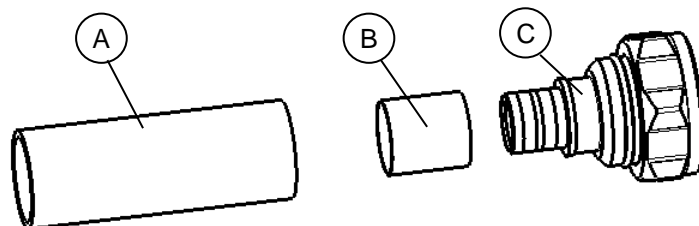




Connector type:	11_716-50-12-8	Inner conductor contact:	Plugged-in
Suitable cables:	SPUMA_600	Outer conductor contact:	Crimped (Cavity 14.5)

## Parts list connector:



## Assembly steps:

Picture	Process	Feature / Check	Tools required
	Slide shrink tube A and ferrule B onto cable. Prepare cable according to diagram. Chamfer inner conductor of cable (approx. 0.3 x 45°)	Do not damage inner conductor, dielectric and braid of cable. Remove skin of inner conductor! All residual of dielectric have to be removed. Ensure that the inner conductor of cable is straight. Ensure that the cone end is well formed.	Stanley blade Scissors File
	Splay out braid and insert cable in connector body C until stop.	Ensure that braid lies above the crimp neck and the foil enters the body C.	
	Important: Pin of the crimp insert <u>must be</u> inside of the crimp tool.		
	Slide ferrule B over braid and crimp as close to connector body C as possible.	During the crimping push the cable against body C.	Crimp tool: Cavity 14.5 For large crimp tool and table press use insert 76_Z-0-12-1
	Slide shrink tube A over ferrule B and shrink to connector body C. Dimension X max. 1mm.	For achieving better adhesive sealing of the shrinking tube, clean surfaces on body and cable, e.g. with Acetone. Avoid excessive heat. Heat Time 12-15 s. Glue of the shrink tube has to ooze out slightly on both sides.	Hot-air fan Acetone

The cable assembly of R.F. connectors can only be done by well trained assembly staff and suitable assembly equipment. Huber+Suhrner'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.

Revision	B
Date	14/06/2018
Initiator	1079/L YIN