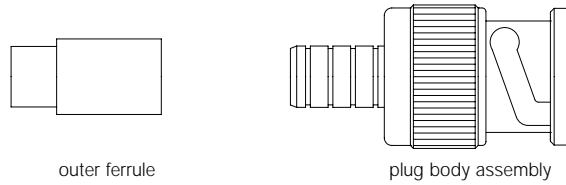
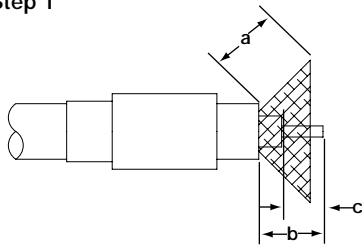


2-PIECE CRIMP PLUGS



Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data			Stripping Dimensions, inches (mm)			
			Cavity for Outer Ferrule	Die Set for Tool 227-944*	CTL Series Tool Number	a	b	c	d
31-5556-RFX	BNC Plug	59, 62	.324(8.2)	227-1221-32	CTL-2	.437(11.1)	.312(7.9)	.248(6.3)	.125(3.2)
31-5557-RFX	BNC Plug	58	.324(8.2)	227-1221-32	CTL-2	.437(11.1)	.312(7.9)	.248(6.3)	.125(3.2)
31-5560-RFX	BNC Plug	Plenum 59, 62	.324(8.2)	227-1221-32	CTL-2	.437(11.1)	.312(7.9)	.248(6.3)	.125(3.2)

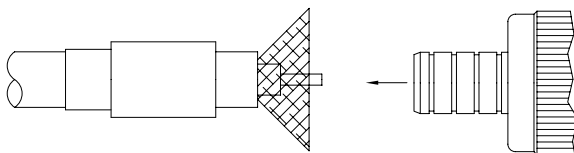
Step 1



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.

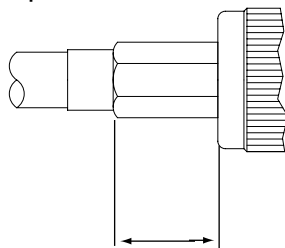
Step 2 Flare slightly end of cable braid as shown to facilitate insertion of inner ferrule of connector. Important: Do not comb out braid.

Step 2

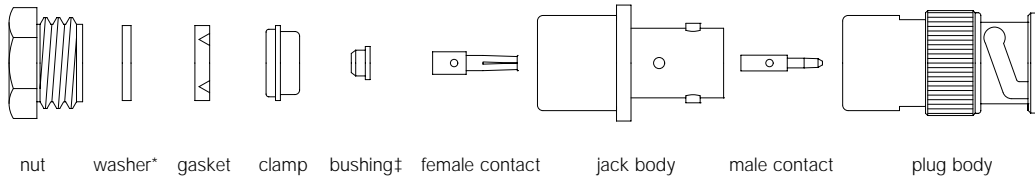


Step 3 Install cable assembly into body assembly so that inner ferrule portion slides under braid. Slide outer ferrule over braid and up against connector. Crimp outer ferrule using Die Set Cavity specified in table above.

