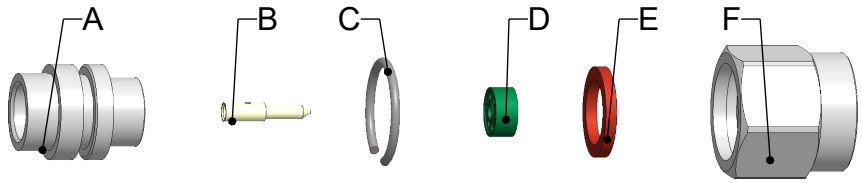
© ROSENBERGER HOCHFREQUENZTECHNIK GMBH & Co. KG or THIRD PARTY
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization by the owner or rights-holder is prohibited. Offenders can be held liable. All rights reserved in the event of the grant of patent, utility model or design.

Montageanleitung: MA_02A7

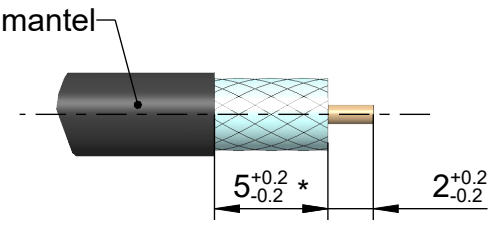
Verbinder - gerade
für Festmantel- und Flexkabel

Kabelbefestigung:
Innenleiter - gelötet
Außenleiter - gelötet

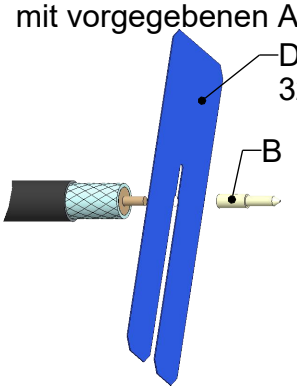


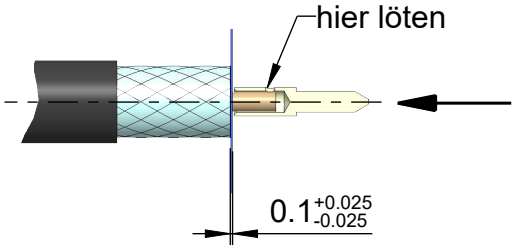
Schematische Darstellung

1) Kabel nach Zeichnung abisolieren.
* Bei Flexkabel:
Kabelmantel nach Zeichnung abisolieren.
Achtung: Schirmgeflecht nicht beschädigen
Bei Bedarf: Litzeninnenleiter verzinnen
Für 02S142-272: Abisoliermaß 8±0.2



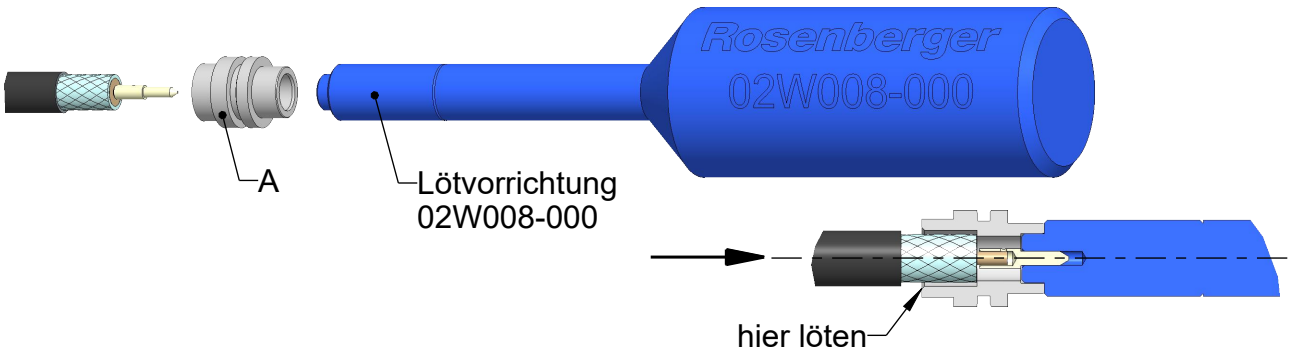
2) Innenleiter "B" mit Distanzlehre (32W100-038) auf den Kabelinnenleiter stecken und mit vorgegebenen Abstand festlöten.





