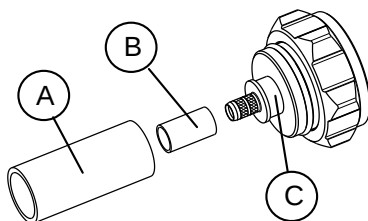


Assembly instruction Series 716 0000327739



Connector type:	11_716-50-4-5	Inner conductor contact:	Plugged-in
Suitable cables:	SX_4172-B-60 / LMR-240	Outer conductor contact:	Crimped (cavity C)

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	Slide tube A and ferrule B onto cable. Prepare cable according to diagram. Cut foil on same length as braid. From tip of centre contact to a 60° cone	Do not damage inner conductor, dielectric, foil and braid of cable.	Stanley blade Scissors Tip trimmer tool W 264
	Splay out braid and insert cable in connector body B until stop.	Ensure that braid lies above the crimp neck and the foil enters the body B.	
	Slide ferrule B over braid and crimp as close to connector body C as possible.	During the crimping push the cable against the body C.	Crimp tool: Cavity C For large crimp tool and table press use insert 76_Z-0-4-1. For small crimp tool use insert 76_Z-0-4-51
	Slide shrink tube A over ferrule B and shrink to connector body C. Dimension X=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 12-15s. 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 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.

Revision	B
Date	20.12.2013
Initiator	1077/quda

Old Assembly instruction No. :