

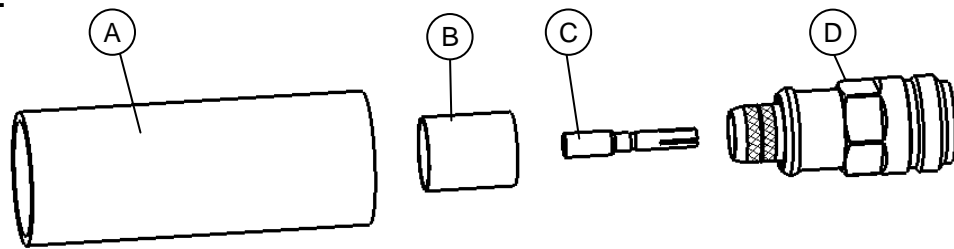
# Assembly instruction Series N

0000344575



Connector type:	21_N-50-7-32	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 braid.	Do not damage braid, dielectric and inner conductor of cable	Stanley blade Scissors
	Push contact C over inner conductor of cable and crimp at X.	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 in connector 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 shrink to connector body D. 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 staff and suitable assembly equipment. Huber+Suhr's skilled staff 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	C
Date	10.07.2017
Initiator	1079/ L YIN