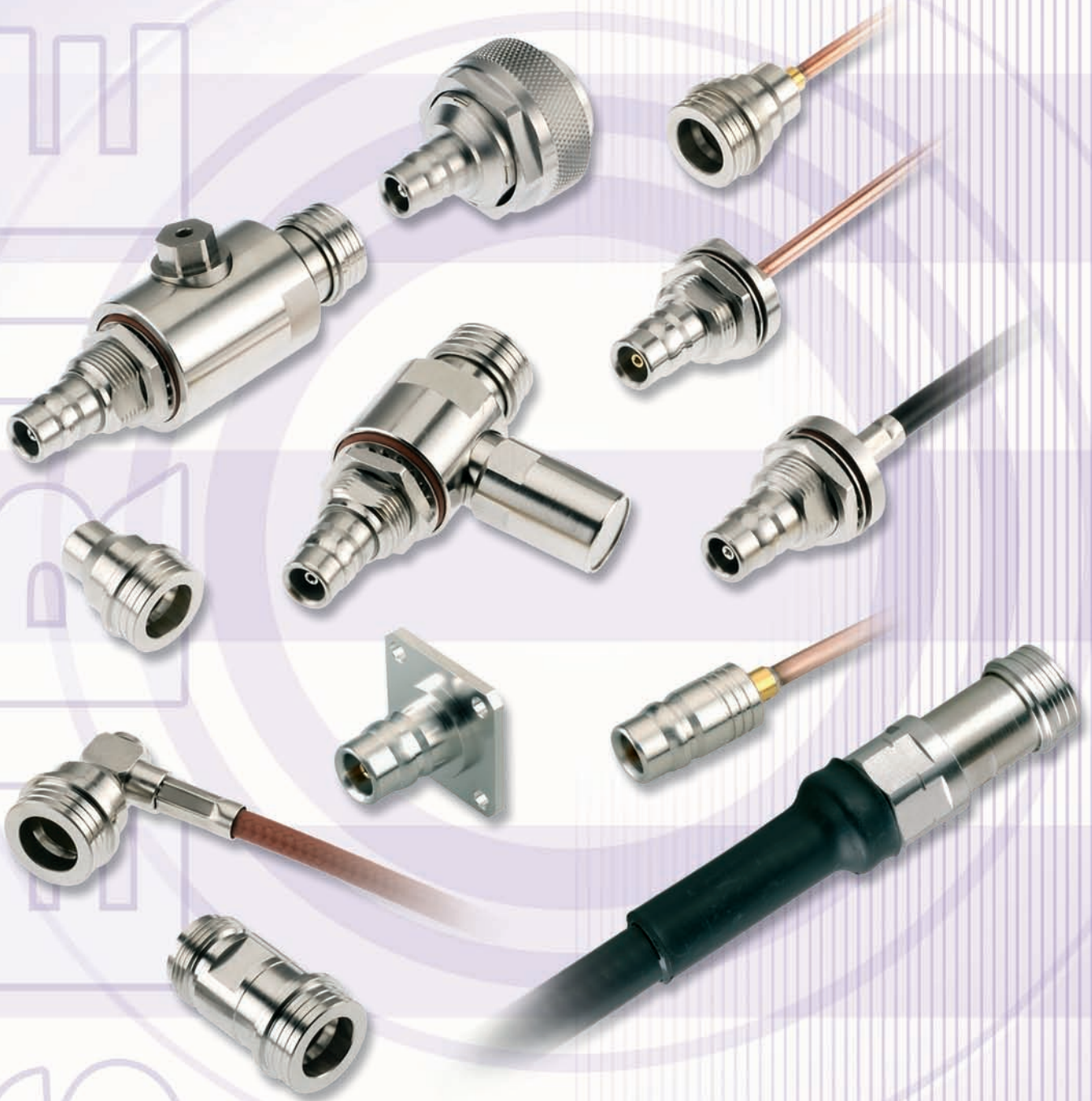
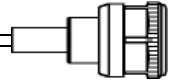


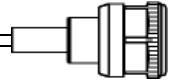
QN series

RI64





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Receptacles packaging.....	18
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The "Quick Lock Formula[®]"

QMA and QN connectors, patented products, become some real standard for the RF Telecommunications industry.

The "QLF[®]" trademark, **Quick Lock Formula[®]**, standard applies to QMA and QN series and guarantees the full intermateability between suppliers using this trademark. Using QLF certified connectors also guarantees the high level of performance of the RF transmission.

QN connectors (Quick Lock N) and QMA (Quick Lock SMA) enable fast, secured and easy matings with minimum space requirements. The QN and QMA series are the perfect alternative to N and SMA connectors in new generation telecommunication systems as well as in many other RF applications



QN series

Exhibiting the same operating frequency range as N series between **DC and 11 GHz**, the new QN series performance has been **optimized from DC to 6 GHz** for **50 Ω** applications.

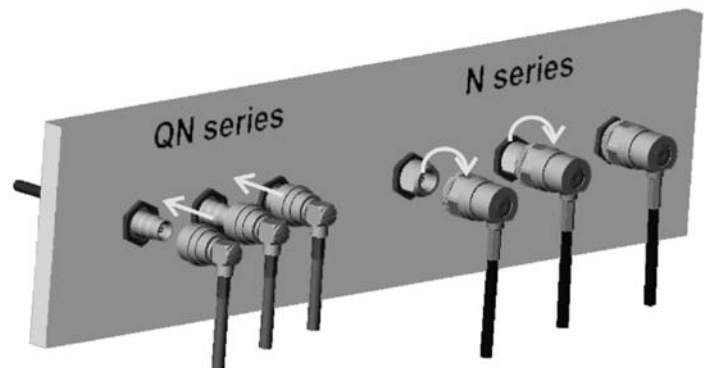
The new QN interface typically features a VSWR of 1.052 from DC to 3 GHz and 1.12 from 3 to 6 GHz. The corresponding return loss is **32 dB from DC to 3 GHz** and **25 dB from 3 to 6 GHz**.

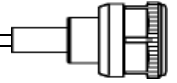
The high screening effectiveness enables a level of RF leakage as low as -90 dB from DC to 3 GHz and -80 dB from 3 to 6 GHz.

Designed for indoor and outdoor applications such as BTS, antenna systems or test and measurement devices, QN connectors offer very **good intermodulation level** (-155 dBC / -112 dBm) and an IP rating of **68** (water and dust protection). The power rating is **300 W at 2.5 GHz** and the engagement life is **100 matings**.

Saving installation time: 10 times faster

QN connectors are **10 times quicker** to connect compared to N connectors reducing the cost of ownership. With its snap-on interface, it takes only 2 seconds to connect QN connectors in field condition.





Space saving

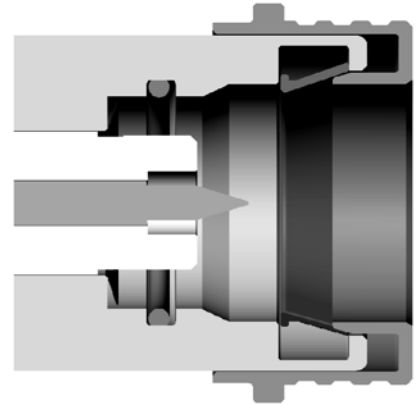
In new **high-density** applications, distance between connectors can be optimized on the panel compared to N models, as new QN ones require less space. The size of snap-on QN connectors is indeed smaller than corresponding usual screw-on N models and space for the use of a tool can be saved. The pitch between two QN connectors is only 20 mm compared to 40 mm minimum for N connectors.

Secure connection : Click !

QN connectors have a **positive locking system**. Applying an engagement force of 30N, you connect QN connectors. An audible click ensures a good connection. Pulling back, the decoupling nut opens the elastic ring allowing the deconnection with 30N. The retention force of the interface is 450N. QN connectors ensure a secure link and eliminate the risk of loose or overtorqued connections.

QN implementation

At anytime, you can switch from N to QN configuration as Panel drilling are the same. In addition, flange receptacles are available with N flange in order to replace N connectors or with TNC flange in order to optimize panel implementation.



Thanks to a snap-on interface, no torque wrench is required to connect QN connectors.

Cost saving

As no torque wrench is required, risk in damaging or scratching the panel is eliminated. Another advantage of the new QN series is that the cabled plugs can freely rotate around the panel jacks, avoiding any stress on the cable and allowing more flexibility during the mounting process.

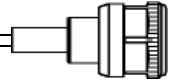
Adding all these advantages to the time saving, space saving and improvement of the quality of connection, QN connectors have a reduced cost of ownership compared to N connectors. **RADIALL QN is your cost effective solution for advanced RF interconnections !**

Range

Radiall offers a large range of QN connectors for indoor applications including straight and right angle plugs, bulkhead or flange jacks, receptacles, a full batch of adapters.

