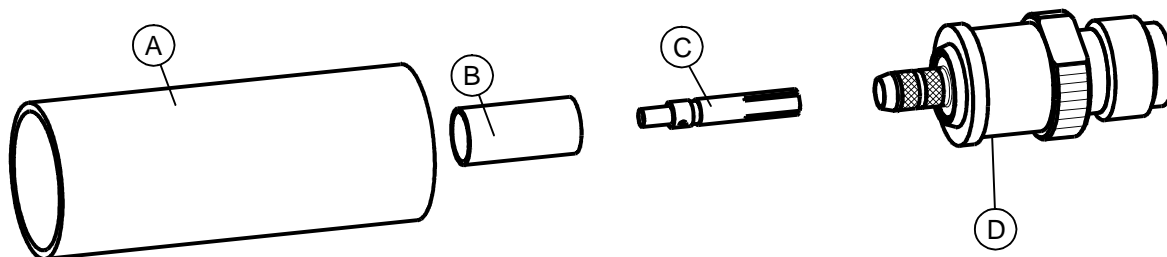


Assembly instruction Series TNC 0000344856



Connector type:	21_TNC-50-3-17	Inner conductor contact:	Crimped(Cavity 2)
Suitable cables:	EF 400 , RG 400/U	Outer conductor contact:	Crimped(Cavity 8)

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, dielectric and braid of cable.	Stanley blade Scissors
	Push contact C over inner conductor of cable and crimp	Contact C flush to dielectric	Crimp tool: 2 For large crimp tool and table press use insert 76_Z-0-3-1 For small crimp tool use insert 76_Z-0-3-51
	Splay out braid and insert contact C into connector body D until stop	Ensure that braid lies above crimp neck	
	Slide Ferrule B over braid and crimp	Crimp as close to connector body D as possible	Crimp tool: B For large crimp tool and table press use insert 76_Z-0-3-1 For small crimp tool use insert 76_Z-0-3-51
	Slide shrink tube A over ferrule B and shrink to connector body D. Dimension X max. 1 mm.	For achieving better adhesive sealing of the shrinking tube, clean surfaces on body and cable ,e.g. with Acetone. Avoid excessive heat. Heat Time 12-15s. 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 stuff and suitable assembly equipment. Huber+Suhr'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	B
Date	Sep. 8, 2010
Initiator	46871/WAJ