Step 3



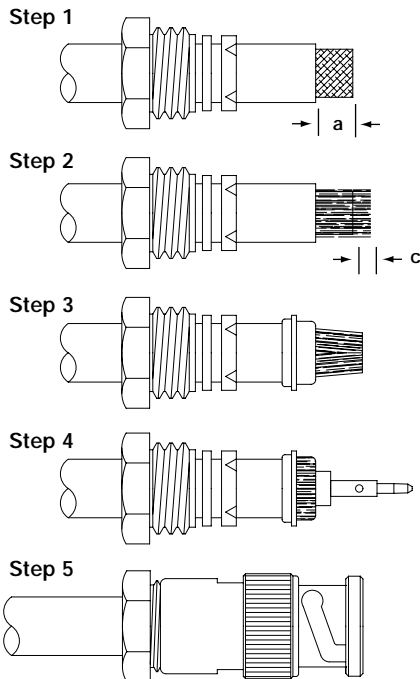
CLAMP CONNECTORS



* Not supplied on all items

‡ For use on RG-62, 71, 122, 178, 180, 196, 210

Amphenol Number	Connector Type	Cable RG-/U	Stripping Dims, Inches (Millimeters)	
			a	c
6775	BNC Plug	8, 9, 11, 213, 214	.490(12.4)	.200(5.1)
6775-75	75Ω BNC Plug	11	.490(12.4)	.200(5.1)
8525	BNC Angle Plug	58, 141, 142, 400	.343(8.7)	.187(4.7)
8575	BNC Angle Plug	59, 62, 140, 210	.297(7.5)	.094(2.4)
9350	BNC Plug	6	.405(10.3)	.094(2.4)
15875	BNC Plug	178, 196	.156(3.96)	.078(1.98)
16300	BNC Plug	180	.250(6.4)	.094(2.4)
33275	BNC Angle Plug	174, 179, 187, 188, 316	.540(13.7)	.156(3.96)
69475	BNC Plug	174, 179, 187, 188, 316	.281(7.1)	.172(4.4)
84975	BNC Plug	122	.281(7.1)	.172(4.4)
86350	BNC Bulkhead Jack	174, 179, 187, 188, 316	.265(6.73)	.156(3.96)
86425	BNC Panel Jack	174, 179, 187, 188, 316	.313(7.95)	.203(5.15)
86850	BNC Bulkhead Jack	178, 196	.266(6.75)	.109(2.76)
31-2	BNC Plug	58, 141, 142, 400	.312(7.9)	.094(2.4)
31-2-RFX	BNC Plug	58, 141, 142A	.315(8.0)	.118(3.0)
31-15	BNC Jack	59, 62, 71, 140, 210	.297(7.54)	.109(2.75)
31-202	BNC Plug	55, 58, 141, 142, 223, 400	.274(6.95)	.094(2.4)
31-204	BNC Angle Plug	55, 58, 141, 142, 223, 400	.297(7.54)	.109(2.8)
31-206	BNC Bulkhead Jack	58, 141, 142, 400	.297(7.5)	.109(2.8)
31-207	BNC Bulkhead Jack	59, 62, 71, 140, 210	.297(7.54)	.209(2.75)
31-212	BNC Plug	59, 62, 71, 140, 210, 302	.250(6.4)	.094(2.4)
31-212-1005	BNC Plug	59 (20GA CC)	.250(6.4)	.094(2.4)
31-850	BNC Angle Plug	59, 62, 71, 140, 210	.375(9.52)	.125(3.17)
31-3202	BNC Plug	55, 58, 141, 142, 223, 400	.250(6.4)	.094(2.4)
31-3301	BNC Plug	58, 141, 142, 223	.250(6.4)	.094(2.4)
31-3302	BNC Plug	59, 62, 71, 140, 210	.250(6.4)	.094(2.4)



▲ For angle plugs only: (except 31-204) Solder center conductor to preassembled contact. Assemble cap and lightly punch center of cap for retention in body, or solder in place.

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. [For RG-62, 71 and 210/U cable, trim an additional .032"(0.8mm) of insulation off center conductor and add bushing.] Tin center conductor.

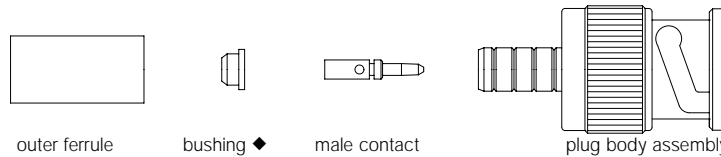
Step 3 Pull braid wires forward and taper toward center conductor. Place clamp over braid and push back against cable jacket.

Step 4 Fold back braid wires as shown, trim to proper length [approximately .125" (3.2mm) long] and form over clamp as shown. Braid wire should not extend beyond step of braid clamp. Solder contact to center conductor, sliding bushing first (when supplied) over center conductor. ▲

Step 5 Insert cable and parts into connector body. Make sure sharp edge of clamp seats properly in gasket. Tighten nut to approximately 15 inch pounds.