Our range also includes connectors for outdoor applications with its EZ Fit range for corrugated cables.

QN termination and lightning protectors are also available.



TEST/CHARACTERISTICS	VALUES/REMARKS
----------------------	----------------

ELECTRICAL CHARACTERISTICS

Impedance	50 Ω	
Frequency range	optimized working range	DC - 6 GHz DC - 11 GHz
Return loss typical	DC - 3 GHz 3 - 6 GHz	≥ 32 dB / 1.05 ≥ 25 dB / 1.12
Intermodulation	Better - 155 dBc (2 x 43 dBm)	
RF Leakage	100 MHz to 3 GHz better than - 90 dB 3 to 6 GHz better than - 80 dB	
Dielectric withstanding voltage in VRMS (interface) at sea level, 50 Hz	2500	
Working voltage in VRMS (interface) at sea level, 50 Hz	≤ 1000	
Insulation resistance	≥ 5.10 ³ MΩ	
Contact resistance	initial after test	Center contact ≤ 1 mΩ ≤ 1.5 mΩ Outer contact ≤ 0.25 mΩ ≤ 1 mΩ

MECHANICAL CHARACTERISTICS

Durability matings	≥ 100	
Force to engage and disengage	typical	40 N
Retention force for interface	≥ 450 N (101.25 Lbs)	
Bending moment admissible interface	≤ 10 Nm	
Contact captivation	cable connectors receptacles	≥ 28 N ≥ 18 N

ENVIRONMENTAL CHARACTERISTICS

Temperature range	- 55°C + 125°C	
Climatic category	40 /125/21 (IEC 60169 1 16.2)	
Shock	MIL STD 202F, method 213, condition I	
Rapid change of temperature	IEC 60169-1 16.4 (-40°C + 125°C)	
Corrosion salt spray	Test acc. to MIL STD 202F, method 101D, condition B	
Vibration	IEC 1169-1 paragraph 9.3.3 (10-500 Hz; 5g)	
Moisture resistance	MIL STD 202 F, method 106F	
Water resistance	IP 68	

MATERIALS

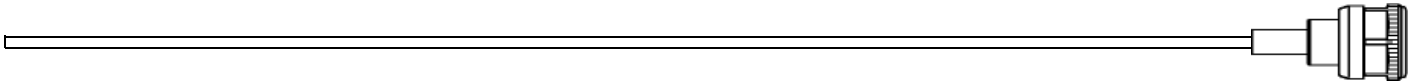
Body	Brass
Center contact	Brass /Beryllium copper
Outer contact	Beryllium copper
Insulator	PTFE
Others parts	Brass

PLATINGS

Body	BBR* over Silver
Center contacts	Silver passivated over copper
Outer contacts	BBR* over Silver
Others parts	BBR*

* Bright Bronze Radiall

All dimensions are given in mm



STRAIGHT PLUGS, FULL CRIMP TYPE, FOR FLEXIBLE CABLES

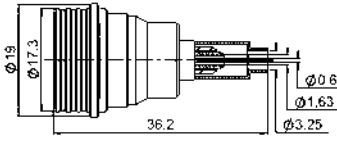


Fig. 1

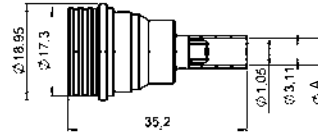


Fig. 2

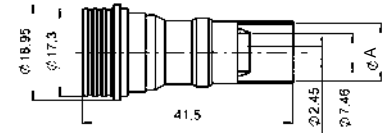


Fig. 3

Cable group	Part number	Fig.	Dimensions A (mm)	Captured center contact	Assembly instructions	Packaging
2.6/50/S	R164 072 020	1	-	no	M10	50 pieces (*)
5/50/S	R164 075 000	2	5.41			
5/50/D	R164 076 000		5.8			
10/50/S	R164 080 000	3	11.05			
11/50/D	R164 088 000		11.4			

STRAIGHT PLUGS, SOLDER TYPE, FOR SEMI-RIGID CABLES

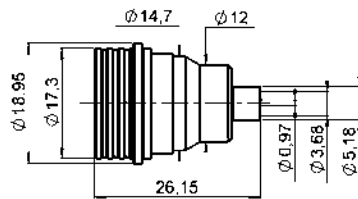


Fig. 1

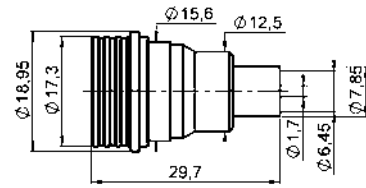
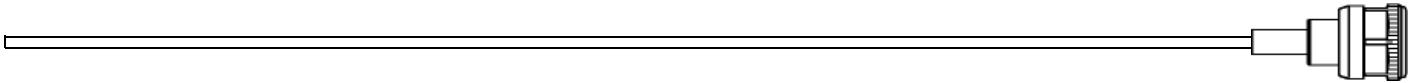


Fig. 2

Cable group	Part number	Fig.	Captured center contact	Assembly instructions	Packaging
.141"	R164 051 002	1	yes	M03	50 pieces (*)
.250"	R164 054 002	2	no	M04	

(*) For unit packaging, add «W» after the P/N



STRAIGHT PLUGS, EZ FIT TYPE, FOR CORRUGATED CABLES

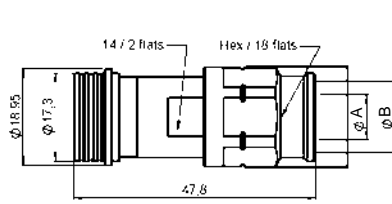


Fig. 1

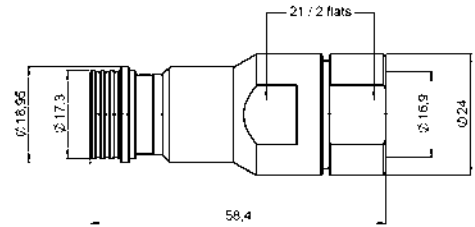


Fig. 2

Cable group	Part number	Fig.	Dimensions (mm)		Captured center contact	Assembly instructions	Packaging
			A	B			
3/8" superflexible corrugated	R164 036 000	1	7.1	11	yes	M07	unit
1/2" superflexible corrugated	R164 037 000		8.8	14			
1/2" flexible corrugated	R164 091 000	2	-	-		M08	

RIGHT ANGLE PLUGS, CRIMP TYPE, FOR FLEXIBLE CABLES

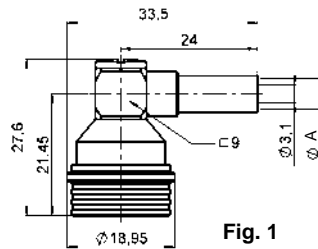


Fig. 1

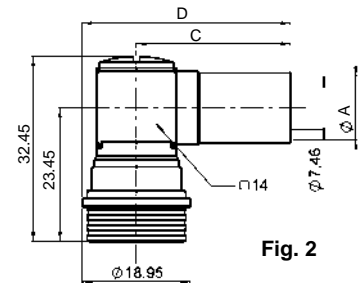
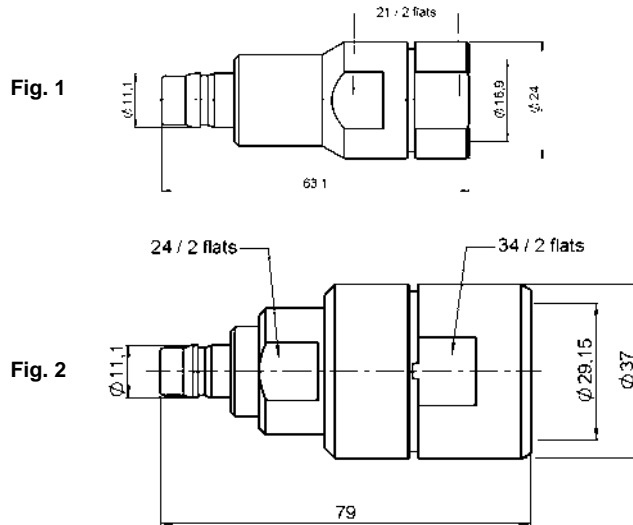


Fig. 2

Cable group	Part number	Fig.	Dimensions (mm)			Captured center contact	Assembly instructions	Packaging
			A	C	D			
5/50/S	R164 175 000	1	5.41	-	-	yes	M02	50 pieces (*)
5/50/D	R164 176 000		5.80	-	-			
10/50/S	R164 184 000	2	11.05	27	36.5			
11/50/D	R164 186 000		11.4	25	34.5			

