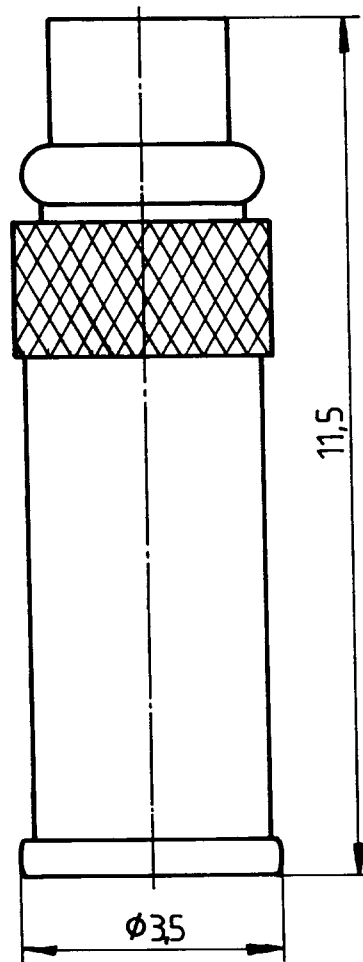


11MMCX 50-1-3c

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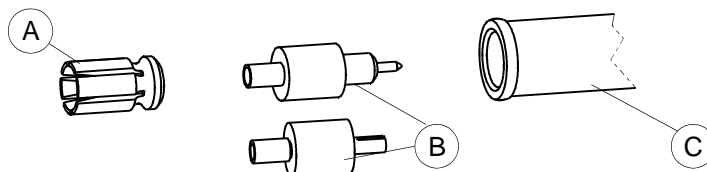
Assembly instruction Series MMCX 0000180922



Old Assembly instruction No. 09078

Connector type:	11_MMCX-50-1-3 ; 24_MMCX-50-1-3	Inner conductor contact:	Crimped
Suitable cables:	EZ_47, SUCOFORM_47	Outer conductor contact:	Soldered

Parts list connector:



Assembly steps:

Picture	Process	Feature / Check	Tools required
	<p>For EZ and SUCOFORM Prepare cable according to diagram.</p> <p>Dimension 11 mm applies to SUCOFORM with jacket.</p>	<p>Cut cable end perpendicular to cable axis.</p> <p>Do not damage centre contact, dielectric and braid.</p>	<p>Stripping tool W 157. See instruction sheet DOC-0000199604 for detailed description.</p> <p>Stanley blade</p>
	<p>Slide ferrule A over the cable and seat firmly against cable jacket.</p>		
	<p>Push contact B over inner conductor of cable to about cable dielectric and crimp.</p>	<p>Contact B flush to dielectric.</p>	<p>Crimp tool : 76_Z-0-2-53 Cavity : (1) 0.75</p>
	<p>Push prepared cable into connector body C until stop.</p> <p>Tighten locator tool W 61 against to body C and solder.</p>	<p>Avoid excessive heat.</p> <p>Promptly swap soldered area with alcohol to cool joint and remove any residual flux.</p>	<p>Soldering iron Solder Alcohol Soldering fixture : W 58 Locator tool : W 61</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	C
Date	06.02.2012
Initiator	4779/JPE

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