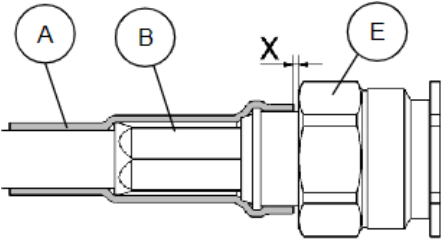


Assembly instruction Series TNC 0000719526

Connector type:	11_TNC-50-4-78	Inner conductor contact:	Crimped
Suitable cables:	SPUMA_240-RS-FR, SPUMA_240	Outer conductor contact:	Crimped
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.	Do not damage inner conductor and braid of cable.	Suitable stripping tool
	Push insulator C and contact D over inner conductor of cable and crimp at X.	Contact D and insulator C flush to the dielectric.	Coax Crimptool, HX4 (M6000112) Coax Crimptool, Inserts, Y206P (M6000113)
	Splay out braid and insert cable with contact D into body E until stop.	Ensure that braid lies above crimp neck and the foil enters the body E.	

	<p>Slide shrink tube A over ferrule B and shrink to connector body E. Dimension X ~ 1 mm.</p>	<p>Clean surfaces on body and cable. Avoid excessive heat. Glue of the shrink tube has to ooze out slightly on both sides.</p>	<p>f.e. Acetone Hot air fan</p>
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<p>The cable assembly of R.F. connectors can only be done by well trained assembly stuff and suitable assembly equipment. Huber+Suhner'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.</p>	<p>Revision Date Initiator</p>	<p>C 14.05.2019 4779/JPE</p>
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