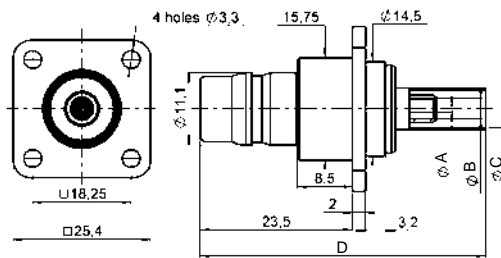
(*) For unit packaging, add «W» after the P/N

STRAIGHT JACKS, EZ FIT TYPE, FOR CORRUGATED CABLES



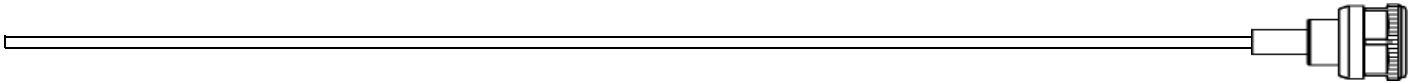
Cable group	Fig.	Part number	Captured center contact	Assembly instructions	Packaging
1/2" flexible corrugated	1	R164 230 000	yes	M05	unit
7/8" flexible corrugated	2	R164 231 000		M06	

25.4 mm SQUARE FLANGE, STRAIGHT JACKS, CRIMP TYPE, FOR FLEXIBLE CABLES

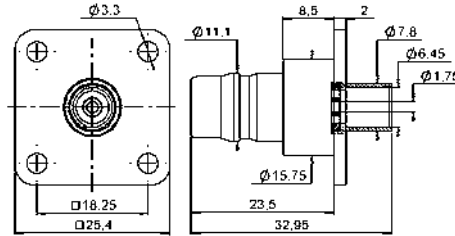


Cable group	Part number	Dimensions (mm)				Captured center contact	Assembly instructions	Panel drilling	Packaging
		A	B	C	D				
5/50/S	R164 282 000	1.05	3.11	5.41	44.1	no	M01	P05	50 pieces (*)
5/50/D	R164 283 000			5.8					
10/50/S	R164 286 000	2.45	7.46	11.05	46.1				
11/50/D	R164 286 200			11.4					

(*) For unit packaging, add «W» after the P/N

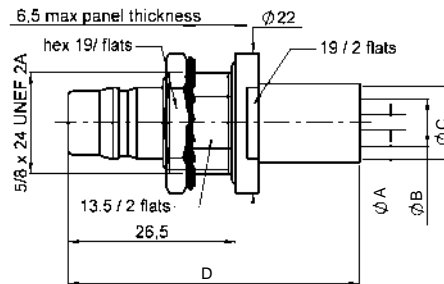


25.4 mm SQUARE FLANGE, STRAIGHT JACK, SOLDER TYPE, FOR SEMI-RIGID CABLE



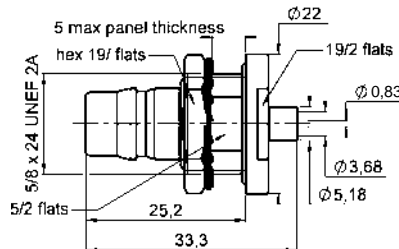
Cable group	Part number	Captured center contact	Assembly instructions	Panel drilling	Packaging
.250"	R164 278 302	yes	M04	P05	50 pieces (*)

BULKHEAD STRAIGHT JACKS, FULL CRIMP TYPE, FOR FLEXIBLE CABLES (panel sealed)



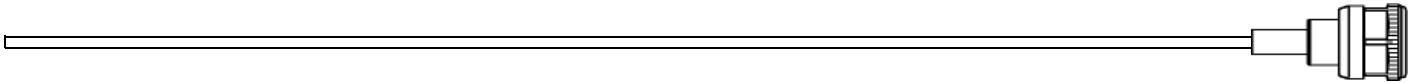
Cable group	Part number	Dimensions (mm)				Captured center contact	Assembly instructions	Panel drilling	Note	Packaging
		A	B	C	D					
5/50/S	R164 329 000	1.05	3.11	5.41	44.1	no	M01	P03	rear mount	50 pieces (*)
5/50/D	R164 329 200			5.8						
10/50/S	R164 331 000	2.45	7.46	11.05	46.1					
11/50/D	R164 331 200			11.4						

BULKHEAD STRAIGHT JACK, SOLDER TYPE, FOR SEMI-RIGID CABLE (panel sealed)

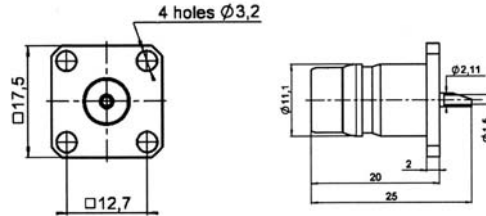


Cable group	Part number	Captured center contact	Assembly instructions	Panel drilling	Note	Packaging
.141"	R164 635 002	yes	M03	P03	rear mount	50 pieces (*)

(*) For unit packaging, add «W» after the P/N

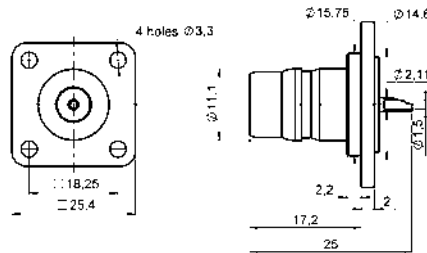


17.5 mm SQUARE FLANGE, STRAIGHT FEMALE RECEPTACLE



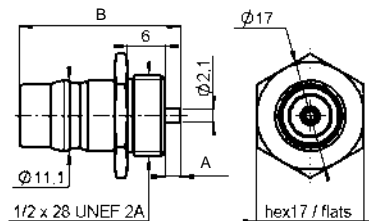
Part number	Captured center contact	Panel drilling	Note	Packaging
R164 418 000	yes	P01	solder pot	50 pieces (*)

25.4 mm SQUARE FLANGE, STRAIGHT FEMALE RECEPTACLE



Part number	Captured center contact	Panel drilling	Note	Packaging
R164 404 000	yes	P04	solder pot	50 pieces (*)

SCREW-ON RECEPTACLES FRONT MOUNTING



Part number	Dimensions (mm)		Captured center contact	Packaging
	A	B		
R164 571 027	2.5	25.5	yes	50 pieces (*)
R164 571 030	3.5	26.5		

(*) For unit packaging, add «W» after the P/N

PRESS-IN RECEPTACLES

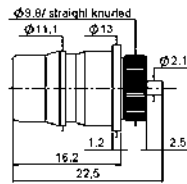


Fig. 1

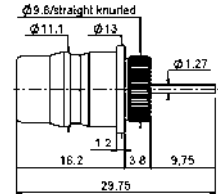
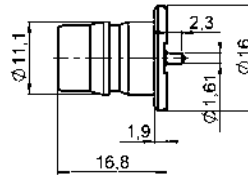


Fig. 2

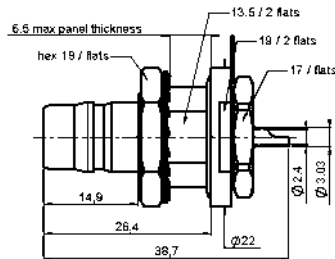
Part number	Fig	Captured center contact	Panel drilling	Packaging
R164 540 027	1	yes	P02	50 pieces (*)
R164 540 030	2			

SMT RECEPTACLE



Part number	Captured center contact	Assembly instructions	Note	Packaging
R164 501 023	yes	M11	circle flange	50 pieces (*)

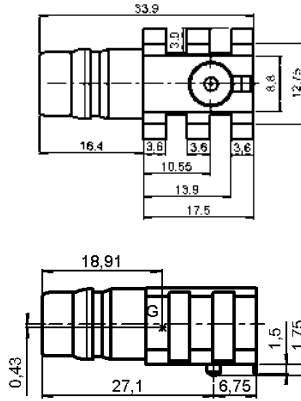
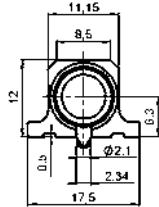
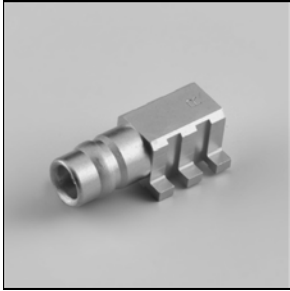
INSULATED JACK PANEL RECEPTACLE (seal rear mounting)