3) Das Kabel bis auf Anschlag in den Steckerkörper "A" schieben. Zur Zentrierung des Innenleiters die Lötvorrichtung (02W008-000) bis auf Anschlag in den Außenleiter "A" schieben und mit dem Gehäuse verlöten.

Bei Bedarf:
Überstehendes Dielektrikum mit Fräser (02W005-000) entfernen.



					date	name	scale:
				drawn	17.06.2004	B_Dandl	
j00	19-1093	S_Schmid	13.09.2019	check.	13.09.2019	G_Schiele	sheet:
i00	13-0838	M_Fuehrich	14.10.2013	appr.	13.09.2019	H_Babinger	1/6
h00	12-0156	T_Oberhauser	05.03.2012				
g00	11-0226	T_Oberhauser	15.03.2011				
f00	09-0814	M_Knoll	25.11.2009				
e00	08-0731	S_Hofmeister	13.11.2008				
rev.	change-no	name	date				

Rosenberger

Werkzeuge:

Abisolierwerkzeug	Konushülse 32W100-039
Lötausrüstung	Lötvorr. 02W008-000
Fräser 02W005-000	Distanzl. 32W100-038
Einpressw. 02W006-000	Messuhr 32W100-033
Kegelh. 32W100-022/01	Messuhr 32W100-034
Gegenh. 32W100-022/02	....
Stößel 32W100-022/04	....

PD_FB_01

-METRIC-

ISO-Projektion
Methode 1

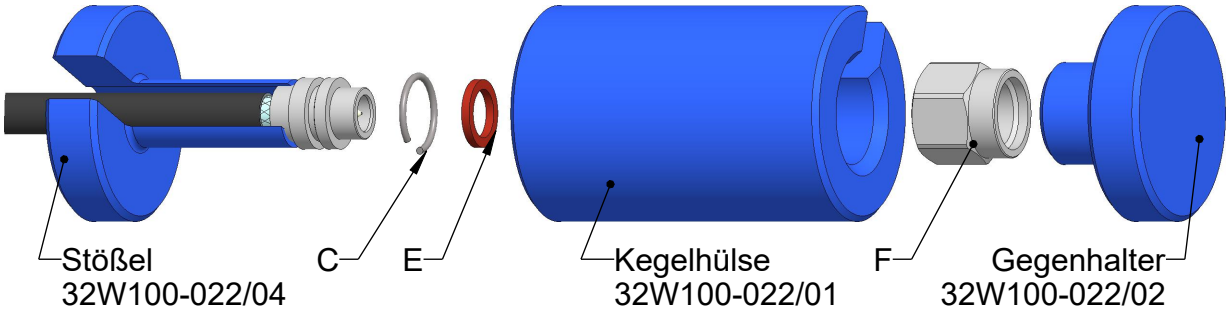
© ROSENBERGER HOCHFREQUENZTECHNIK GMBH & Co. KG or THIRD PARTY
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization by the owner or rights-holder is prohibited. Offenders can be held liable. All rights reserved in the event of the grant of patent, utility model or design.

