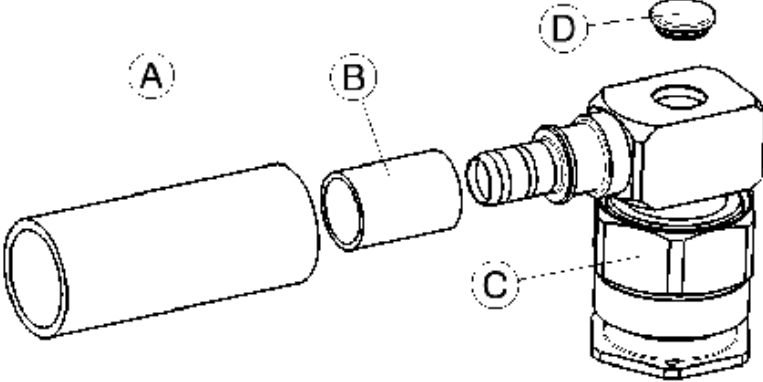
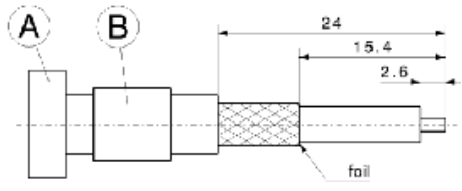
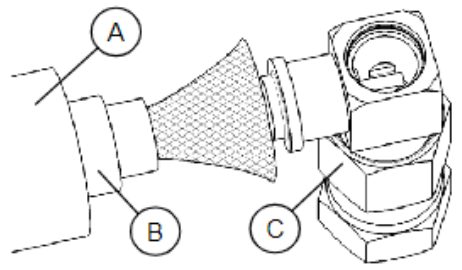
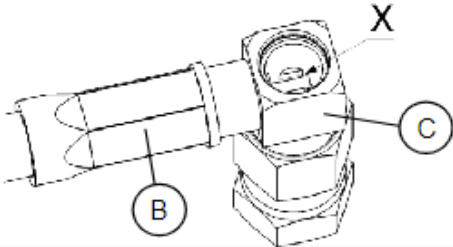
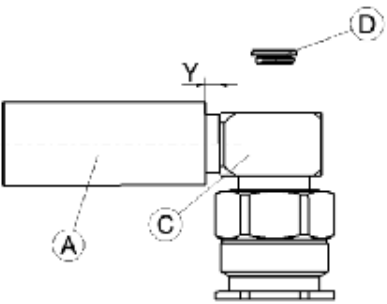


## Assembly instruction Series TNC 0000719588

<b>Connector type:</b>	16_TNC-50-4-22	<b>Inner conductor contact:</b>	Soldered
<b>Suitable cables:</b>	SPUMA_240-RS-FR, SPUMA_240, SPUMA_240-FR	<b>Outer conductor contact:</b>	Crimped
<b>Parts list connector:</b>			

<b>Assembly steps:</b>			
<b>Picture</b>	<b>Process</b>	<b>Feature/Check</b>	<b>Tools required</b>
	Slide shrink tube A and 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 Scissors
	Splay out braid and insert prepared cable in connector body C until stop.	Ensure that braid lies above the crimp neck and the foil enters the body C.	

	<p>Slide ferrule B over braid and crimp as close to connector body C as possible. Solder inner conductor to cable at X.</p>	<p>During the crimping push the cable against body C.</p>	<p>Coax Crimptool, HX4 (M6000112) Coax Crimptool, Inserts, Y206P (M6000113)</p>
	<p>Place cover D on rear aperture of body C. Press cover D into body C. Slide shrink tube A over ferrule B and shrink to connector body C. Dimension Y max. 1mm.</p>	<p>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.</p>	<p>Soft hammer, a small press or a small bench vice. Hot-air fan Acetone</p>

<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>B 30.11.2015 1076/F YANG</p>
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