Part number	Captured center contact	Panel drilling	Packaging
R164 606 000	yes	P03	50 pieces (*)

(*) For unit packaging, add «W» after the P/N

RIGHT ANGLE SMT RECEPTACLE



Part number	Captured center contact	Assembly instructions	Packaging
R164 682 803	yes	M11	100 pieces (*)

IN SERIES ADAPTERS

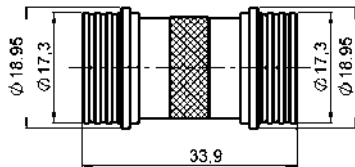


Fig. 1

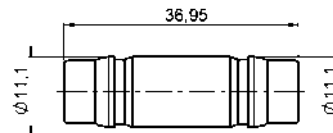


Fig. 2

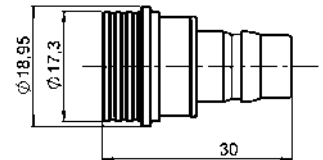


Fig. 3

Part number	Fig	Captured center contact	Note	Packaging
R164 703 000	1	yes	QN male - QN male	50 pieces (*)
R164 705 000	2		QN female - QN female	
R164 708 000	3		QN male - QN female	

(*) For unit packaging, add «W» after the P/N

BETWEEN SERIES ADAPTERS QN / N

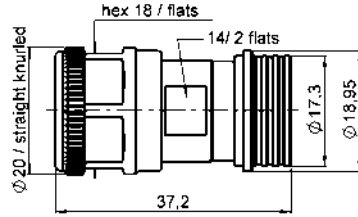


Fig. 1

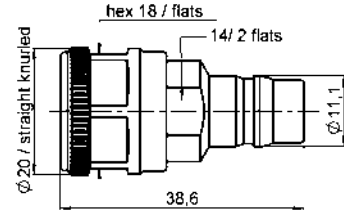


Fig. 2

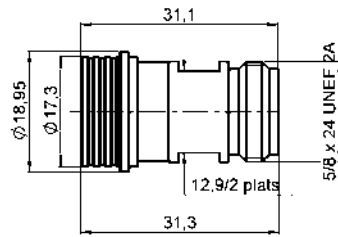


Fig. 3

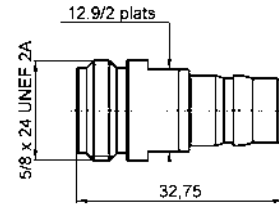


Fig. 4

Part number	Fig	Captured center contact	Note	Packaging
R191 757 000	1	yes	QN male - N male	unit
R191 758 000	2		QN female - N male	
R191 759 000	3		QN male - N female	
R191 760 000	4		QN female - N female	

BETWEEN SERIES ADAPTERS QN / 7/16

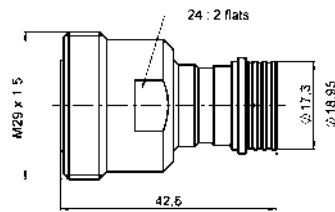


Fig. 1

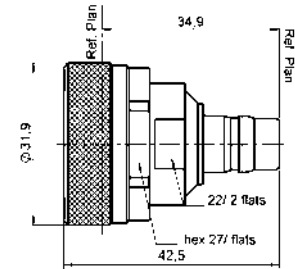


Fig. 2

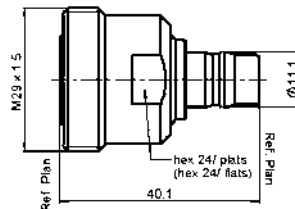


Fig. 3

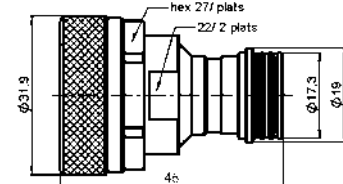
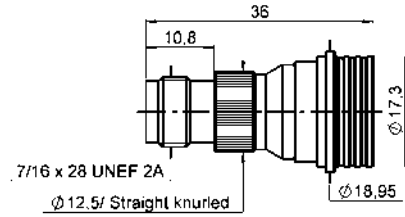
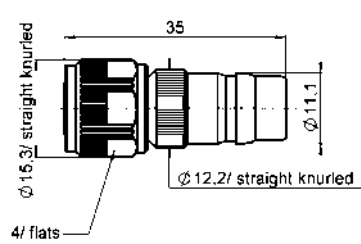


Fig. 4

Part number	Fig	Captured center contact	Note	Packaging
R191 922 000	1	yes	QN male - 7/16 female	unit
R191 923 000	2		QN female - 7/16 male	
R191 924 000	3		QN female - 7/16 female	
R191 925 000	4		QN male - 7/16 male	

BETWEEN SERIES ADAPTERS QN / TNC



Part number	Fig	Captured center contact	Note	Packaging
R191 507 000	1	yes	QN female - TNC male	unit
R191 508 000	2		QN male - TNC female	

PROTECTIVE CAPS

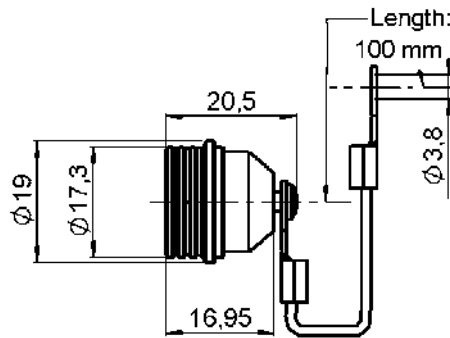


Fig. 1

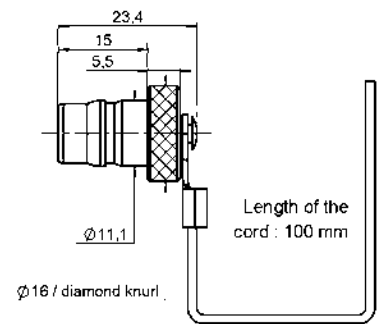
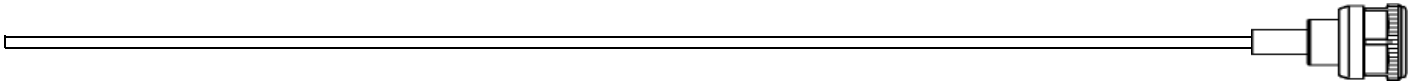
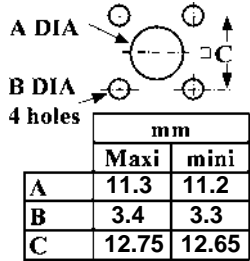


Fig. 2

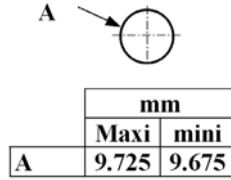
Part number	Fig	Designation
R164 804 000	1	Male
R164 844 000	2	Female