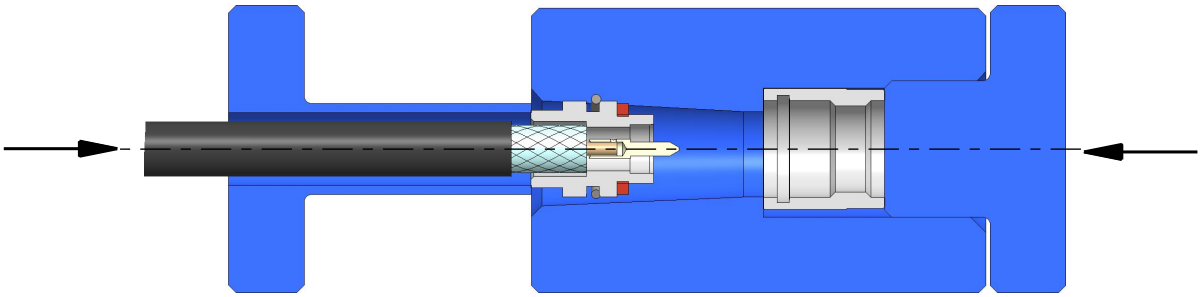
Montageanleitung: MA_02A7

Verbinder - gerade
für Festmantel- und Flexkabel

Kabelbefestigung:
Innenleiter - gelötet
Außenleiter - gelötet

4) Montage von Überwurfmutter "F":
a) Federring "C" mit Konushülse (32W100-039) und Dichtungsring "E" auf Gehäuse "A"aufziehen.
b) Überwurfmutter "F" mit dem Gegenhalter (32W100-022/02) in die Kegelhülse (32W100-022/01) drücken.
c) Das Kabel mit dem Stößel (32W100-022/04) in die Kegelhülse schieben, bis der Federring "C" hör- und spürbar einrastet.
Die Schlitze von Federring "C" und der Kegelhülse dürfen nicht übereinstimmen.
d) Montiertes Kabel aus der Kegelhülse entfernen und prüfen, ob Überwurfmutter "F" frei drehbar ist.





					date	name	scale:
				drawn	17.06.2004	B_Dandl	
j00	19-1093	S_Schmid	13.09.2019	check.	13.09.2019	G_Schiele	sheet:
i00	13-0838	M_Fuehrich	14.10.2013	appr.	13.09.2019	H_Babinger	2/6
h00	12-0156	T_Oberhauser	05.03.2012				
g00	11-0226	T_Oberhauser	15.03.2011				
f00	09-0814	M_Knoll	25.11.2009				
e00	08-0731	S_Hofmeister	13.11.2008				
rev.	change-no	name	date				

Rosenberger

Werkzeuge:

Abisolierwerkzeug	Konushülse 32W100-039
Lötausrüstung	Lötvorr. 02W008-000
Fräser 02W005-000	Distanzl. 32W100-038
Einpressw. 02W006-000	Messuhr 32W100-033
Kegelh. 32W100-022/01	Messuhr 32W100-034
Gegenh. 32W100-022/02	....
Stößel 32W100-022/04	....

PD_FB_01

-METRIC-

ISO-Projektion
Methode 1

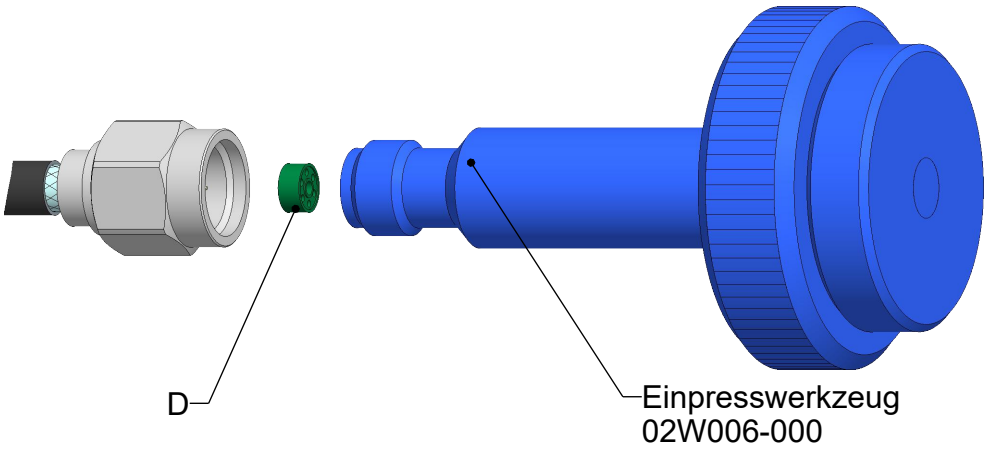
© ROSENBERGER HOCHFREQUENZTECHNIK GMBH & Co. KG or THIRD PARTY
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization by the owner or rights-holder is prohibited. Offenders can be held liable. All rights reserved in the event of the grant of patent, utility model or design.