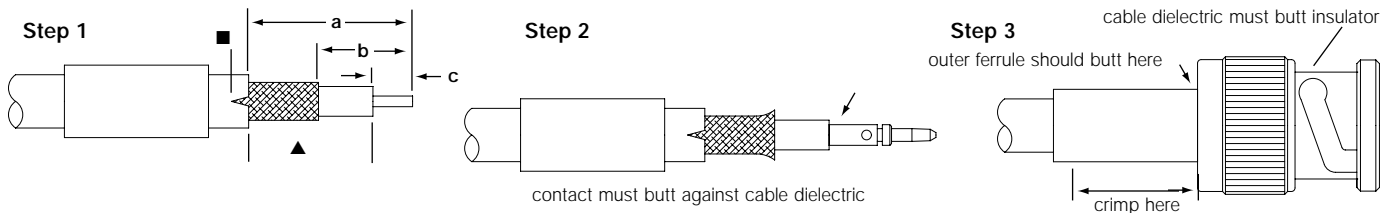
Assembly Instructions-C26 BNC

3-PIECE CRIMP PLUGS



◆ used with RG-62, 71, 210 cable only

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 Number	a	b	c
36650-1003	BNC Plug	Belden 82907, 88240 89907, Plenum 58	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
36650-3RFX	BNC Plug	Plenum 58	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.630(16.0)	.319(8.1)	.157(4.0)
36875	BNC Plug	55, 142, 223, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
68175-1003	BNC Plug	Belden 9259	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
68175-1005	BNC Plug	59 (20AG CC)	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
68175-1011	BNC Plug	Belden 1560A, 82259, 89259, Plenum 59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
68175-11RFX	BNC Plug	Plenum 59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.157(4.0)
68175-5RFX	BNC Plug	59 (20GA CC)	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.157(4.0)
31-242	BNC Plug	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-242-RFX	BNC Plug	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
31-315	BNC Plug	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-315-RFX	BNC Plug	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-315-1005	BNC Plug	Dbl. Br. 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-320	BNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-320-RFX	BNC Plug	58A, 141, 142A	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
31-320-1006	BNC Plug	Belden 9907, 89907	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-321	BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-321-RFX	BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
31-321-1000	BNC Plug	Belden 8281, 88281	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-321-10RFX	BNC Plug	Belden 8281	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.630(16.0)	.303(7.7)	.156(4.0)
31-325	BNC Plug	Belden 8218	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-326	BNC Plug	55, 142, 223	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-326-RFX	BNC Plug	55, 142, 223, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-4320	BNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-4321	BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-4411	BNC Plug	Belden 8213	.100(2.5)	.429(10.9)	227-1221-25	CTL-3	.650(16.5)	.250(6.4)	.156(4.0)
31-4427	BNC Plug	142, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-5558-RFX	BNC Plug	6 Type (.314OD)	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.630(16.0)	.303(7.7)	.156(4.0)
31-5800	BNC Plug	58, 141, PL-58	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-5900	BNC Plug	59, 62, 59 (20GA CC), Plenum -59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)



Step 1 Strip cable jacket, braid, and dielectric to dimensions in table above. [for RG-62,71,210/U cable, trim an additional .039"(1.0mm) of insulation off center conductor and add bushing] All cuts are to be sharp and square. Important: Do not nick braid, dielectric, and center conductor. Slide outer ferrule onto cable as shown.

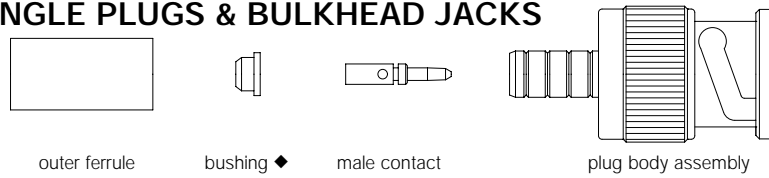
Step 2 Flare slightly end of cable braid as shown to facilitate insertion of inner ferrule. Important: Do not comb out braid ▲. Place contact on cable center conductor so that it butts against cable dielectric. Crimp contact in place using Die Set Cavity indicated in table above. When using RG-62, 71, 210 cable, install bushing over center conductor before installing contact.

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 specified in table above.

▲ 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 and under braid. The center contact should butt against the dielectric and TFE sleeve.

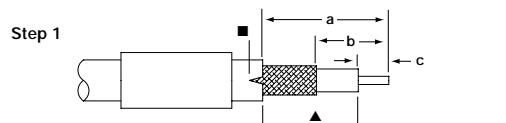
* for pneumatic crimp tool 227-60, use die sets indicated in this column.

3-PIECE CRIMP ANGLE PLUGS & BULKHEAD JACKS

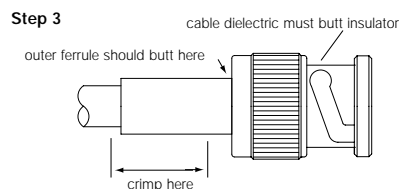
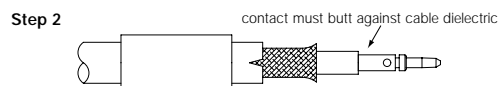


