Assembly Instruction

Quick-Fit plus connectors for ½” foam cables

Safety Instructions

Connector Types

<table>
<thead>
<tr>
<th></th>
<th>Straight cable plug</th>
<th>Right angle cable plug</th>
<th>Straight cable jack</th>
</tr>
</thead>
<tbody>
<tr>
<td>N type</td>
<td>11_N-50-12-6…</td>
<td>16_N-50-12-6…</td>
<td>21_N-50-12-6…</td>
</tr>
<tr>
<td>4.3-10 type</td>
<td>11_4310-50-12-X/Y/Z6…</td>
<td>16_4310-50-12-X/Y/Z6…</td>
<td>21_4310-50-12-X/Y/Z6…</td>
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<tr>
<td>7/16 type</td>
<td>11_716-50-12-6…</td>
<td>16_716-50-12-6…</td>
<td>21_716-50-12-6…</td>
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</tbody>
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Required Tools

- Preparing tool 74_Z-0-12-18 with blade units and chamfering tool
- Remover 74_Z-0-12-24
- Cordless-drill
- Speed controlled
- 2x HEX-Spanner AF 24 mm / 15-16 in

Check appropriate blade unit

Green 74_Z-0-12-21
For jacket diameters > 16 mm
(e.g. HUBER+SUHNER Sucofeed)

Yellow 74_Z-0-12-20
For jacket diameters < 16 mm

Perform rough cut
If the cable must be cut for length, leave around 3” (7 cm) of cable beyond the expected connector cable entry point. Use a tube cutter in order to avoid shavings. Then straighten approx. 20” (500 mm) of the cable end.

Set START/END position
Make sure that the preparing tool is in the START/END position by rotating the left part of the tool clockwise or counter-clockwise.

Position tool
Slide the tool according the cable direction indicator on the cable until it is visible in the opening at least. Mind connector’s cable entry reference on the tool.

Cut
a) Hold preparing tool at the grip whilst keeping the foam cable in preferred axial position
b) Turn the base tool manually or supported in clockwise direction until START/END position is reached again after about 14 turns
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5 Eject cut sections
   a) Slide the preparing tool backwards away from the cable end
   b) Remove loose jacket outer conductor ring 1st
   c) Remove the tool from the cable

6 Remove outer conductor, dielectric and centre conductor coating
   Use the removing tool and remove the outer conductor, the dielectric and the jacket by using the appropriate tool shape. Remove also the centre conductor coating if needed.

7 Chamfer center conductor
   Chamfer the centre conductor by use of the chamfering tool until stop.

8 Proper cable preparation
   Inspect the final condition of the stripped foam cable end carefully for following points:
   ✓ All the cut sections should be clean cut
   ✓ Corrugated outer conductor without deformation
   ✓ Center conductor, straight aligned and without scratches on the entire surface and completely chamfered

9 Position connector
   a) Slide the connector onto latching CLICK position
   b) Verify the connector is proper settled by counter movement

10 Fix connector
   Remove the red locking clip and torque the cable entry part (AF 24 mm / 15, 16 in) while keeping the connector body in stationary position until the positive stop.
   Proof torque: ≥ 17 Nm

For latest assembly instruction with full product range, please visit –
www.hubersuhner.com/QuickFitPlus

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