

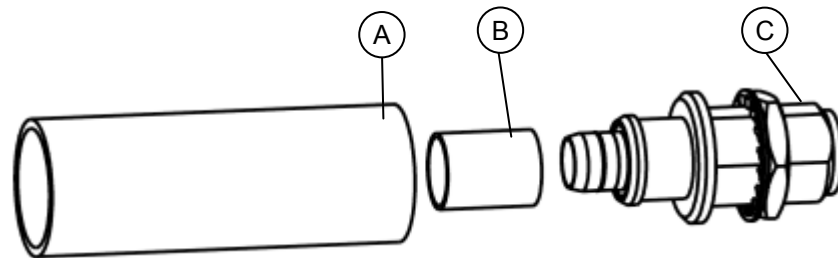
# Assembly instruction Series N

0000721787



|                  |              |                          |                   |
|------------------|--------------|--------------------------|-------------------|
| Connector type:  | 24_N-50-3-45 | Inner conductor contact: | Plugged-in        |
| Suitable cables: | SPUMA-195    | Outer conductor contact: | Crimped(Cavity B) |

## Parts list connector:



## Assembly steps:

| Picture | Process                                                                                           | Feature / Check                                                                                                                                                                                                            | Tools required                                                                                                                     |
|---------|---------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------|
|         | Slide ferrule B onto cable. Prepare cable according to diagram. Cut foil on same length as braid. | Do not damage inner conductor, dielectric, foil and braid of cable.                                                                                                                                                        | Stanley blade<br>Scissors                                                                                                          |
|         | Form tip of inner conductor of cable to a 60° cone.                                               | Ensure that the inner conductor of cable is straight. Ensure that the cone end is well formed.                                                                                                                             | Tip trimmer tool<br>W 264                                                                                                          |
|         | 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.                                                                                                                                                |                                                                                                                                    |
|         | 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 B<br>For large crimp tool and table press use insert 76_Z-0-3-1.<br>For small crimp tool use insert 76_Z-0-3-51 |
|         | 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<br>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.

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| Revision  | B          |
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| Initiator | 1079/L YIN |