

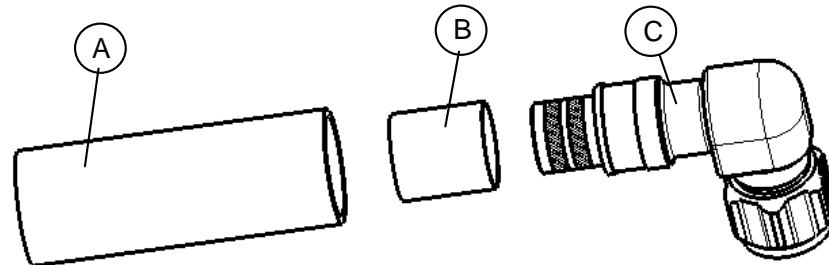
# Assembly instruction Series N

0000443228



Connector type:	16_N-50-12-12	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
	<p>Slide shrink tube A and ferrule B onto cable.</p> <p>Prepare cable according to diagram.</p> <p>Splay out braid and remove foil on same length as jacket.</p> <p>Chamfer inner conductor of cable (approx. 0.3 x 45°)</p>	<p>Do not damage inner conductor, dielectric and braid of cable.</p> <p>Remove skin of inner conductor!</p> <p>All residual of dielectric have to be removed.</p> <p>Ensure that the inner conductor of cable is straight.</p> <p>Ensure that the cone end is well formed.</p>	<p>Stanley blade</p> <p>Scissors</p> <p>File</p>
	<p>Splay out braid and insert cable in connector body C until stop.</p>	<p>Ensure that braid lies above the crimp neck and the foil enters the body C.</p>	
	<p>Important: Pin of the crimp insert <u>must be</u> inside of the crimp tool.</p>		
	<p>Slide ferrule B over braid and crimp as close to connector body C as possible.</p>	<p>During the crimping push the cable against body C.</p>	<p>Crimp tool: Cavity 14.5</p> <p>For large crimp tool and table press use insert 76_Z-0-12-1</p>
	<p>Slide shrink tube A over ferrule B and shrink to connector body C.</p> <p>Dimension X max. 1mm.</p>	<p>For achieving better adhesive sealing of the shrinking tube, clean surfaces on body and cable, e.g. with Acetone.</p> <p>Avoid excessive heat.</p> <p>Heat Time 12-15 s.</p> <p>Glue of the shrink tube has to ooze out slightly on both sides.</p>	<p>Hot-air fan</p> <p>Acetone</p>

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	C
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