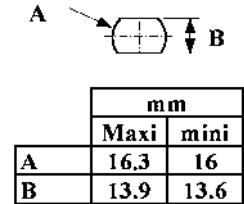
P01



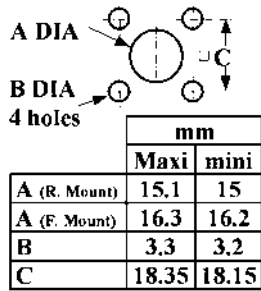
P02



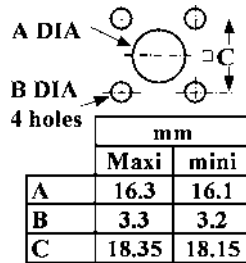
P03



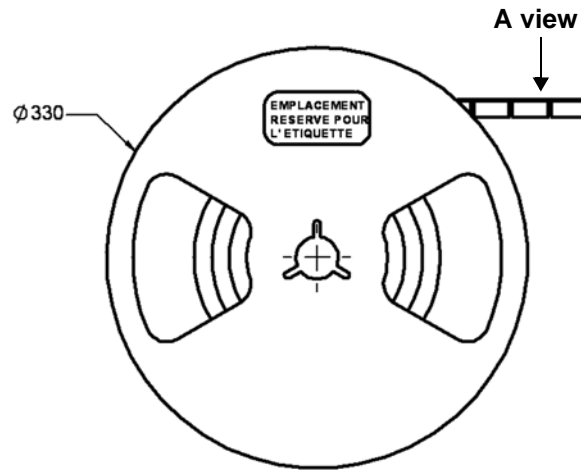
P04



P05



TAPE AND REEL



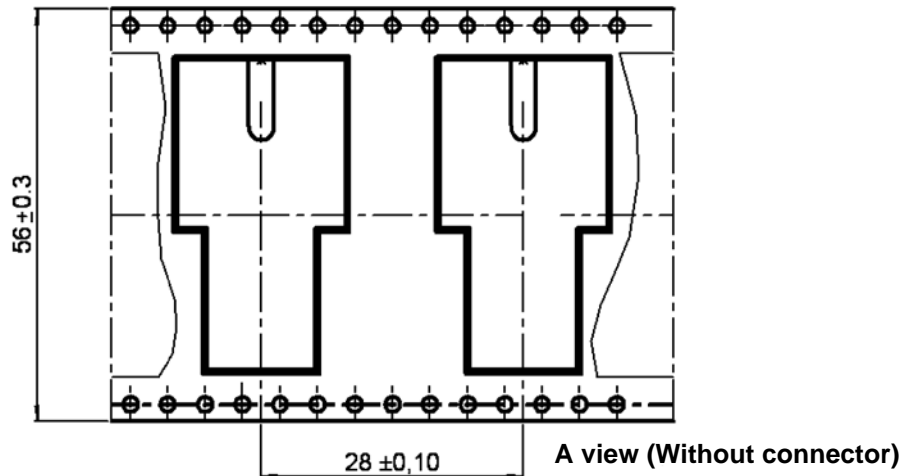
ACCORDING TO IEC 286-3 STANDARD

MATERIALS

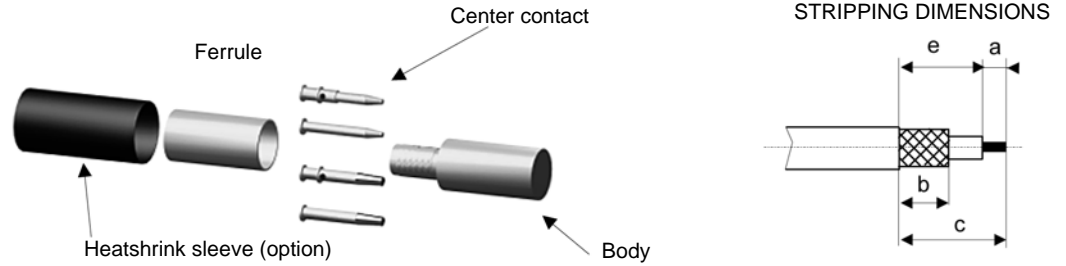
Reel: polyester

Carrier tape: antistatic PETG (polyester)

Cover tape: polyester

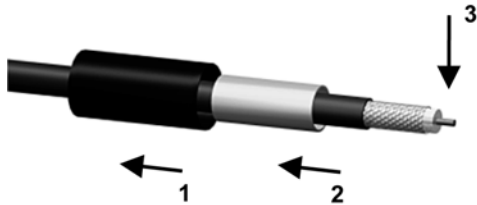


M 01



Part number	Stripping length (mm)				Hex.	Standard crimp tools dies included	Ferrule MIL standard R282 293 000 (M22520/5-01) + dies
	a	b	c	e			
R164 075 000 R164 076 000	4	7	12.9	8.9	1.73 - 5.41	R282 223 000	R282 235 011 (M22520/5-11)
R164 080 000 R164 088 000 R164 286 000 R164 286 200 R164 331 000 R164 331 200	5	8	14	9	2.54 - 10.54	R282 231 000	R282 235 116 (Y116 Daniels)
R164 282 000 R164 283 000 R164 329 000 R164 329 200	4.5	8	15	10.5	1.73 - 5.41	R282 223 000	R282 235 011 (M22520/5-11)

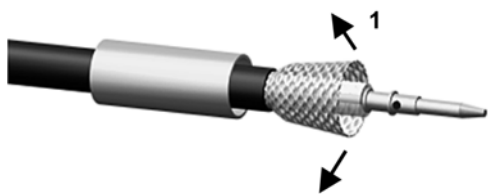
- 1**
- Slide the heatshrink sleeve onto the cable (Option).
 - Slide the ferrule onto the cable.
 - Strip the cable.



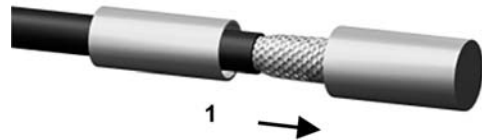
- 2**
- Slide on the centre contact until it bottoms against the cable dielectric.
 - Crimp the centre contact with the crimping tool.



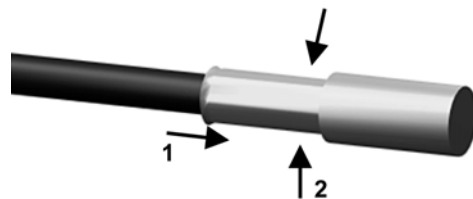
- 3**
- Fan the braid.



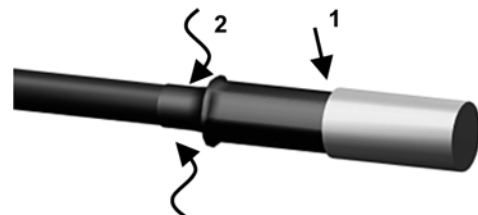
- 4**
- Slide the cable into the body until it bottoms against insulator.



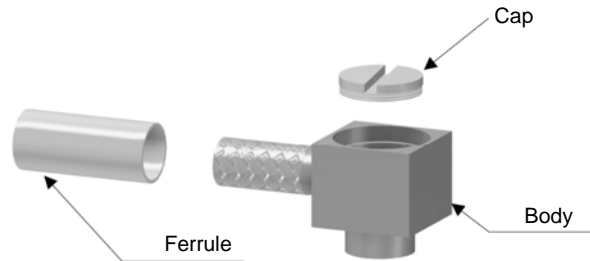
- 5**
- Slide the ferrule over the braid.
 - Crimp the ferrule with the crimping tool.



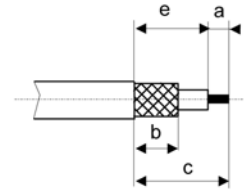
- 6**
- Cut the excess of braid if necessary.
 - Slide the sleeve over the ferrule and heatshrink it in place (Option).



M 02



STRIPPING DIMENSIONS



Part number	Stripping length (mm)				Hex.	Standard crimp tools dies included	Ferrule
	a	b	c	e			MIL standard R282 293 000 (M22520/5-01) + dies
R164 175 000 R164 176 000	2.5	8	20	17.5	5.41	R282 223 000	R282 235 011 (M22520/5-11)
R164 184 000 R164 186 000	2.5	10	21.9	19.4	10.54	R282 231 000	R282 235 116 (Y116 Daniels)

1

- Slide the ferrule onto the cable.
- Strip the cable.

2

- Fan the braid.

3

- Push the connector body under the braid.
- Slide the ferrule over the braid.

4

- Solder the inner conductor.

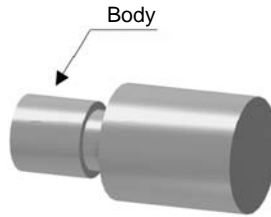
5

- Crimp the ferrule with the crimping tool.

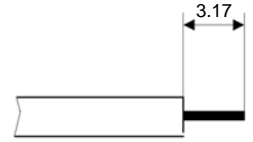
6

- Screw the cap into the body.

M 03



STRIPPING DIMENSIONS

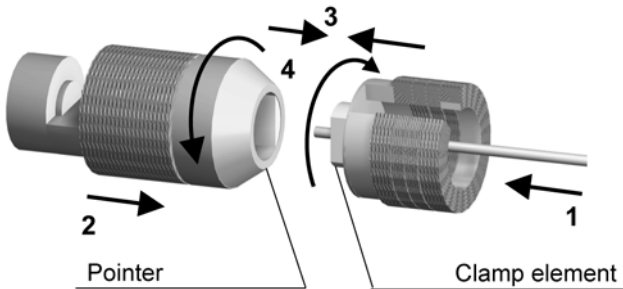


We recommend a thermal preconditioning cable

Part number	Stripping tool	Pointer gauge
R164 051 002 R164 336 000 R164 635 002	R282 053 000	R282 067 000

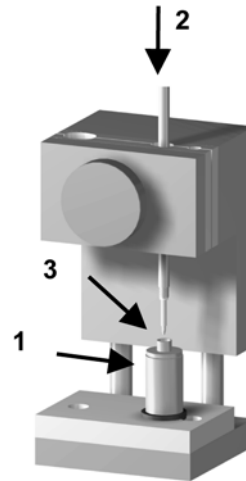
1

- Insert the cable into the clamp element.
- Present the pointer in front of the clamp element.
- Push the cable until it stops, while holding the clamp element pushed on the hollow part of the pointer.
- Turn the clamp element until the release of the pointer.



