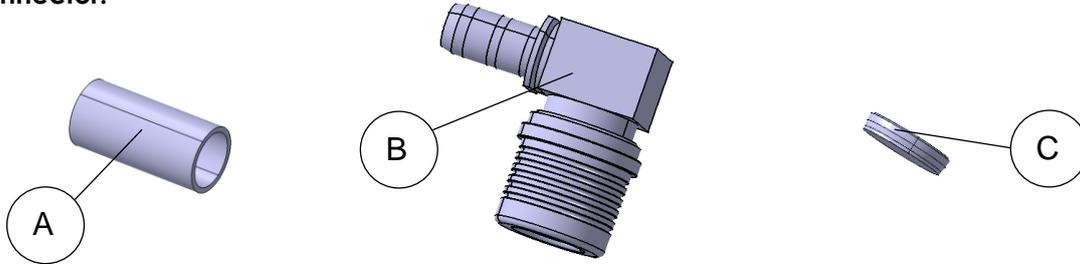


Assembly instruction Series QMA 0000196741

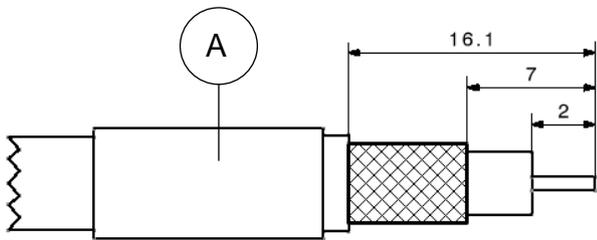


Tools and materials required: Stanley-blade ; Scissors Soldering iron 80 to 100 Watts 200 – 240 °C Solder, activated rosin flux Soft hammer, small bench vice Locator tool W360 Crimp tool B	Connector type:	16 QMA-50-3-4
	Suitable cables:	L45466-B14-C25
	Inner conductor contact:	soldered
	Outer conductor contact:	cavity B
	Crimp tool:	2 B (orange)

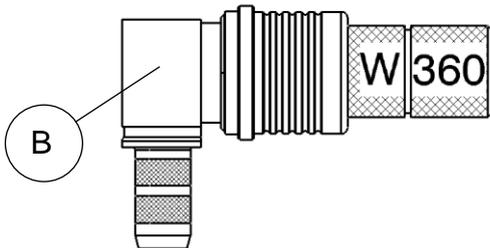
Parts list connector:



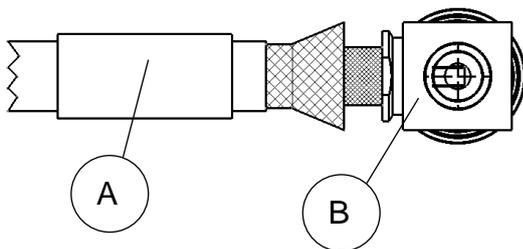
Assembly steps:



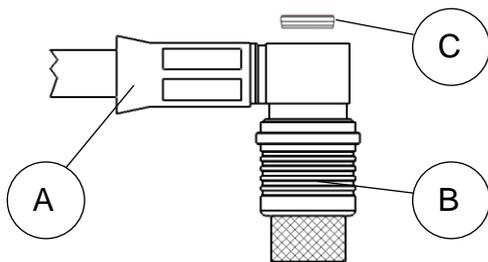
Slide ferrule A onto cable. Prepare cable according to diagram.
 Alulaminat foil prepare like cable.
 Caution: Centre contact, braid and dielectric do not damage.



Mount locator tool W 360 into the body B.



Splay out braid and insert cable in connector body B.
 Caution: Ensure that braid lies above the crimp neck.
 Ensure that foil lies under the crimp neck.



Slide ferrule A over braid and crimp as close to connector body B as possible. Solder inner conductor to contact.
 Position assembly with locator tool downwards on a solid base. Please cover C on rear apertur of connector body B. carefully press cover C into connector body B using a soft hammer, a small press or a small bench vice. Remove locator tool.