◆ used with RG-62, 71, 210 cable only

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 Number	a	b	c
36800	BNC Jack	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
36800-RFX	BNC Jack	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
68150	BNC Jack	59, 62, 140	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
95700	BNC Bulkhead Jack	55, 142, 223	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-245	BNC Bulkhead Jack	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-316	BNC Angle Plug	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.578(14.6)	.328(8.3)	.125(3.1)
31-317	BNC Jack	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-318	BNC Bulkhead Jack	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-318-RFX	BNC Bulkhead Jack	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.630(16.0)	.362(9.2)	.156(4.0)
31-318-1001	BNC Bulkhead Jack	DbL Br. 316	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-245-RFX	BNC Bulkhead Jack	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.630(16.0)	.362(9.2)	.156(4.0)
31-334	BNC Angle Plug	55, 142, 223, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.578(14.6)	.328(8.3)	.125(3.1)
31-335	BNC Angle Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-335-RFX	BNC Angle Plug	58, 144	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.677(17.2)	.350(8.9)	.156(4.0)
31-336	BNC Angle Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-336-RFX	BNC Angle Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.677(17.2)	.350(8.9)	.156(4.0)
31-342	BNC Bulkhead Jack	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-342-RFX	BNC Bulkhead Jack	58, 141, 142, 223	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-343-1002	BNC Bulkhead Jack	Pl. 59 (20 AWG)	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-343-RFX	BNC Bulkhead Jack	59, 62, 140, 210	.068(1.7)	.255(6.5)	227-1221-11	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-4327	BNC Jack	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-5911-RFX	BNC Angle Plug	58, 141	Solder	.213	227-1221-11	CTL-1,3,5	.709(18.0)	.382(9.7)	.161(4.1)
31-5914-RFX	BNC Angle Plug	59	Solder	.255	227-1221-13	CTL-1,5,6,8	.709(18.0)	.382(9.7)	.161(4.1)
31-5991-RFX	BNC Angle Plug	316	Solder	.128	227-1221-3	CTL-9,13	.618(15.7)	.350(8.9)	.157(4.0)
31-316-RFX	BNC Angle Plug	316	Solder	.128	227-1221-3	CTL-9,13	.618(15.7)	.350(8.9)	.157(4.0)
31-70239	BNC Angle Plug	734A	.042	.255	—	CTL-14	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-70240	BNC Angle Plug	735A	.042	.187	—	CTL-15	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-70234	BNC Plug	Beld 1694	.042	.319	—	CTL-14	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-70235	BNC Plug	Beld 8281	.042	.324	—	CTL-14	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-70236	BNC Plug	Beld 8218	.042	.178	—	CTL-15	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-70237	BNC Plug	734A	.042	.255	—	CTL-14	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-70238	BNC Plug	735A	.042	.187	—	CTL-15	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-315-RFX	BNC Plug	174,188,316	.068	.178	227-1221-9	CTL-2	.593 (15.1)	.250 (6.4)	.156 (4.0)
31-317-RFX	BNC Jack	174,188,316	.068	.178	227-1221-9	CTL-2	.634 (16.1)	.303 (7.7)	.156 (4.0)
31-335-RFX	BNC Angle Plug	58,141,142	.068	.213	227-1221-11	CTL-1,5	.677 (17.2)	.350 (8.9)	.157 (4.0)
31-5998-RFX	BNC Plug	B8214,B9913,B9914	.118	.429	227-1221-61	CTL-11	.630 (16)	.303 (7.7)	.157 (4.0)
31-5999-RFX	BNC Plug	8x,LMR240	.068	.255	227-1221-13	CTL-1,5	.630 (16)	.303 (7.7)	.157 (4.0)
31-6004-RFX	BNC Angle Plug	B9913,B9914	Solder	.429	227-1221-25	CTL-4	.728 (18.5)	.401 (10.2)	.244 (6.2)
31-6005-RFX	BNC Angle Plug	8x,LMR240	Solder	.255	227-1221-13	CTL-1,5	.728 (18.5)	.401 (10.2)	.244 (6.2)
31-6006	BNC Plug	8x,LMR240	.068	.255	227-1221-13	CTL-1,5	.593 (15.1)	.250 (6.4)	.156 (4.0)



▲ For RG-174, 179, 187, 188, 316/U cables only, slit jacket back .100"(.25mm) as shown. Before attaching center contact, slide metal spacer/TFE sleeve (not shown) over cable dielectric and under braid. The center contact should butt against the dielectric and TFE sleeve.



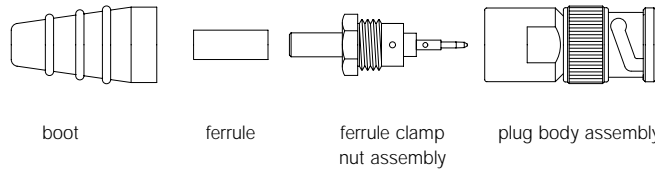
Step 1 Strip cable jacket, braid, and dielectric to dimensions in table above. [for RG-62,71,210/U cable, trim an additional .039"(.10mm) of insulation off center conductor and add bushing] All cuts are to be sharp and square. Important: Do not nick braid, dielectric, and center conductor. Slide outer ferrule onto cable as shown.

Step 2 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. When using RG-62, 71, 210 cable, install bushing onto center conductor before installing contact.

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 specified in table above.