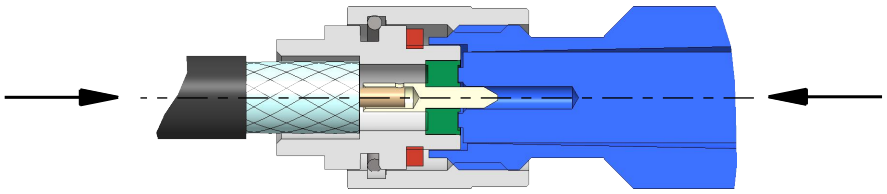
Montageanleitung: MA_02A7

Verbinder - gerade
für Festmantel- und Flexkabel

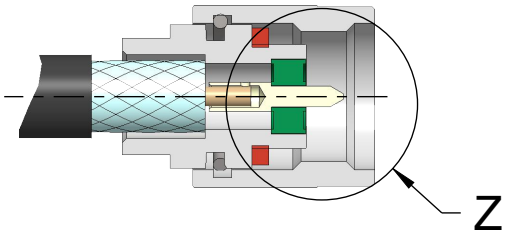
Kabelbefestigung:
Innenleiter - gelötet
Außenleiter - gelötet

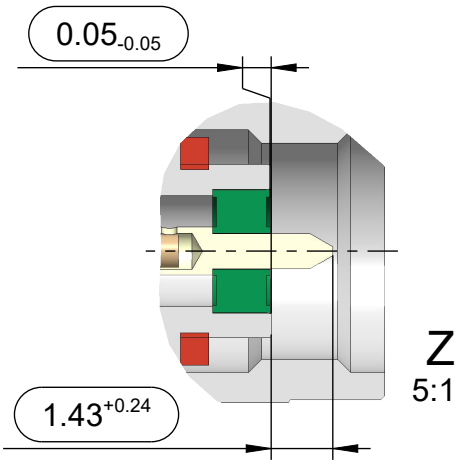
5) Montage von Isolierteil "D":
a) Isolierteil "D" auf Innenleiter "B" vorzentrieren.
b) Einpresswerkzeug (02W006-000) bis auf Anschlag in den Stecker einschrauben.
c) Isolierteil "D" bis auf Anschlag mit dem Stempel eindrücken.
Achtung: Isolierteil "D" darf nicht über Steckkörper "A" vorstehen!





6) Anschlussmaße kontrollieren:
Innenleiter "B" mit Messuhr (32W100-033)
Isolierteil "D" mit Messuhr (32W100-034)





					date	name	scale:
				drawn	17.06.2004	B_Dandl	
j00	19-1093	S_Schmid	13.09.2019	check.	13.09.2019	G_Schiele	sheet:
i00	13-0838	M_Fuehrich	14.10.2013	appr.	13.09.2019	H_Babinger	3/6
h00	12-0156	T_Oberhauser	05.03.2012				
g00	11-0226	T_Oberhauser	15.03.2011				
f00	09-0814	M_Knoll	25.11.2009				
e00	08-0731	S_Hofmeister	13.11.2008				
rev.	change-no	name	date				

Rosenberger

Werkzeuge:

Abisolierwerkzeug	Konushülse 32W100-039
Lötausrüstung	Lötvorr. 02W008-000
Fräser 02W005-000	Distanzl. 32W100-038
Einpressw. 02W006-000	Messuhr 32W100-033
Kegelh. 32W100-022/01	Messuhr 32W100-034
Gegenh. 32W100-022/02	....
Stößel 32W100-022/04	....