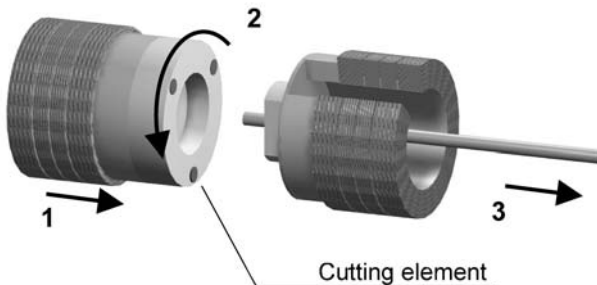
3

- Position the connector onto the assembly jig.
- Slide the cable into the connector until it bottoms against the body.
- Tighten.
- Put three rings of solder around the cable and solder.
- After cooling, remove the assembly from the jig.

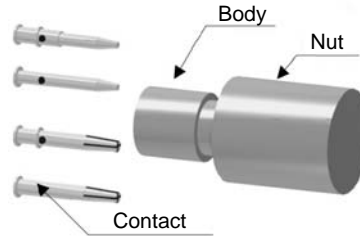


2

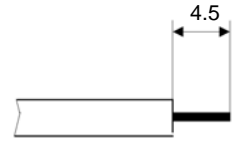
- Present the cutting element in front of the clamp element.
- Push and turn both elements, back part opposite to the front part. Once they reach the stop, pull without revolving.



M 04



STRIPPING DIMENSIONS

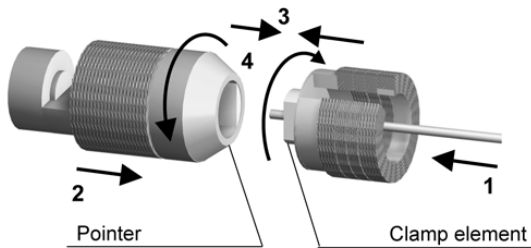


We recommend a thermal preconditioning cable

Part number	Soldering mounting	Stripping tool	Solder gauge	Pointer gauge	Soldering positioner
R164 054 002	R 282 740 030	R282 054 000	R282 862 140 thickness : .0276	R282 074 020	R282 744 261
R164 228 000 R164 278 302			R282 862 130 thickness : .0354		R282 744 260

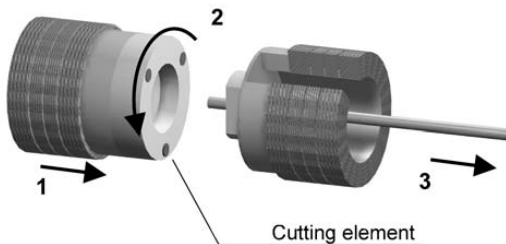
1

- Insert the cable into the clamp element.
- Present the pointer in front of the clamp element.
- Push the cable until it stops, while holding the clamp element pushed on the hollow part of the pointer.
- Turn the clamp element until the release of the pointer.



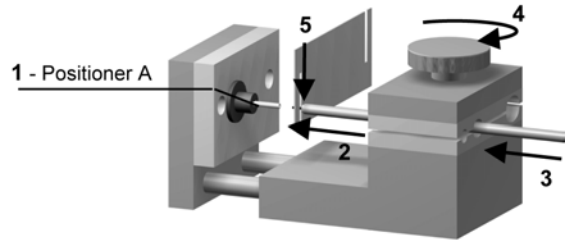
2

- Present the cutting element in front of the clamp element.
- Push and turn both elements, back part opposite to the front part. Once they reach the stop, pull without revolving.



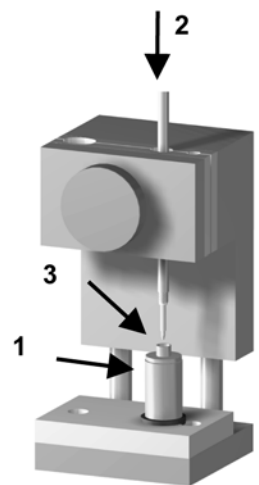
3

- Mount the positioner A.
- Slide the centre contact into the positioner A.
- Insert the solder gauge between the centre contact and the cable.
- Tighten.
- Solder the contact.



4

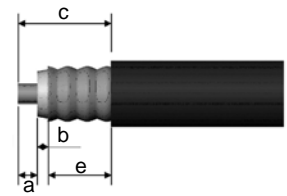
- After cooling, remove the assembly from the jig.
- Position the connector onto the assembly jig.
- Slide the cable into the connector until it bottoms against the insulator.
- Tighten.
- Put three rings of solder around the cable and solder.
- After cooling, remove the assembly from the jig.



M 05



STRIPPING DIMENSIONS



Part number	Stripping length (mm)				Stripping tool
	a	b	c	e	
R164 230 000	5	2.7	23.7	16	R282 011 050

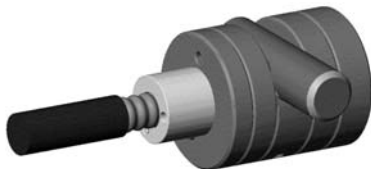
1

- Cut the front extremity of the cable in a hallow (between two rings) with a hacksaw (dimension C).
- Raise the handle and introduce the cable until it stops in the stripping tool.
- Push down the handle by applying a light pressure on it , keep turning the tool until it turns freely.
- Hold the handle down, and turn the tool (of approximately ¼ of tour) in the opposite direction, while pulling gently on the cable in order to release pieces of the cable cut.
- Raise the handle, slide the cable out and remove loose pieces of cable.
- In case of cut parts jammed in the tool : raise the handle , introduce again the stripped cable in the tool, screw slightly the cable into the copper previously cut and remove cable + loose parts.
- Push down again the handle.

BLADE ADJUSTMENT: The height of blades can be modified with the help of adjustment screw located in the body (see here-hunder).

2

- Introduce the cable in the opposite side of the tool.
- Turn the tool and apply a light pressure until it stops.
- After cutting, the dielectric cut will be extracted on the other side of the tool.



3

- Introduce the cable in the tool as shown.
- Turn the tool to point the inner conductor of the cable.



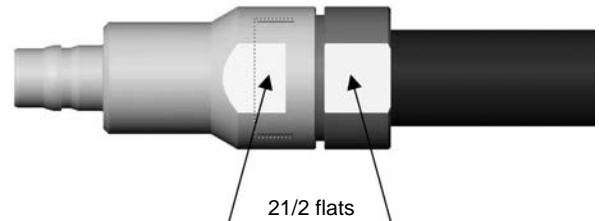
4

- Mount the clamp nut on the cable, until the clipsage of the elastic contact on the first anelure.
- To push the part defers the two press in stop on the elastic contact.

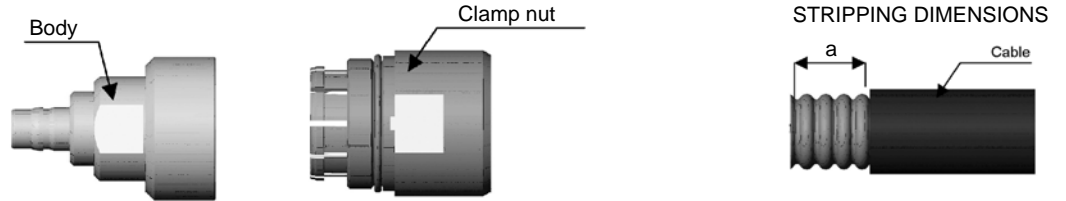


5

- Mount the clamp nut with the cable in the body of the connector.
- Couple of tightening recommended : 800N.cm



M 06



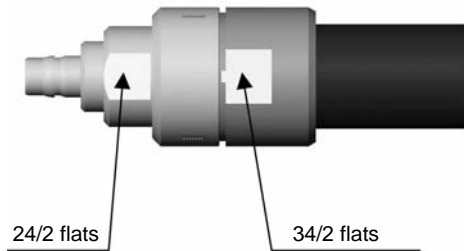
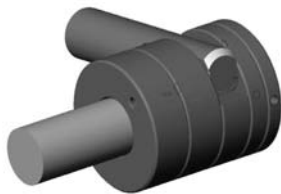
Part number	Stripping length (mm) a	Stripping tool
R164 231 000	26	R282 011 060

- 1**

 - Cut the front extremity of the cable at the top of a annelure with a hacksaw.
 - Raise the handle and introduce the cable until it stops in the stripping tool.
 - Push down the handle by applying a light pressure on it, keep turning the tool until it turns freely + appointing of the interior of the inner of the cable.
 - Raise the handle, and slide the cable out.
 - Split the sheath with a tool cutting perpendiculary to the previously undertaken split.
 - Remove the sheath cut.

