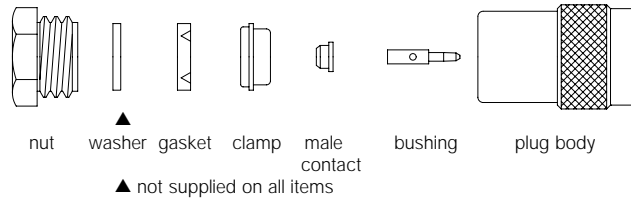
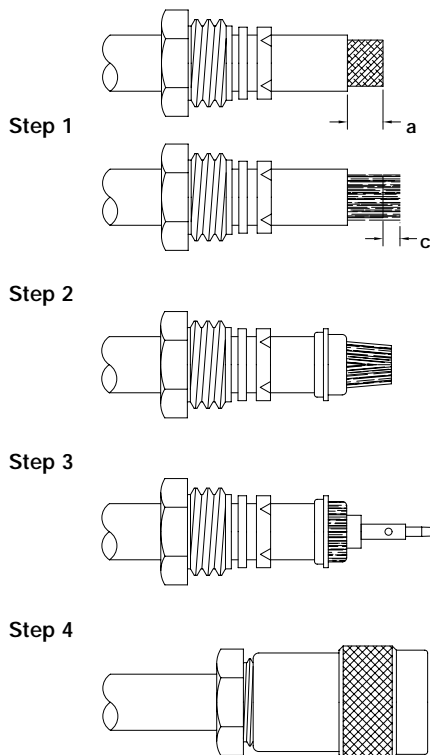


CLAMP TYPES



Amphenol Number	Conn. Type	Cable	Stripping Dimensions, In.(mm)	
			a	c
79075	TNC Angle Plug	RG-58	.281(7.1)	.109(2.8)
79875	TNC Plug	RG-58	.281(7.1)	.109(2.8)
79600	TNC Jack	RG-58	.300(7.5)	.110(2.8)



Step 1 Place nut, washer (when supplied) and gasket over cable and strip jacket to dimension **a** shown in table above.

Step 2 Comb out braid and fold out. Trim insulation off center conductor to dimension **c** shown in table above. Tin center conductor. Pull braid wires forward and taper toward center conductor. Place clamp over braid and push back against cable jacket.

Step 3 Fold back braid wires as shown, trim to proper length [.125" (3.2mm)] and form over clamp as shown. Solder contact to center conductor.

Step 4 Insert cable and parts into connector body. Make sure sharp edge of clamp seats properly in gasket. Tighten nut.

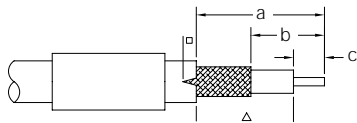
CRIMP-CRIMP TYPES



outer ferrule bushing male contact plug body assembly
 ♦ This part is used only with RG-62 cable

Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data				Stripping Dimensions, inches (mm)		
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944	CTL Series Tool No.	a	b	c
36825	TNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2318	TNC Bulkh. Jack	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-2367	TNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2367-RFX	TNC Plug	58, 141, 142A	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
31-2368	TNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2373	TNC Plug	55, 142, 223	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2381	TNC Angle Plug	55, 142, 223, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-4452	TNC Plug	142, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2242	TNC Plug	179,187	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-2242-RFX	TNC Plug	179,187	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
31-2264	TNC Blkh Jack	59,62,140,210	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2264-RFX	TNC Blkh Jack	59	.068 (1.7)	.255 (8.5)	227-1331-13	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-2264-RFX	TNC Blkh Jack	62	.068 (1.7)	.255 (8.5)	227-1331-13	CTL-1	.689(17.5)	.362(9.2)	.197(5.0)
▲ 31-2315	TNC Plug	174,188	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
▲ 31-2315-RFX	TNC Plug	174,188,316	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
▲ 31-2317	TNC Jack	174,188	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
▲ 31-2318	TNC Blkh Jack	174,187,188	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
31-2368-RFX	TNC Plug	59	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.157(4.0)
31-2368-RFX	TNC Plug	62	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.197(5.0)
31-2381	TNC Angle Plug	55,142	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-2382	TNC Angle Plug	58,141	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-2383	TNC Angle Plug	62	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.689(17.5)	.362(9.2)	.156(4.0)
31-2389	TNC Blkh Jack	58,141	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2389-RFX	TNC Blkh Jack	141,142	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-2367-RFX	TNC Plug	58,141	.068	.213	227-1221-11	CTL-1,5	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-5849-RFX	TNC Angle Plug	58,58c	Solder	.213	227-1221-11	CTL-1,3,5	.709(18)	.382(9.7)	.161(4.1)
31-6000-RFX	TNC Plug	8x,LMR240	.068	.255	227-1221-13	CTL-1,5	.630 (16)	.303 (7.7)	.157 (4.0)
31-6001-RFX	TNC Plug	B8214, B9913	Solder	.429	227-1221-25	CTL-4	.630 (16)	.303 (7.7)	.157 (4.0)
31-6002-RFX	TNC Angle Plug	LMR 400, B9913, B9914	Solder	.429	227-1221-25	CTL-4	.728 (18.5)	.401 (0.2)	.244 (6.2)
31-6003-RFX	TNC Angle Plug	8x,LMR240	Solder	.255	227-1221-13	CTL-1,5	.728 (18.5)	.401 (10.2)	.244 (6.2)

