

# Assembly instruction

# Series N, PC7 N9 No. 9006

## 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 (74Z-0-0-68)  
 SR cable stripping tool No. W157  
 Soldering fixture No. W58  
 Inserts No. W59  
 Locator tool No. W66  
 Tip trimmer No. W64  
 Trim tool No. W3-4  
 Spanners 9 mm and 14 mm  
 Positioner No. W81 (for W64)

## Straight connectors for copper jacket cable

**Cable entry:** soldered

### Connector types: (e.g.)

11N-50-3-51      11PC7-50-3-2  
 21N-50-3-51

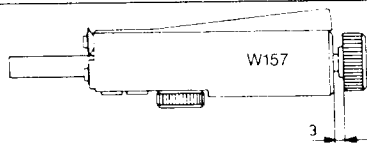
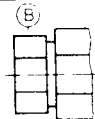
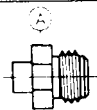
This connector  
 is supplied  
 in 2 parts

**Suitable cables e.g.**

**Braid:**

RG 402/U  
 SR3

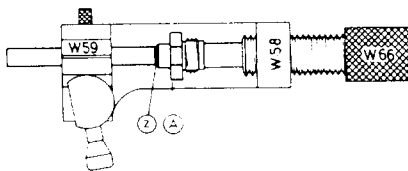
soldered



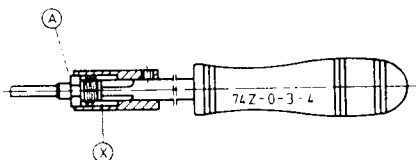
Cut cable end perpendicular to cable axis.  
 Cut back copper jacket using cable stripping tool W157.  
 See instruction sheet No. 9054 for detailed description.  
 The tool must be set for 3 mm stripping dimension.



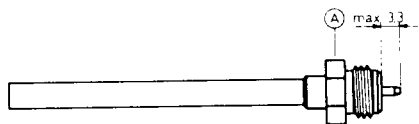
Remove dielectric flush with copper jacket using a blade.  
 Form tip of inner conductor to a 90° cone using tip trimmer W64 and W81.  
 Check dimension 3 mm.



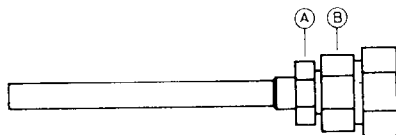
Slide connector part A over cable.  
 Fix cable in soldering fixture W58 using inserts W59.  
 Tighten locator tool W66 fully against cable.  
 Push connector part A against locator tool W66 and solder in this position.  
 Immediately cool down and clean with alcohol.



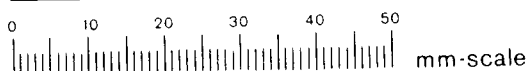
Place prepared cable in trim tool W3-4 as illustrated.  
 Rotate trim tool to remove protruding dielectric and copper jacket until flush with body.  
 Important: This operation must be performed only after the cable has reached temperature stability at room temperature!



Check dimension 3.3 mm, centre conductor must be exactly centred.



Carefully screw body A into connector housing B using a 9 mm and a 14 mm spanner.



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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