

# Assembly instruction Series C,N

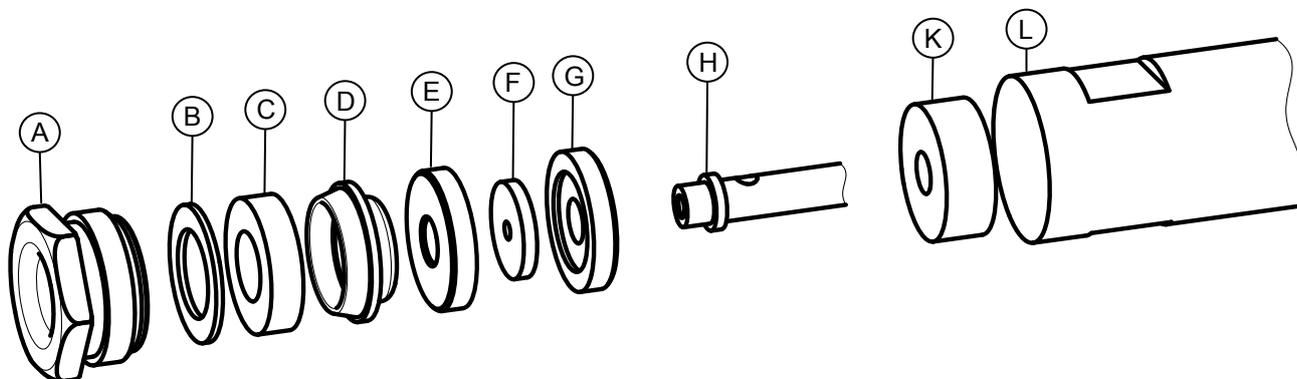
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Old instruction No. 3017



|                         |   |                          |          |
|-------------------------|---|--------------------------|----------|
| Connector type: (e.g.)  | 25_C-50-3-4 / 25_N-50-3-4 / 11_N-50-3-5 | Inner conductor contact: | soldered |
| Suitable cables: (e.g.) | RG_58_C/U / RG_223_U / K_02252_D        | Outer conductor contact: | screwed  |

## Parts list connector:



## Assembly steps:

| Picture | Process  | Feature / Check  | Tools required                           |
|---------|--|--|--|
|         | <p>Slide nut A, washer B and gasket C onto cable. Prepare cable according to diagram.</p>  | <p>Do not damage braid!</p>  | <p>Stanley blade<br/>Scissors</p>        |
|         | <p>Push braid back slightly to expose dielectric and cut back dielectric 5.5 mm perpendicular to cable axis<br/>Taper braid towards inner conductor. Position braid clamp D so that its shoulder fits against cable sheath. Fold back braid over clamp D and trim overlapping braid.</p> | <p>Do not damage inner conductor.<br/>Check dimension of 1.5 ± 0.3 mm.</p> | <p>Stanley blade<br/>Scissors</p>        |
|         | <p>Position bushing E, insulator F and G. Heat inner contact H using a soldering iron and flow small amount of solder into bore X.<br/>Push cable inner conductor into bore, immediately remove soldering iron to prevent melting of the dielectric.</p>                                 |  | <p>Soldering iron (150 W)<br/>Solder</p> |
|         | <p>Push prepared cable into connector body L, with front part of insulator K and tighten nut A.</p>  | <p>Torque 4 Nm.<br/>Do not rotate cable in connector body.</p>             | <p>Spanner 11 mm<br/>(74_Z-0-0-2)</p>    |

The cable assembly of R.F. connectors can only be done by well trained assembly stuff and suitable assembly equipment.  
Huber+Suhr's skilled stuff 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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| Revision  | C          |
| Date      | 15.06.2006 |
| Initiator | 4512/LAD   |