required:

Soldering iron 80 to 100 Watts/220-240°C
 Solder Sn/Pb 60/40 0,8mm Ø activated rosin flux
 Alcohol, brush, spanner AF. 9, blade (74-Z-0-0-68)
 SR cable stripping tool Nr. W 157
 Soldering fixture Nr. W 58
 Inserts Nr. W 59
 Locator tool Nr. W 66
 Tip Trimmer Nr. W 164
 Trim tool 74 Z 0-3-4
 Soldering gauge Nr. W 35 (0,45)
 Contact holder Nr. W 287 (BNC, TNC)
 Contact holder Nr. W 67 (N)

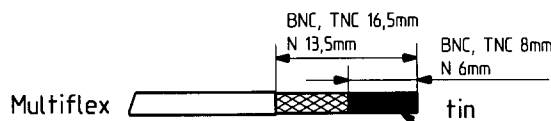
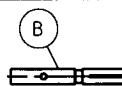
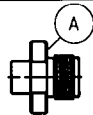
Straight connectors for EZ and Multiflex cable

cable entry: soldered

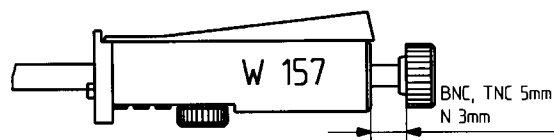
Connector types: (e.g.)

21 BNC-50-3-33	21 TNC-50-3-29	21 N-50-3-11
24 BNC-50-3-33	24 TNC-50-3-29	24 N-50-3-14
25 BNC-50-3-33	25 TNC-50-3-29	25 N-50-3-9

This connector is supplied in 3 parts.	Suitable cables: e.g.	EZ 141, (.141") / Multiflex 141
	Centre contact:	soldered
	Braid:	soldered



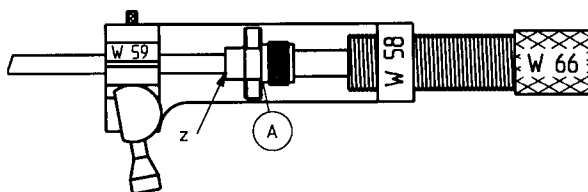
Prepare Multiflex cable according to diagram.
 Lightly tin braid according to diagram.
 Use appropriate shrink tube for strain relief. (FEB 73 Z-0-0-300)



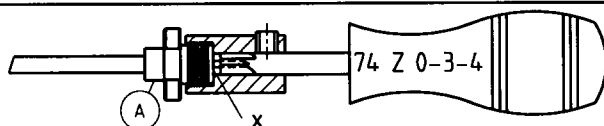
Cut cable end perpendicular to cable axis. Cut back copper jacket / braid using cable stripping tool W 157.
 See instruction sheet No. 9144 for detailed description.
 The tool must be set for (according to diagram) stripping dimension.



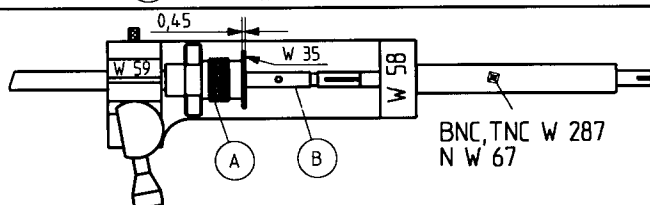
Remove dielectric flush with copper jacket / braid using a blade. Form tip of inner conductor to a 90° cone using tip trimmer W 164.



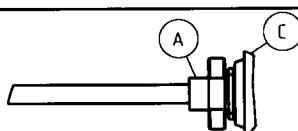
Slide nut A over cable. Fix cable in soldering fixture W 58 using inserts W 59. Tighten locator tool W 66 fully against cable. Push nut A against locator tool W 66 and solder in this position. Immediately cool down and clean with alcohol.



Place prepared cable in trim tool 74 Z-0-3-4 as illustrated. Rotate trim tool to remove protruding dielectric and copper jacket until flush with nut A. IMPORTANT: Prior to this operation the cable must be cooled down to room temperature.



Push centre contact B onto contact holder (according to diagram) and fix cable in soldering fixture W 58 as illustrated. Use inserts W 59. Place soldering gauge W 35 on inner conductor B as illustrated. Push contact holder W 67 against soldering gauge and solder. Remove cable from fixture and clean solder joint with alcohol.



Carefully screw body C into nut A using a spanner AF.9mm.
 (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

Deutscher Text: siehe Rückseite