3

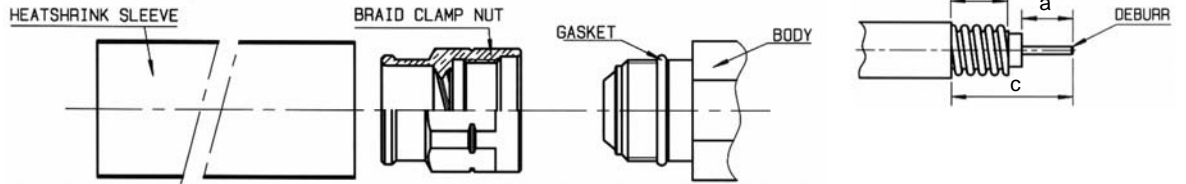
 - Mount the clamp nut with the cable in the body of the connector.
 - Couple of tightening recommended : 2500N.cm



- 2**
- Mount the clamp nut on the cable, until the clipsage of the elastic contact on the first annelure.
 - To push the part, defers the two press in stop on the elastic contact.



M 07



Part number	Stripping length (mm)			Stripping tool	Torque wrench
	a	b	c		
R164 036 000 R164 037 000	5	5.5	11.5	R282 010 040 R282 010 050	R282 303 220 (.708 in 84.075 in.lb)

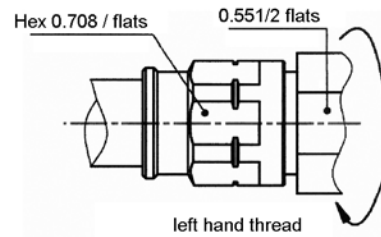
1

- Strip the cable.
- Do not damage the outer conductor.
- Deburr cable inner conductor.

3

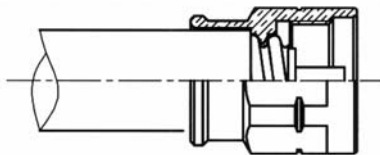
- Screw the connector onto the assembly.

WARNING: Screw the connector on the braid clamp nut turning left (left-hand thread) so that the copper outer conductor is being squeezed.



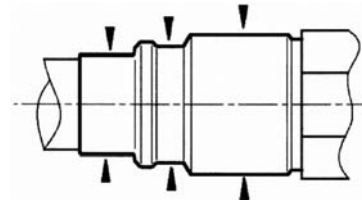
2

- Slide the heatshrink sleeve onto the cable.
- Screw manually the braid clamp nut onto cable outer conductor until it stops.

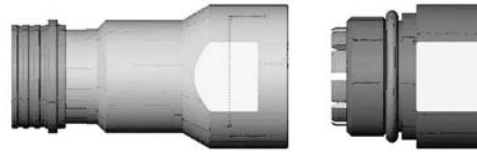


4

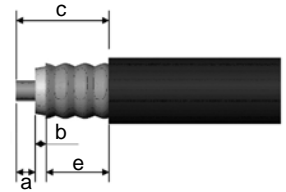
- Shrink the heatshrink sleeve.



M 08



STRIPPING DIMENSIONS

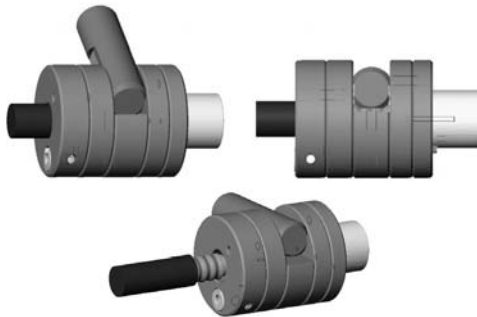


Part number	Stripping length (mm)				Stripping tool
	a	b	c	e	
R164 091 000	5	2.7	23.7	16	R282 011 050

1

- Cut the extremity of the cable in the top of a annelure with a hacksaw (dimension C).
- Raise the handle and introduce the cable until it stops in the stripping tool.
- Push down the handle by applying a light pressure on it, keep turning the tool until it turns freely.
- Hold the handle down, and turn the tool (of approximately 1/4 of tour) in the opposite direction, while pulling gently on the cable in order to release pieces of the cable cut.
- Raise the handle, slide the cable out and remove loose pieces of cable.
- In case of cut parts jammed in the tool : raise the handle , introduce again the stripped cable in the tool, screw slightly the cable into the copper previously cut and remove cable + loose parts.
- Push down again the handle.

BLADE ADJUSTMENT: The height of blades can be modified with the help of adjustment screw located in the body (see here-hunder).



2

- Introduce the cable in the opposite side of the tool.
- Turn the tool and exert a light pressure until stop.
- After cutting the dielectric cut will be extracted on the other side of the tool.



3

- Introduce the cable in the tool as shown.
- Turn the tool to point the inner conductor of the cable.



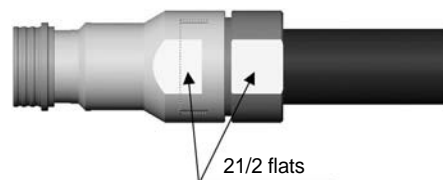
4

- Mount the clamp nut on the cable, until the clipsage of the elastic contact on the first annelure.
- To push the part defers the two press in stop on the elastic contact.

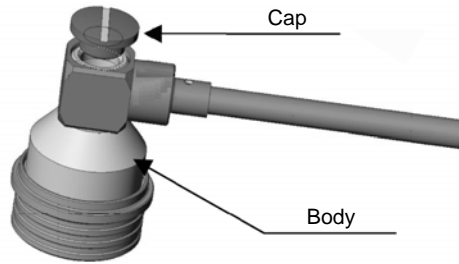


5

- Mount the clamp nut with the cable in the body of the connector.
- Couple of tightening recommended : 800 Ncm.



M 09



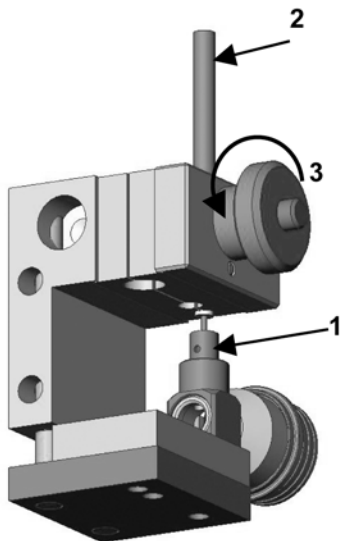
STRIPPING DIMENSIONS



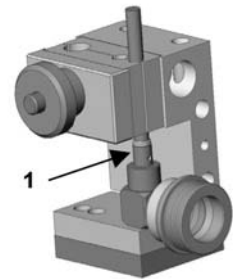
Part number	Stripping length (mm)			Stripping tool
	a	b	c	
R164 152 000	2.8	6.5	9.3	R282 740 030

1 - Strip the cable.

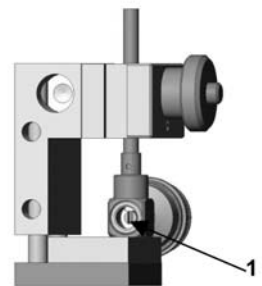
2 - Insert the cable into the body.
- Place the sub-assembly into the assembly jig.
- Tighten.



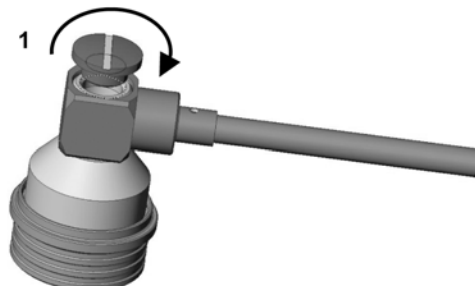
3 - Put three rings of solder around the cable.
- Solder the body onto the cable.



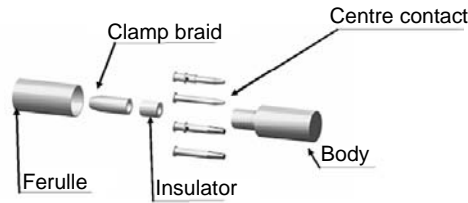
4 - Solder the inner conductor.



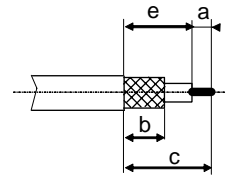
5 - Screw the cap into the body.