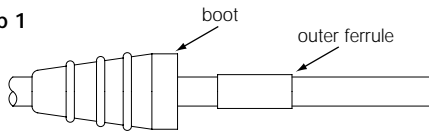
* for pneumatic crimp tool 227-60, use die sets indicated in this column

ORIGINAL CRIMP PLUGS



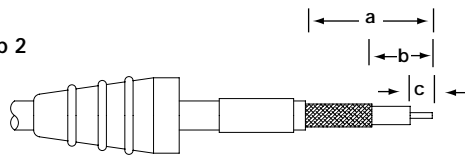
Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data			Stripping Dimensions, inches (mm)		
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944*	a	b	c
31-351	BNC Plug	58, 141	—	.213(5.4)	227-1221-11	.922(23.4)	.516(13.1)	.250(6.3)
31-359	BNC Plug	59, 62, 140	—	.255(6.5)	227-1221-13	.922(23.4)	.516(13.1)	.250(6.3)
31-371	BNC Plug	174, 179, 187, 188, 316	—	.128(3.2)	227-1221-3	.797(20.2)	.516(13.1)	.250(6.3)

Step 1



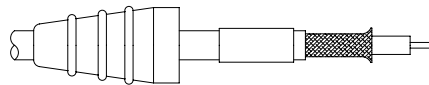
Step 1 Install boot and slide outer ferrule onto cable as shown prior to stripping cable.

Step 2



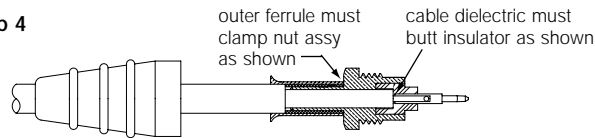
Step 2 Strip cable jacket, braid and dielectric to dimensions shown. See attached table for dimensions. All cuts are to be sharp and square. Important: DO NOT nick braid, dielectric, and center conductor when cutting. Tin center conductor using soft solder per QQ-S-571 comp Sn 60. Avoid excessive heat while tinning to prevent swelling of cable dielectric.

Step 3



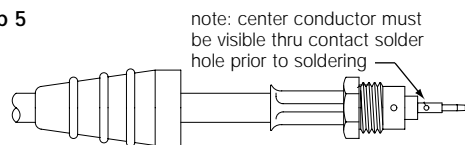
Step 3 Slightly flare out end of cable braid as so as to facilitate insertion onto ferrule clamp nut assembly. Important: DO NOT comb out braid.

Step 4



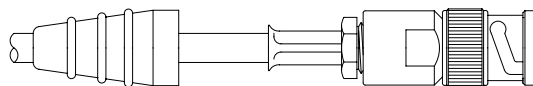
Step 4 Install ferrule clamp nut assembly onto cable so that ferrule portion slides under braid and insulator butts flush against cable dielectric. Slide outer ferrule over braid and up against nut. Make sure no slack exists in braid. Crimp outer ferrule with tool specified in table above, keeping cable dielectric bottomed against insulator.

Step 5



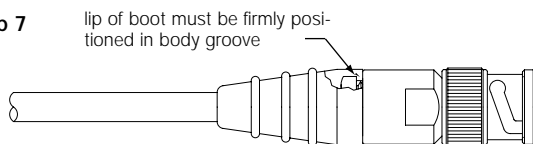
Step 5 Soft solder center conductor to contact using rosin core per QQ-S-571 comp Sn 60. DO NOT get any solder on outside surfaces of contact.

Step 6



Step 6 Screw connector body onto prepared cable termination. Wrench tighten by holding the cable nut assembly STATIONARY while ROTATING the connector body.

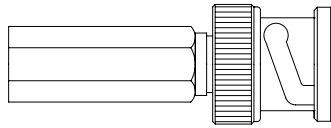
Step 7



Step 7 Push body forward and into position as shown to complete assembly.

* for pneumatic crimp tool 227-60, use die sets indicated in this column

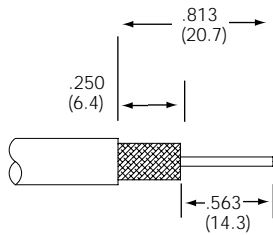
SURETWIST® PLUG



BNC SURETWIST® plug

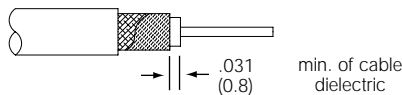
Amphenol Number	Connector Type	Cable RG-/U
31-5136	BNC Plug	59
31-5136-RFX	BNC Plug	59
31-5137	BNC Plug	58
31-5137-RFX	BNC Plug	58

Step 1



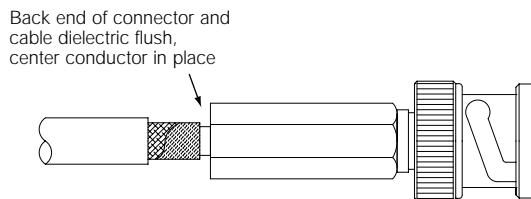
Step 1 Strip cable as shown. Take care not to nick center conductor or outer braid.

