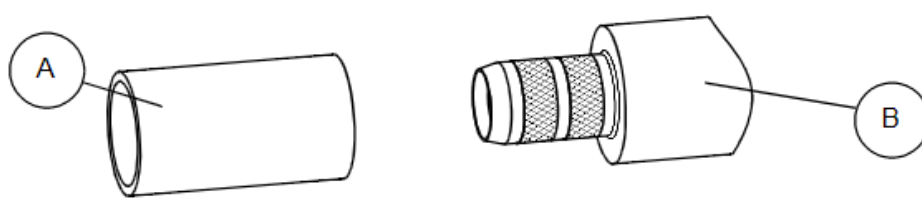
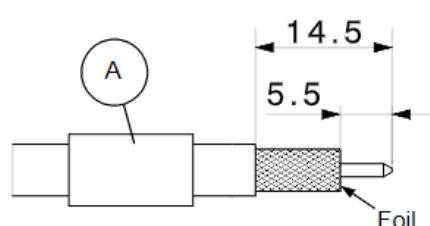
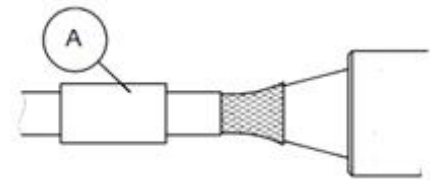
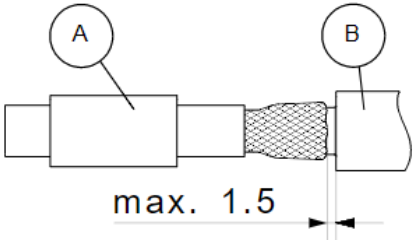
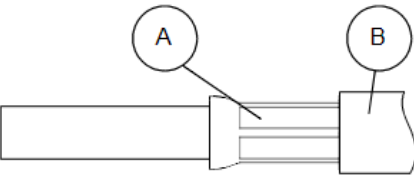
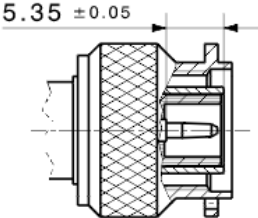


Assembly instruction Series SMA 0000179057

Connector type:	11_N-50-4-55, 24_N-50-4-53, 11_PC35-50-4-4, 21_PC35-50-4-4, 11_SMA-50-4-53, 21_SMA-50-4-52, 11_TNC-50-4-52, 24_TNC-50-4-52	Inner conductor contact:	Plugged-in
Suitable cables:	SPUMA_240-RS-FR, S 04272 B	Outer conductor contact:	Crimped
Parts list connector:			

Assembly steps:			
Picture	Process	Feature/Check	Tools required
	Slide ferrule A onto cable. Prepare cable according to diagram. Form tip of inner conductor to a 60° cone.	Do not damage inner conductor, dielectric, foil and braid of cable. Ensure that the inner conductor of cable is straight. Ensure that the cone end is well formed.	Stanley blade Scissors
	Splay out braid and calibrate foil.		

 <p>max. 1.5</p>	<p>Insert cable in connector body B.</p>	<p>Ensure that braid lies above the crimp neck and the foil enters the body B.</p>	
	<p>Slide ferrule A over braid and crimp</p>	<p>During the crimping push the cable against the body B. Crimp as close to connector body B as possible.</p>	<p>Coax Crimptool, HX4 (M6000112) Coax Crimptool, Inserts, Y206P (M6000113)</p>
 <p>5.35 ± 0.05</p> <p>11_TNC-50-4-52</p>	<p>Check interface dimension.</p>	<p>Distance shoulder of centre contact to reference plane.</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>G 29.05.2009 4952/WIS</p>
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