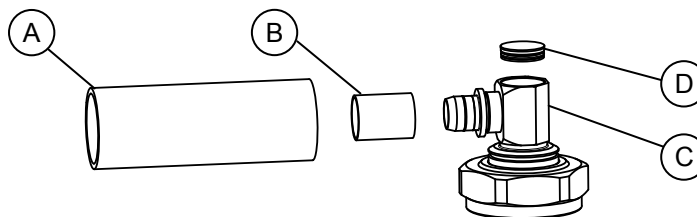


Assembly instruction Series 716 0000456388



Connector type:	16_716-50-7-15	Inner conductor contact:	Soldered
Suitable cables:	SPUMA-400-FR, LMR-400	Outer conductor contact:	Crimped (Cavity D)

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	<p>Prepare cable according diagram. Form tip of centre contact to a 90° cone. Cut foil on same length as braid.</p>	<p>Do not damage braid, dielectric, foil and centre contact of cable.</p>	<p>Stanley knife Scissors Tip trimmer tool W 264</p>
	<p>Slide shrink-tube A and ferrule B over the cable. Slightly Splay out braid and insert cable into body C until stop.</p>	<p>Ensure that braid lies above crimp neck.</p>	
	<p>Slide ferrule B over braid and crimp. Solder inner conductor to cable at X.</p>	<p>Crimp as close to connector body C as possible.</p>	<p>Crimp tool : Cavity D For large crimp tool and table press use Insert 76 Z-0-7-14</p>
	<p>Place cover D on rear aperture of body C. Press cap D into body C.</p>		<p>Using a soft hammer, a small press or a small bench vice.</p>
	<p>Slide shrink-tube A over body C and shrink close to connector body C. Dimension X max. 1mm.</p>	<p>Avoid excessive heat.</p>	<p>Hot-air fan</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.

Revision	B
Date	10.10.2014
Initiator	4954/PiS