Step 2



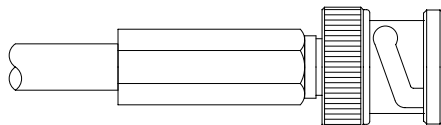
Step 2 Twist outer braid in a clockwise direction so that at least 1/32" of cable dielectric is bared, and braid is left flat. (Stray or loose braid can cause shorts.)

Step 3



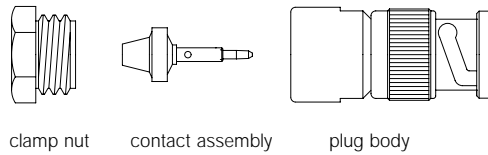
Step 3 Gently insert center conductor into back end of connector, "feeling" it into the guide hole. (If center conductor is NOT properly in place, about 1/8" of center conductor will show at the back end. Reinsert until cable dielectric reaches position shown in illustration.)

Step 4

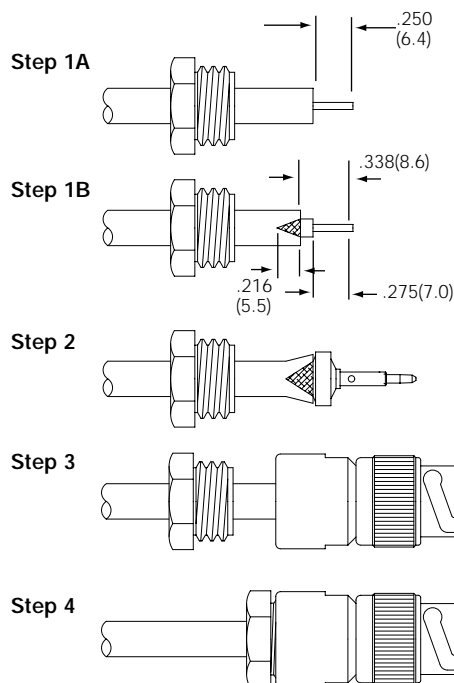


Step 4 Push the cable firmly home (as far as possible). Then screw the connector onto the cable in a clockwise direction until it stops. Assembly is complete.

QUICKTRIM® PLUG



Amphenol Number	Connector Type	Cable RG-/U	Center Contact Affixment		
			Hex Size	Die Set for Tool 227-944*	CTL Series Tool Number
31-4541	BNC Plug	59, 59A, 62, 62A	.068(1.7)	227-1221-13 Cavity B	CTL-1
31-4541-RFX					
31-4542	BNC Plug	Belden 9268 Montrose CBL-5098			
31-30220-1	BNC Plug	58			
31-30220-8	BNC Plug	223			



Step 1A For all connectors except 31-4541-RFX (see step 1B). Slide clamp nut over cable. Strip cable to dimension shown. Cut braid and dielectric square. Do not nick center conductor.

Step 1B For 31-4541-RFX.. Same as step 1A except use Step 1B strip dimensions, and then slit jacket back .125"(3.2 mm) in four places 90° apart as shown in illustration.

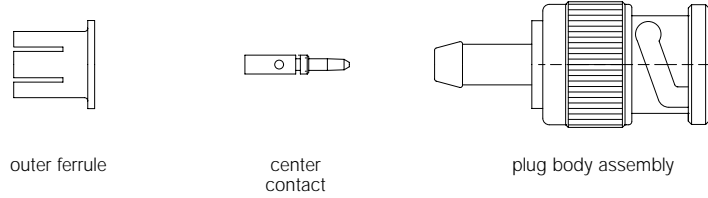
Step 2 Slide contact assembly under braid and jacket until braid butts as shown. Use caution that braid slides over contact assembly and not inside of it. Be sure center conductor is visible through side hole of contact. Solder contact to center conductor. Contact may be crimped on applicable connectors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

Step 3 Insert into connector body.

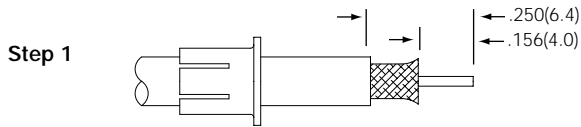
Step 4 Tighten clamp nut to a torque of 35 lbf-in.

* for pneumatic crimp tool 227-60, use die sets indicated in this column

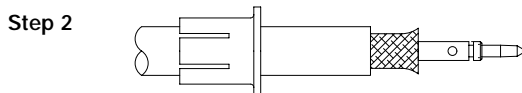
PLUGS FCP TERMINATION



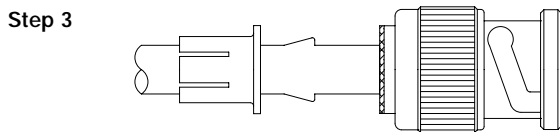
Amphenol Number	Connector Type	Cable RG-/U
31-4700	BNC Plug	58, 141
31-4702	BNC Plug	59



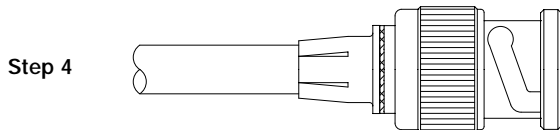
Step 1 Slide ferrule over cable end, slotted end first. Strip cable to dimensions shown. Do not nick center conductor. Flare braid slightly as shown.