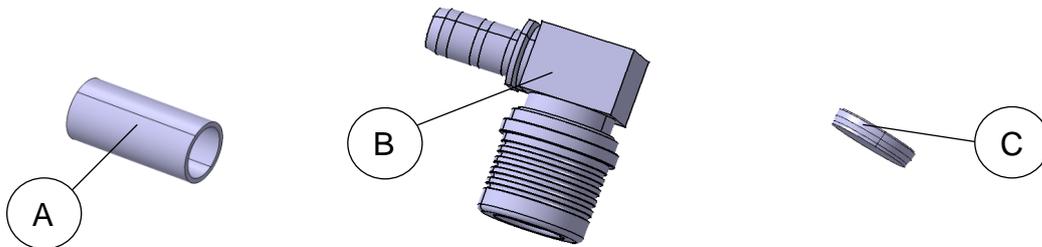
Huber+Suhr's skilled stuff and specialised equipment are available to carry out complete R.F. lead-assembly on your behalf. We mount your connectors on cables at economic prices! Please contact our representative for further details of this service.

Revision	F
Date	08.10.03
Initiator	4954/MOR

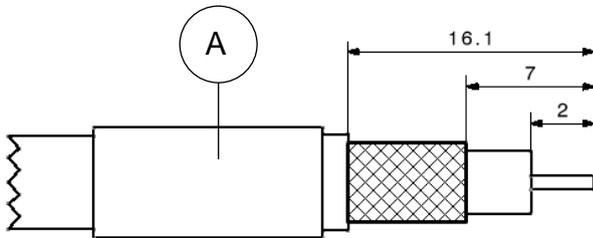


Benötigte Hilfsmittel: Stanley-Messer ; Schere Lötkolben, ca 80-100 Watt 200 – 240 °C Lötzinn, aktiviertes Kolophonium Nylonhammer, Schraubstock Montagelehre W360 Klemmzange mit Einsatz B	Verbinder Typ:	16 QMA-50-3-4
	Geeignetes Kabel:	L45466-B14-C25
	Innenleiter:	gelötet
	Aussenleiter:	Aussparung B
	Klemmwerkzeug:	2 B (orange)

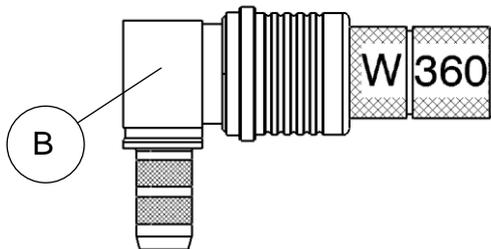
Stückliste Verbinder:



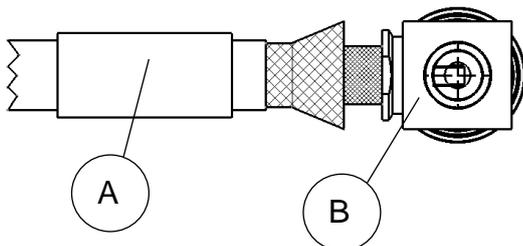
Montage Schritte :



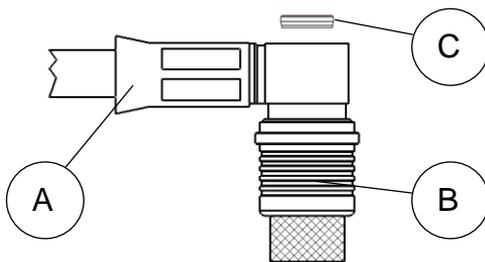
Hülse A auf Kabel schieben. Kabel abisolieren gemäss Figur.
 Aluminium Folie gleich wie Abschirmung abisolieren.
 Achtung: Innenleiter, Abschirmung und Dielektrikum nicht beschädigen.



Montagelehre W 360 in Gehäuse B stecken.



Abschirmung leicht aufspreizen und Kabel in Gehäuse B stecken.
 Achtung: Abschirmung muss über Crimphals liegen.
 Folie muss unter Crimphals liegen.



Hülse A über Abschirmung schieben und möglichst nahe am Gehäuse B klemmen. Innenleiter mit Kontakt verlöten.
 Montierter Stecker mit Montagelehre nach unten auf Unterlage stellen. Deckel C auf Oeffnung in Gehäuse B legen. Deckel C mit Presse, Nylonhammer oder Schraubstock einpressen. Montagelehre entfernen.