

# Assembly instruction Series QMA AC 11.06.02 4101/HAN No. 27444

## Tools and materials required:

Soldering iron 80-100 Watt  
Solder, activated rosin flux  
Alcohol, brush, blade (74 Z 0-0-68)  
Soft hammer, small press or small bench vice  
SR cabel stripping tool No. W 157  
Locator tool W 360

Angle plug for EZ / Sucoform / Multiflex

Cable entry: soldered

Connector types: (e.g.)

16 QMA-50-2-3

16 QMA-50-3-3

EZ 86

EZ 141

Sucoform 86

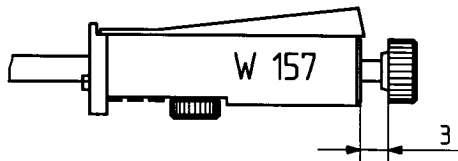
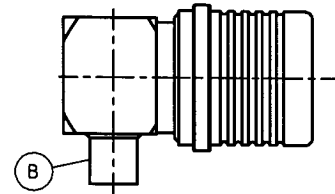
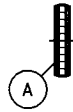
Sucoform 141

Multiflex 86

Multiflex 141

Suitable  
cables: e.g.

This connector  
is supplied in  
2 parts.

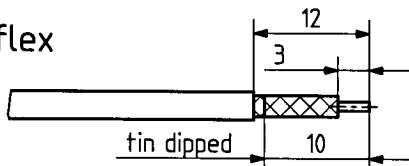


Cut cable end perpendicular to cable axis.  
Cut back copper jacket / braid using cable stripping tool W 157.  
See instruction sheet No. 9144 for detailed description.  
The tool must be set for 3 mm stripping dimension.

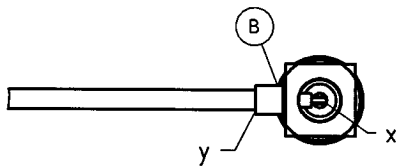
Sucoform / EZ



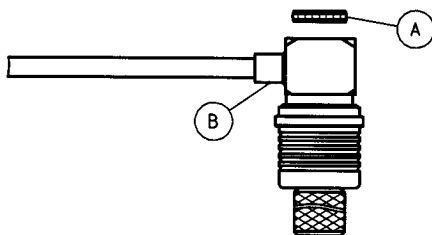
Multiflex



Lightly tin braid according to diagram.  
Remove dielectric flush with braid  
Form tip of inner conductor to a 90° cone  
Check dimension 2,5mm



Slide prepared cable into connector body B.  
Solder connector body B to copper jacket at point y.  
Promptly swab soldered area with alcohol to cool joint and remove any residual flux.  
Solder inner conductor to contact pin at point x, slot has to be filled up with solder.



Mount locator tool W 360 into body B.  
Position assembly with locator tool downwards on a solid base.  
Place cover A on rear apertur of connector body B. Carefully press cover A into connector body B using a soft hammer, a small press, or a small bench vice. Remove locator tool.

SUHNER'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



HUBER + SUHNER AG CH-9100 HERISAU

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