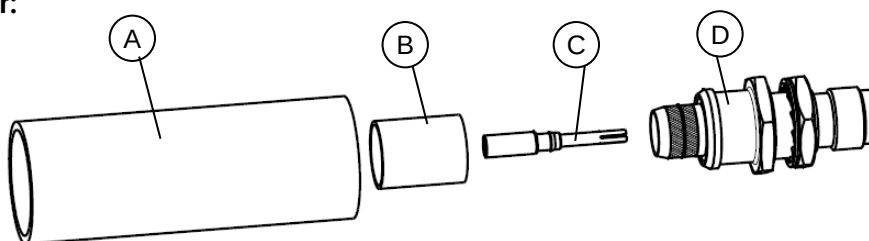


Assembly instruction Series TNC 0000452674



Connector type:	24_TNC-50-7-5	Inner conductor contact:	Crimped (Cavity 4)
Suitable cables:	SPUMA_400-FR, LMR 400	Outer conductor contact:	Crimped (Cavity D)

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	Slide shrink tube A and ferrule B onto cable. Prepare cable according to diagram. Cut foil on same length as dielectric.	Do not damage braid, dielectric, foil and inner conductor of cable	Stanley blade Scissors
	Push contact C over inner conductor of cable and crimp.	Contact C flush to dielectric.	Crimp tool : Cavity 4 For large crimp tool and table press use insert 76_Z-0-7-14.
	Splay out braid and insert cable into body D until stop.	Ensure that braid lies above the crimp neck. Foil must be pushed in bore hole.	
	Slide ferrule B over braid and crimp as close to connector body D as possible.	During the crimping push the cable against body D.	Crimp tool : Cavity D For large crimp tool and table press use insert 76_Z-0-7-14.
	Slide shrink tube A over ferrule B and connector body D till flange. 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 Acetone

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	B
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Initiator	4726/Bom