Step 1

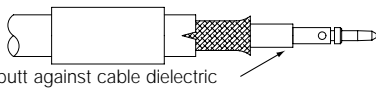


▲ For RG-174, 179, 187, 188, 316/U cables only, slit jacket back .100"(2.5mm) as shown. Before attaching center contact, slide metal spacer/TFE sleeve (not shown) over cable dielectric. The center contact should butt against the dielectric and TFE sleeve.

Step 1

Strip cable jacket, braid, and dielectric to dimensions in table above. All cuts are to be sharp and square. Important: Do not nick braid, dielectric, and center conductor. Slide outer ferrule onto cable as shown.

Step 2

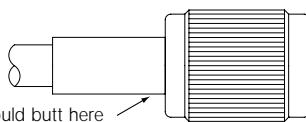


contact must butt against cable dielectric

Step 2

Flare slightly end of cable braid as shown to facilitate insertion of inner ferrule. Important: Do not comb out braid. Place contact on cable center conductor so that it butts against cable dielectric. Crimp contact in place using Die Set Cavity indicated in table above.

Step 3



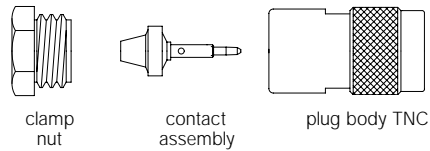
outer ferrule should butt here

cable dielectric must butt insulator

Step 3

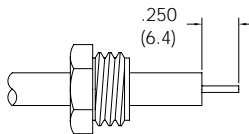
Install cable assembly into body assembly so that inner ferrule portion slides under braid. Push cable assembly forward until contact snaps into place in insulator. Slide outer ferrule over braid and up against connector body. Crimp outer ferrule using Die Set Cavity in table above.

QUICKTRIM® PLUG



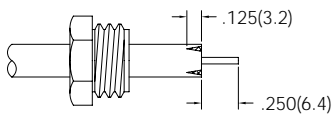
Amphenol Number	Cable RG-/U	Center Contact Affixment		
		Hex Size	Die Set for Tool 227-944	CTL Series Tool Number
31-5061	59, 59A, 62, 62A	.068(1.7)	227-1221-13 Cavity B	CTL-1

Step 1A



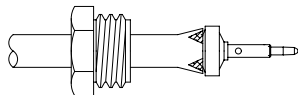
Step 1A For all cables listed, except Plenum 62. Slide clamp nut over cable. Strip cable to dimension shown. Cut braid and dielectric square. Do not nick center conductor.

Step 1B



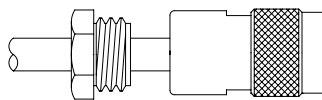
Step 1B For Plenum 62 (IBM 4885584). Same as step 1A, and then slit jacket back .125" (3.2 mm) in four places 90° apart as shown in illustration.

Step 2



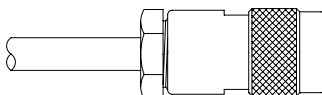
Step 2 Slide contact assembly under braid and jacket until braid butts as shown. Use caution that braid slides over contact assembly and not inside of it. Be sure center conductor is visible through side hole of contact. Crimp contact to conductor using Amphenol CTL-1 crimp tool; or by using die set 227-1221-13 cavity B in tool frame 227-944.

Step 3



Step 3 Insert into connector body.

Step 4



Step 4 Tighten clamp nut to a torque of 35 lbf-in.