M 10

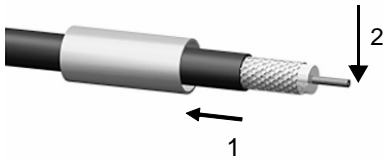


STRIPPING DIMENSIONS

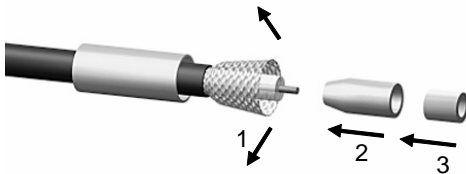


Part number	Stripping length (mm)				Crimping dies	Crimping tool	Positioner for crimping tool
	a	b	c	e			
R164 072 020	4	8	14	10	282 235 011	R282 223 000 R282 293 000 R282 281 000	R282 967 015

- 1**
- Slide the ferrule onto the cable.
 - Strip the cable.



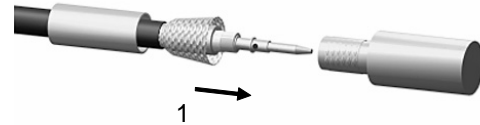
- 2**
- Fan the braid.
 - Slide the braid clamp and the insulator between the dielectric and the braid.
 - Slide the insulator between the dielectric and the braid.



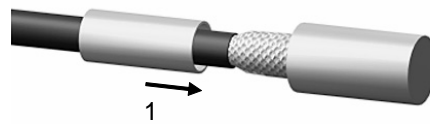
- 3**
- Slide on the centre contact until it bottoms against the cable dielectric.
 - Solder or crimp the centre contact with crimping tool (see table).
 - Clean solder area if necessary.



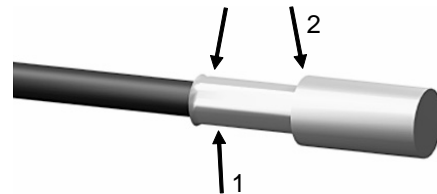
- 4**
- Slide cable into body until it bottoms against insulator.

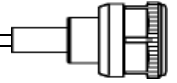


- 5**
- Slide the ferrule over the braid.



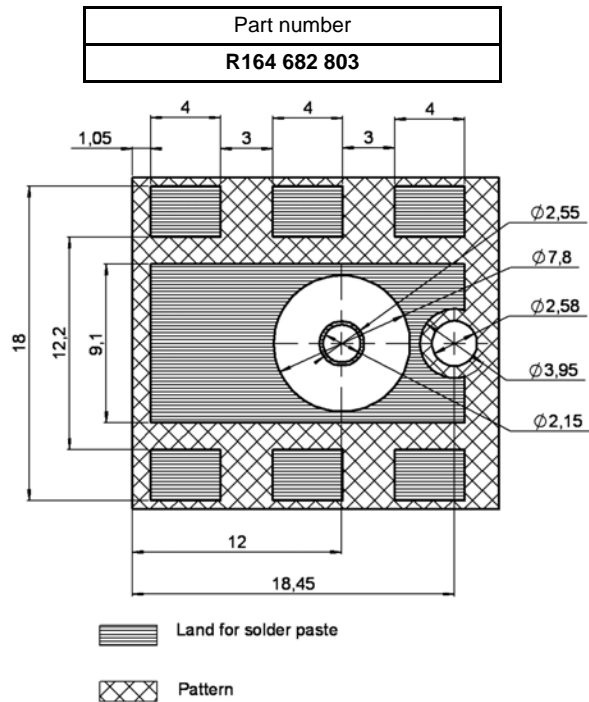
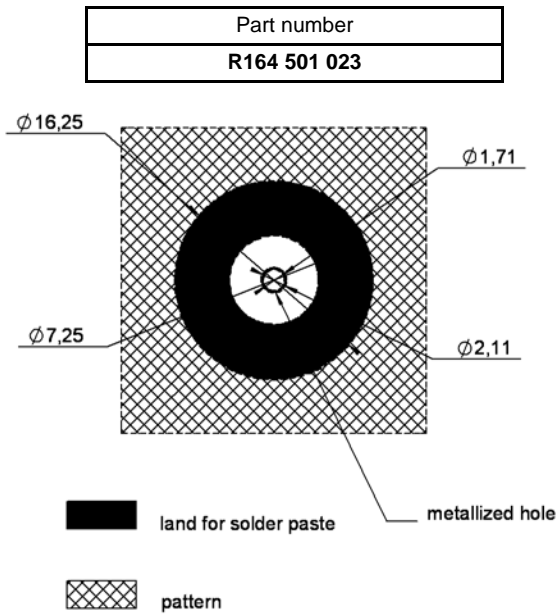
- 6**
- Crimp the ferrule with crimping tool (see table).
 - Cut the excess of braid if necessary.





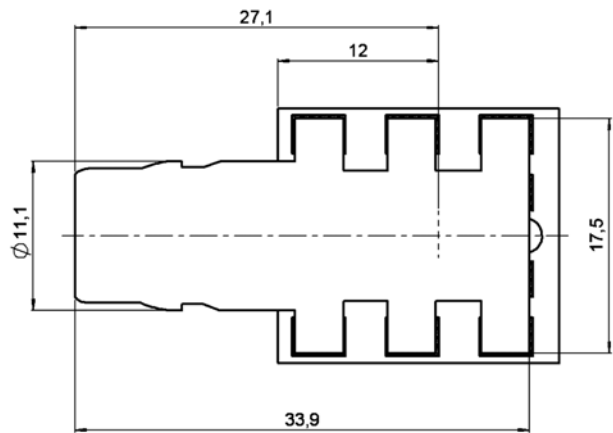
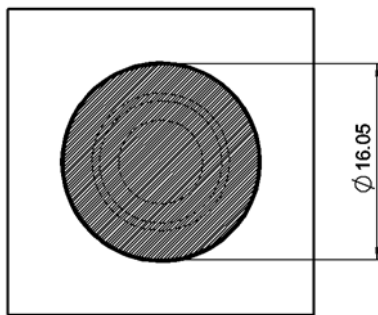
M 11

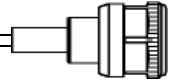
Receptacle soldering pattern:



Micro strip line. Signal is on the opposite side.
 Thickness of PCB: .063 (1.6 mm).
 The material of PCB is the epoxy resin (FR4) (Er = 4.8).
 The solder resist should be printed except for the land pattern on the PCB.

Coplanar line: pattern and signal are on the same side.
 Thickness of PCB: .063 (1.6 mm).
 The material of PCB is the epoxy resin of glass fabrics backs (Er = 4.8).
 The solder resist should be printed except for the land pattern on the PCB.





M 11

SOLDER PROCEDURE

1

Deposit solder paste 'Sn Ag4 Cu0.5' on mounting zone by screen printing application. We recommend a low residue flux. We advise a thickness of 150 micromm (5.850 microinch). Verify that the edges of the zone are clean.

2

Placement of the receptacle on the mounting zone with an automatic machine of 'pick and place' type. Video camera is preferred to check the positioning of the component. Adhesive agents are forbidden on the receptacle.

3

Soldering by infra-red reflow.

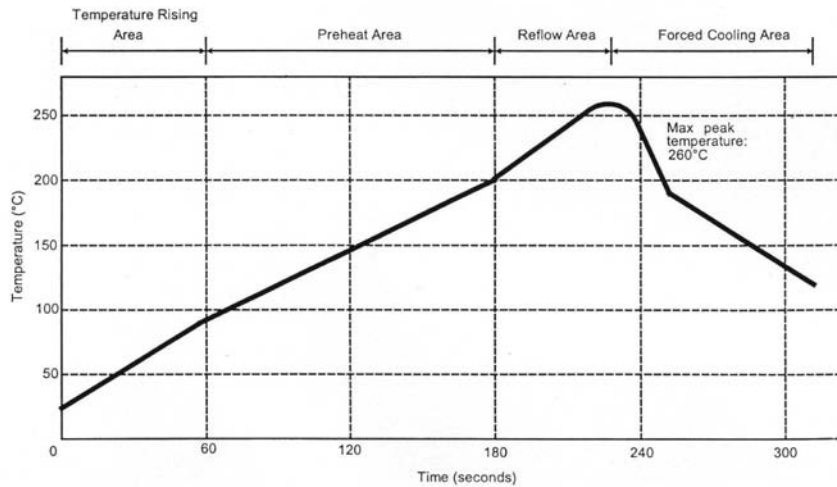
4

Cleaning of printed circuit boards.

5

Checking of solder joints and position of the component by visual inspection.

TEMPERATURE PROFILE



Parameter	Value	Unit
Temperature rising Area	1 - 4	°C/sec
Max Peak Temperature	260	°C
Max dwell time @260°C	10	sec
Min dwell time @235°C	20	sec
Max dwell time @235°C	60	sec
Temperature drop in cooling Area	-1 to -4	°C/sec
Max dwell time above 100°C	420	sec