Step 2 Tin exposed center conductor. Solder center contact on center conductor. Use minimum heat to avoid damaging cable insulation. Remove any excess solder and flux from contact surface. Contact may be crimped using 227-1221-11 die set (cavity B) .068 hex in tool handle 227-944 or equivalent tool.

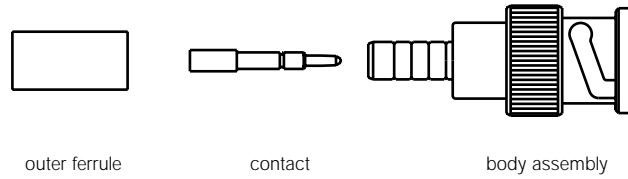


Step 3 Slide body over contact and cable insulation with barb going UNDER flared braid. Push body until shoulder is against cable jacket. Braid will flare out against body shoulder.



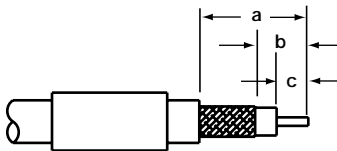
Step 4 Grasp cable with hand and push ferrule over barb until braid is captured between ferrule and body flange. Assembly is complete.

CRIMP TERMINATION FOR TYPE 1 – 75Ω CONNECTORS



Amphenol Connector Cable Number	Connector Cable Type	Hex Crimp Data RG-/U	Stripping Dimensions, inches (mm)			a	b	c
			Cavity for Contact	Cavity for Outer Ferrule	CTL Series Tool No.			
31-70000	75Ω BNC Plug	6, Belden 9248, Plenum 6	.052(1.3) sq.	.324(8.2)	CTL-8	.577(14.7)	.234(5.9)	.140(3.6)
31-70000-1000	75Ω BNC Plug	6, Belden 9248	.052(1.3) sq.	.324(8.2)	CTL-8	.577(14.7)	.234(5.9)	.140(3.6)
31-70008	75Ω BNC Plug	59	.052(1.3) sq.	.255(6.5)	CTL-6 or 8	.577(14.7)	.234(5.9)	.140(3.6)
31-70008-1000	75Ω BNC Plug	59 (20GA CC)	.052(1.3) sq.	.255(6.5)	CTL-6 or 8	.577(14.7)	.234(5.9)	.140(3.6)
31-70008-3000	75Ω BNC Plug	59 (.032 CC)	.052(1.3) sq.	.255(6.5)	CTL-6 or 8	.577(14.7)	.234(5.9)	.140(3.6)
31-70009	75Ω BNC Jack	59	.052(1.3) sq.	.255(6.5)	CTL-6 or 8	.557(14.1)	.214(5.4)	.156(4.0)
31-70013	75Ω BNC Plug	179, 187	.052(1.3) sq.	.178(4.5)	CTL-6	.577(14.7)	.234(5.9)	.140(3.6)
31-70013-1000	75Ω BNC Plug	Dbl. Br. 179, ATT19224-L2	.052(1.3) sq.	.178(4.5)	CTL-6	.594(15.1)	.250(6.4)	.156(4.0)
31-70015-1000	75Ω BNC Angle Plug	Dbl. Br. 179, ATT19224-L2	.052(1.3) sq.	.178(4.5)	CTL-6	.649(16.5)	.435(11.0)	.125(3.2)
31-70016	75Ω BNC Jack	179, 187	.052(1.3) sq.	.178(4.5)	CTL-6	.886(22.5)	.451(11.4)	.140(3.6)
31-70016-1000	75Ω BNC Bulk. Jack	Dbl. Br. 179, ATT19224-L2	.052(1.3) sq.	.178(4.5)	CTL-6	.886(22.5)	.451(11.4)	.140(3.6)
31-70022	75Ω BNC Plug	ATT 728B, Belden 9231	.068(1.7)hex	.324(8.2)	CTL-8	.579(15.1)	.125(3.2)	.125(3.2)
31-70082	75Ω BNC Angle Plug	ATT 735A	Solder Only	.160(4.1)	▲	.635(16.1)	.385(9.8)	.200(5.1)
31-70222	75Ω BNC Plug	Belden 8281, 9231	.052(1.3) sq.	.324(8.2)	CTL-8	.577(14.7)	.234(5.9)	.140(3.6)

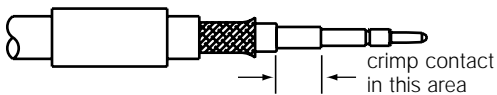
Step 1



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

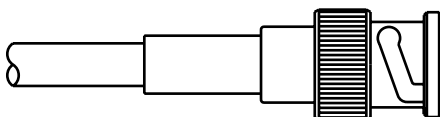
Step 1 Slide outer ferrule over cables shown. Flare slightly end of cable braid as shown to facilitate insertion of inner ferrule. **IMPORTANT:** Do not comb out braid.