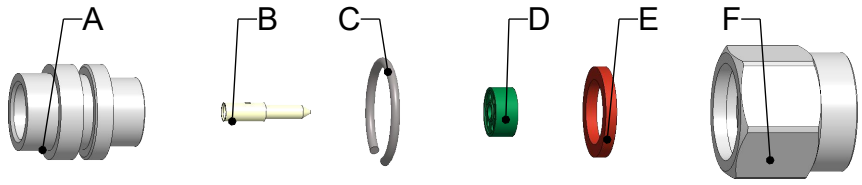
PD_FB_01
-METRIC-
ISO-Projektion Methode 1

© ROSENBERGER HOCHFREQUENZTECHNIK GMBH & Co. KG or THIRD PARTY
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization by the owner or rights-holder is prohibited. Offenders can be held liable. All rights reserved in the event of the grant of patent, utility model or design.

Assembly Instruction: MA_02A7

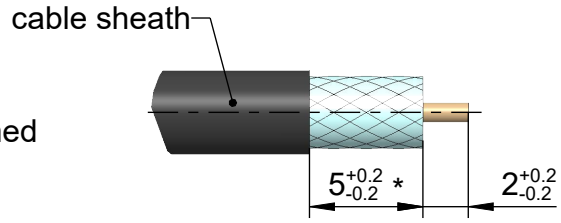
Connector - straight
for semi-rigid- and flexible cable

Cable entry:
Center conductor - soldered
Outer conductor - soldered

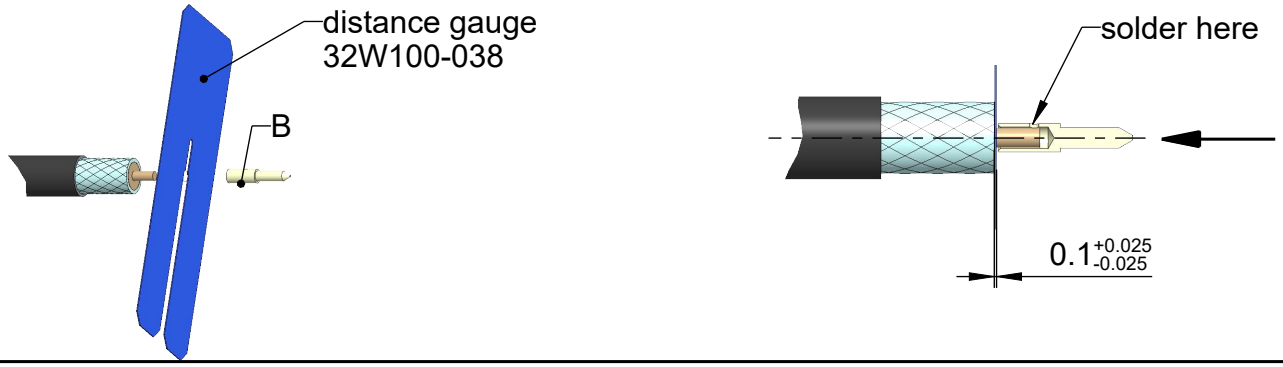


schematic illustration

1) Prepare the cable according to the drawing
* For flexible cable:
Strip the cable sheath according to the drawing
Attention: Do not damage the braided shield!
If required: strainded center pin needs to be tinned
For 02S142-272: Stripping dimension 8±0.2

