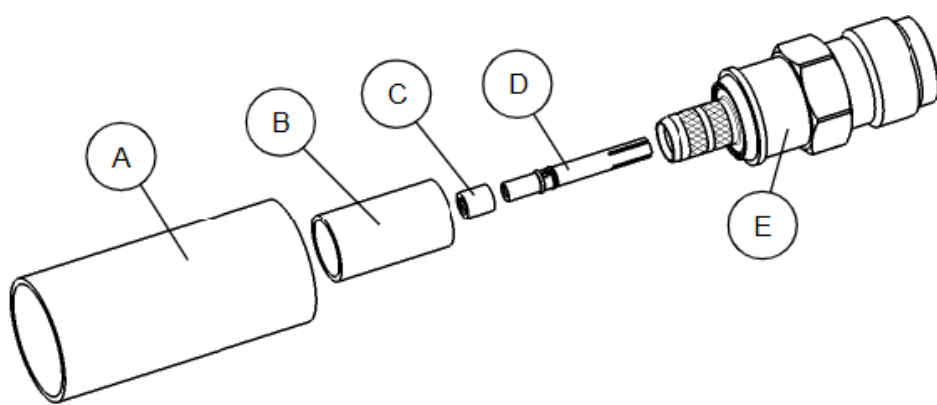
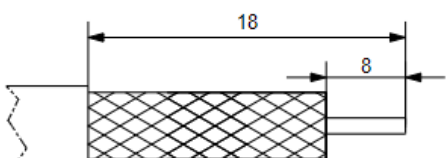
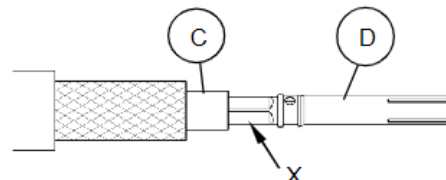
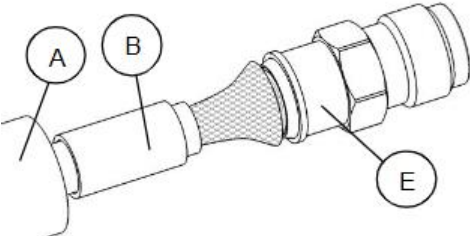
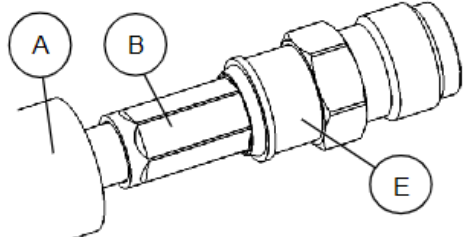
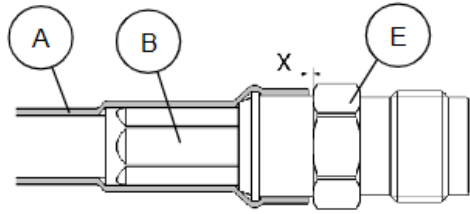


Assembly instruction Series TNC 0000900376

Connector type:	21_TNC-50-4-18	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.	
	Slide ferrule B over braid and crimp.	Crimp ferrule B as close to connector body E as possible.	Coax Crimptool, HX4 (M6000112) Coax Crimptool, Inserts, Y206P (M6000113)
	Slide shrink tube A over ferrule B and shrink to connector body E. Dimension X ~ 1 mm.	Clean surfaces on body and cable. Avoid excessive heat. Glue of the shrink tube has to ooze out slightly on both sides.	f.e. Acetone Hot air fan

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.	Revision Date Initiator	B 22.01.2021 4884/TIS
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