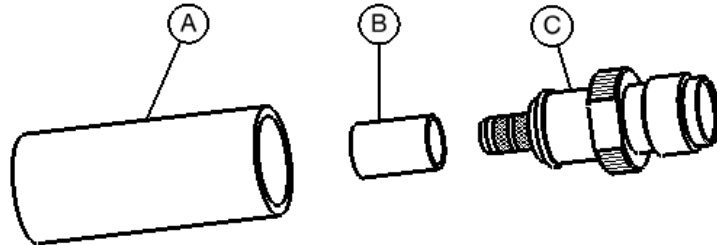


Assembly instruction Series TNC 0000347534



Connector type:	21_TNC-50-4-16	Inner conductor contact:	Plugged-in
Suitable cables:	SX_4172-B-60 / LMR-240	Outer conductor contact:	Crimped

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	<p>Slide shrink tube A and ferrule B onto cable. Prepare cable according to diagram. Cut foil on same length as braid.</p>	<p>Do not damage inner conductor, dielectric, foil and braid of cable.</p>	<p>Stanley blade Scissors</p>
	<p>Form tip of inner conductor of cable to a 60° cone.</p>	<p>Ensure that the inner conductor of cable is straight. Ensure that the cone end is well formed.</p>	<p>Tip trimmer tool W 264</p>
	<p>Splay out braid and insert cable in connector body C until stop.</p>	<p>Ensure that braid lies above the crimp neck and the foil enters the body C.</p>	
	<p>Slide ferrule B over braid and crimp as close to connector body C as possible.</p>	<p>During the crimping push the cable against the body C.</p>	<p>Crimp tool: Cavity 6.5 For large crimp tool and table press use insert 76_Z-0-4-18.</p>
	<p>Slide shrink tube A over ferrule B and shrink to connector body C. Dimension Xmax. 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>Hot-air fan Acetone</p>

The cable assembly of R.F. connectors can only be done by well trained assembly staff and suitable assembly equipment. Huber+Suhrner'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	B
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Initiator	1064 / Jane