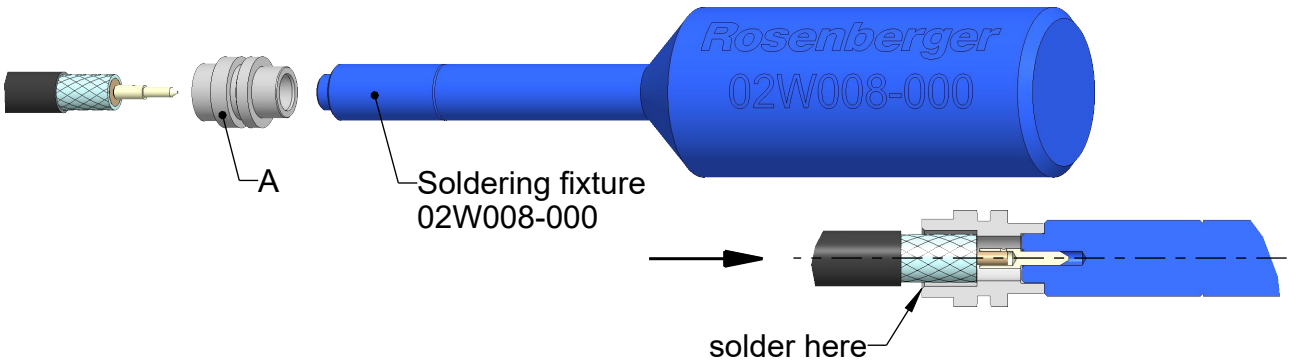


2) Slide center pin "B" with distance gauge (32W100-038) onto the inner conductor of the cable and solder it according to the drawing.



3) Insert the cable into outer conductor "A" until stop, for alignment of the center pin insert the soldering fixture (02W008-000) into outer conductor "A" until stop. Solder the cable with the outer conductor.

If required:
Remove protruded dielectric with cutter (02W005-000)



					date	name	scale:
				drawn	17.06.2004	B_Dandl	
j00	19-1093	S_Schmid	13.09.2019	check.	13.09.2019	G_Schiele	sheet:
i00	13-0838	M_Fuehrich	14.10.2013	appr.	13.09.2019	H_Babinger	4/6
h00	12-0156	T_Oberhauser	05.03.2012				
g00	11-0226	T_Oberhauser	15.03.2011				
f00	09-0814	M_Knoll	25.11.2009				
e00	08-0731	S_Hofmeister	13.11.2008				
rev.	change-no	name	date				

Rosenberger

Tools:

Stripping tool	Cone sleeve 32W100-039
Soldering equipment	Sold. fixture 02W008-000
Cutter 02W005-000	Dist. gauge 32W100-038
Insert tool 02W006-000	Dial gauge 32W100-033
Conic. fer. 32W100-002/01	Dial gauge 32W100-034
Counterp. 32W100-022/02	....
Nut insert. 32W100-022/04	....

PD_FB_01

-METRIC-

ISO-Projektion
Methode 1

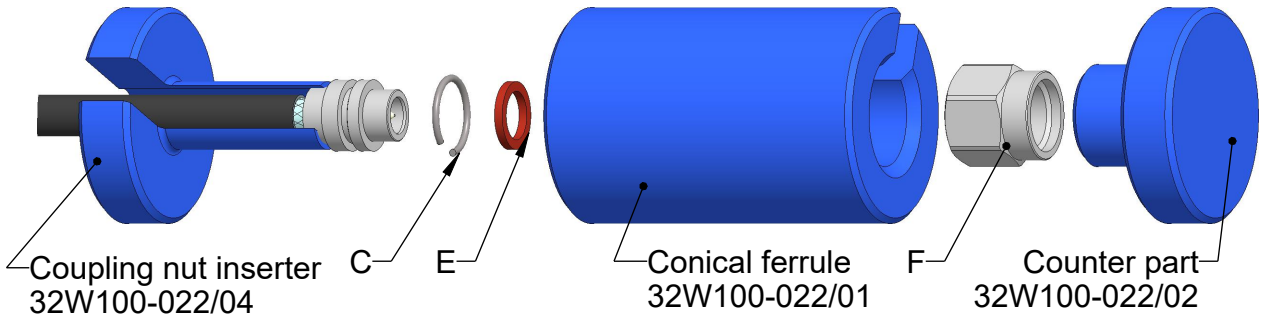
© ROSENBERGER HOCHFREQUENZTECHNIK GMBH & Co. KG or THIRD PARTY
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization by the owner or rights-holder is prohibited. Offenders can be held liable. All rights reserved in the event of the grant of patent, utility model or design.

