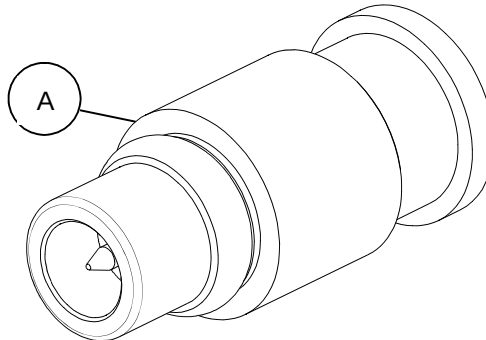


# Assembly instruction Series MMPX 0000317233



|                         |                |                                 |          |
|-------------------------|----------------|---------------------------------|----------|
| <b>Connector type:</b>  | 11_MMPX-50-2-3 | <b>Inner conductor contact:</b> | plugged  |
| <b>Suitable cables:</b> | MF 86          | <b>Outer conductor contact:</b> | soldered |

## Parts list connector:



## Assembly steps:

| Picture | Process                                                                                                                                                                                               | Feature / Check                                                                                                                                                                                                | Tools required                                                                                                                                                               |
|---------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|         | <p><u>For MF</u><br/>                     Dive the on length cutted cable in flux and tin. Cut jacket until screen. Remove jacket. Remove cable dielectric and tinned braid according to diagram.</p> | <p>The solder must flow at behind for min. 5 mm. If the cable does not fit into the cable entry, use a flat-nose plier to calibrate the outer contact. Do not damage centre contact, dielectric and braid.</p> |                                                                                                                                                                              |
|         | <p>Plug in the cable into the connector.</p> <p>Solder connector A to cable.</p>                                                                                                                      | <p>The plug-in process has to be done carefully.</p> <p>Avoid excessive heat.</p> <p>Immediately cool down and clean.</p>                                                                                      | <p>Locator tool W 454<br/>                     Soldering fixture W 442, W 58<br/>                     (W 442 recommended)<br/>                     Inserts W 364 (MF 86)</p> |

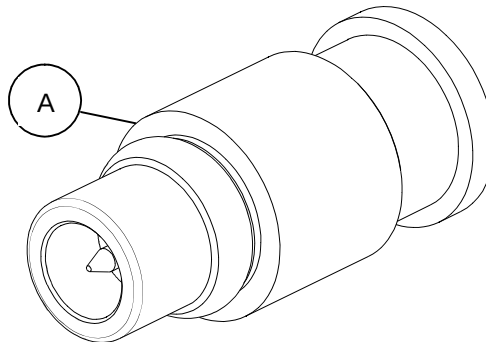
The cable assembly of R.F. connectors can only be done by well trained assembly stuff and suitable assembly equipment. Huber+Suhrner's skilled stuff and specialised equipment are available to carry out complete R.F. lead-assembly on your behalf. We mount your connectors on cables at economic prices! Please contact our representative for further details of this service.

|           |            |
|-----------|------------|
| Revision  | C          |
| Date      | 23.10.2009 |
| Initiator | 4021/BEH   |



|                         |                |                                    |          |
|-------------------------|----------------|------------------------------------|----------|
| <b>Verbinder-Typ:</b>   | 11_MMPX-50-2-3 | <b>Innenleiter Kontaktierung:</b>  | gesteckt |
| <b>Geeignete Kabel:</b> | MF 86          | <b>Aussenleiter Kontaktierung:</b> | gelötet  |

## Stückliste Verbinder:



## Montage Schritte:

| Bild | Prozess                                                                                                                  | Merkmal / Prüfung                                                                                                                                                                                                                                                    | Werkzeuge                                                                                                  |
|------|--------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------|
|      | <p>Für MF<br/>Kabel stirnseitig in<br/>Flussmittel tauchen und<br/>verzinne. Kabel<br/>gemäss Figur<br/>abisolieren.</p> | <p>Das Lot muss auf einer<br/>Länge von min. 5 mm<br/>nach hinten fliessen.<br/>Wenn das Kabel nicht in<br/>die Kabeinführung<br/>passt, verzinnten<br/>Aussenleiter mit<br/>Flachzange kalibrieren.<br/>Innenleiter und<br/>Dielektrikum nicht<br/>beschädigen.</p> |                                                                                                            |
|      | <p>Kabel in Verbinder<br/>einstecken.</p> <p>Verbinder A mit Kabel<br/>verlöten.</p>                                     | <p>Steckvorgang vorsichtig<br/>ausführen.</p> <p>Lange Hitzeeinwirkung<br/>vermeiden.</p> <p>Sofort abkühlen und<br/>reinigen.</p>                                                                                                                                   | <p>Lötschraube W 454<br/>Lötvorrichtung W 442,<br/>W 58<br/>(W 442 empfohlen)<br/>Backen W 364 (MF 86)</p> |

Die Montage von HF-Verbindern kann nur durch geschultes Personal, das über die richtige Ausrüstung verfügt, erfolgen. Huber+Suhr verfügt über ausgebildete Fachkräfte und rationelle Einrichtungen zur Herstellung kompletter HF-Verbindungsleitungen. Wir montieren Ihre Verbinder zu wirtschaftlichen Preisen! Wenden Sie sich an unsere Vertreter.

|          |            |
|----------|------------|
| Version  | C          |
| Datum    | 23.10.2009 |
| Erstellt | 4021/BEH   |