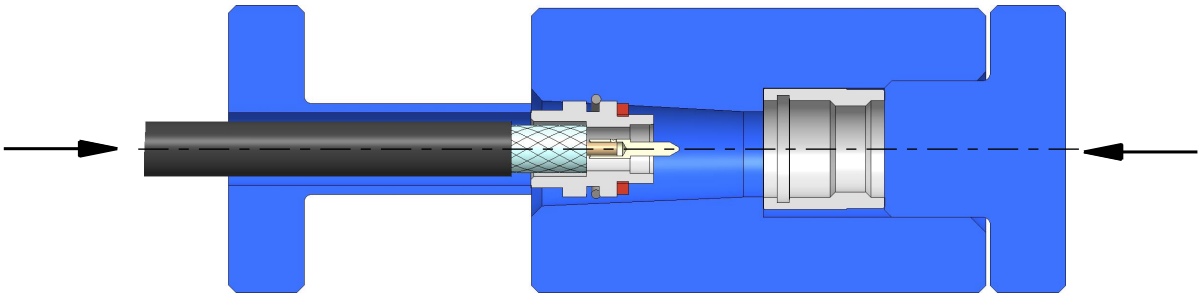
Assembly Instruction: MA_02A7

Connector - straight
for semi-rigid- and flexible cable

Cable entry:
Center conductor - soldered
Outer conductor - soldered

4) Mount coupling nut "F":
a) Mount the spring washer "C" with cone sleeve (32W100-039) and slide gasket "E" onto outer contact "A".
b) Place coupling nut "F" into conical ferrule (32W100-022/01) with the counterpart (32W100-022/02).
c) Slide cable into the conical ferrule with the coupling nut inserter (32W100-022/04) until the spring washer engages
The slots of the spring washer "C" and the conical ferrule should not align.
d) Remove the conical ferrule and check if the coupling nut "F" is free to rotate.





rev.	change-no	name	date
j00	19-1093	S_Schmid	13.09.2019
i00	13-0838	M_Fuehrich	14.10.2013
h00	12-0156	T_Oberhauser	05.03.2012
g00	11-0226	T_Oberhauser	15.03.2011
f00	09-0814	M_Knoll	25.11.2009
e00	08-0731	S_Hofmeister	13.11.2008

	date	name	scale:
drawn	17.06.2004	B_Dandl	
check.	13.09.2019	G_Schiele	sheet:
appr.	13.09.2019	H_Babinger	5/6

Rosenberger

Tools:

Stripping tool	Cone sleeve 32W100-039
Soldering equipment	Sold. fixture 02W008-000
Cutter 02W005-000	Dist. gauge 32W100-038
Insert tool 02W006-000	Dial gauge 32W100-033
Conic. fer. 32W100-002/01	Dial gauge 32W100-034
Counterp. 32W100-022/02	....
Nut insert. 32W100-022/04	....

PD_FB_01
-METRIC-
ISO-Projektion Methode 1

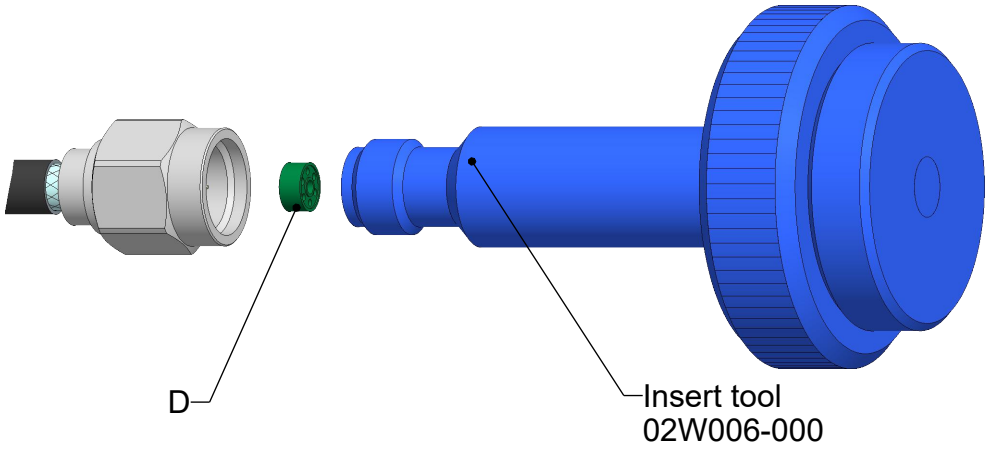
© ROSENBERGER HOCHFREQUENZTECHNIK GMBH & Co. KG or THIRD PARTY
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization by the owner or rights-holder is prohibited. Offenders can be held liable. All rights reserved in the event of the grant of patent, utility model or design.

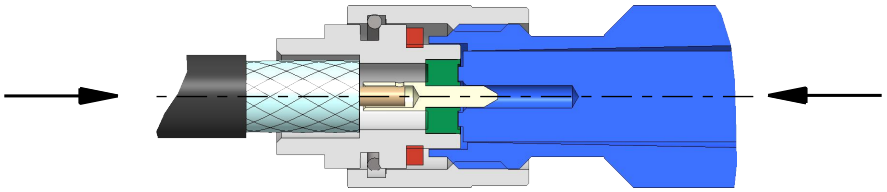
Assembly Instruction: MA_02A7

Connector - straight
for semi-rigid- and flexible cable

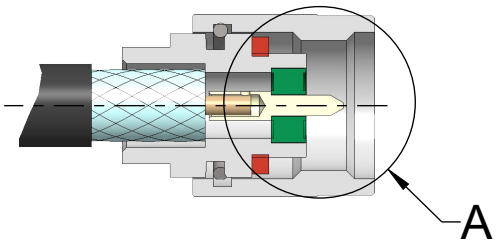
Cable entry:
Center conductor - soldered
Outer conductor - soldered

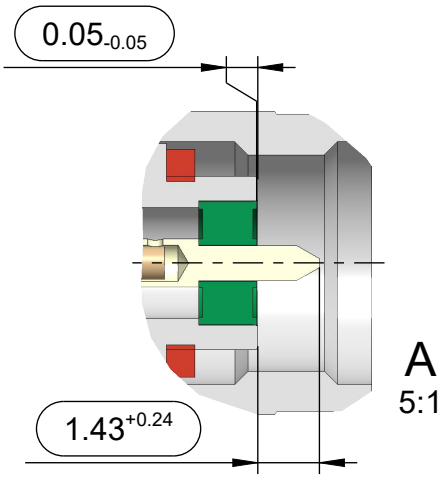
5) Mount insulator "D":
a) Pre-center insulator "D" on center pin "B".
b) Screw insert tool (02W006-000) onto connector housing until stop.
c) Press insulator "D" with heading tool until stop.
Attention: Insulator "D" must not preside over the outer contact!





6) Check the interface dimensions:
Center pin "B" with dial gauge (32W100-033)
Insulator "D" with dial gauge (32W100-034)





					date	name	scale:	Tools:	
				drawn	17.06.2004	B_Dandl			
j00	19-1093	S_Schmid	13.09.2019	check.	13.09.2019	G_Schiele	sheet:	Stripping tool	Cone sleeve 32W100-039
i00	13-0838	M_Fuehrich	14.10.2013	appr.	13.09.2019	H_Babinger	6/6	Soldering equipment	Sold. fixture 02W008-000
h00	12-0156	T_Oberhauser	05.03.2012					Cutter 02W005-000	Dist. gauge 32W100-038
g00	11-0226	T_Oberhauser	15.03.2011					Insert tool 02W006-000	Dial gauge 32W100-033
f00	09-0814	M_Knoll	25.11.2009	Rosenberger				Conic. fer. 32W100-002/01	Dial gauge 32W100-034
e00	08-0731	S_Hofmeister	13.11.2008					Counterp. 32W100-022/02	....
rev.	change-no	name	date					Nut insert. 32W100-022/04	....

PD_FB_01
-METRIC-
ISO-Projektion Methode 1