Step 2



Step 2 Place contact onto center conductor so it butts against cable dielectric. Crimp contact in place.

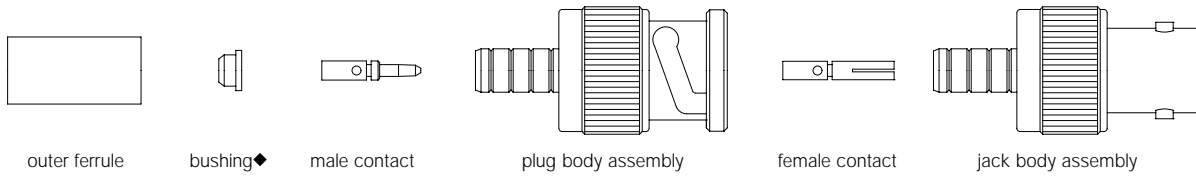
Step 3



Step 3 Install cable assembly into body assembly so inner ferrule slides over sleeve and under braid. Push cable assembly forward until contact seats in insulator. Slide outer ferrule over braid and up against connector body. Crimp outer ferrule.

▲ use die set 227-1448 with tool frame 227-944

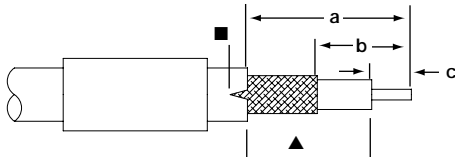
CRIMP TERMINATION FOR TYPE 2 – 75Ω CONNECTORS



◆ for use on RG-62, 71, 210 cable only

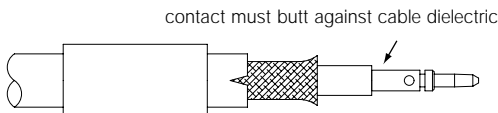
Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data				Stripping Dimensions, inches (mm)		
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944*	CTL Series Tool No.	a	b	c
31-71000-RFX	75Ω BNC Plug	6	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71008	75Ω BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-71008-RFX	75Ω BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
31-71008-1RFX	75Ω BNC Plug	59 (20GA CC)	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
31-71008-1000	75Ω BNC Plug	59, 62 (20GA CC)	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-71008-2000	75Ω BNC Plug	Plenum -59, B89269	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-71010	75Ω BNC Angle Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-71010-RFX	75Ω BNC Plug	59	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.677(17.2)	.350(9.0)	.156(4.0)
	75Ω BNC Plug	62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.677(17.2)	.350(9.0)	.197(5.0)
31-71011	75Ω BNC Bulk. Jack	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-71011-RFX	75Ω BNC Bulk. Jack	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-71013	75Ω BNC Plug	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.539(15.1)	.250(6.4)	.156(4.0)
31-71013-RFX	75Ω BNC Plug	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
31-71013-1000	75Ω BNC Plug	Dbl. Br. RG-179	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71014-RFX	75Ω BNC Jack	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.571(14.5)	.303(7.7)	.157(4.0)
31-71016	75Ω BNC Bulk. Jack	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71016-RFX	75Ω BNC Bulk. Jack	179, 187	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.630(16.0)	.362(9.2)	.157(4.0)
31-71032	75Ω BNC Plug	B8281, 88281	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71033	75Ω BNC Plug	B8218	.068(1.7)	.178(4.5)	227-1221-9	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71034	75Ω BNC Plug	Belden 89292	.100(2.5)	.429(10.9)	227-1221-25	CTL-3	.593(16.7)	.250(6.4)	.156(4.0)
31-71035	75Ω BNC Plug	PL-59 (20GA CC)	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-71064	75Ω BNC Plug	Belden 9248, Pl-6	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71065	75Ω BNC Plug	Belden 9290	.068(1.7)	.324(8.2)	227-1221-32	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-71066	75Ω BNC Plug	Quad Shield 59	.068(1.7)	.263(6.7)	227-1221-15	—	.593(15.1)	.250(6.4)	.156(4.0)

Step 1

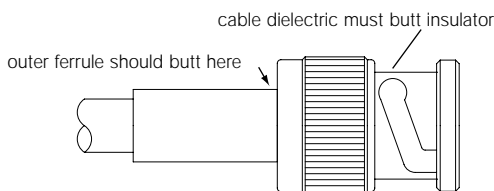


■▲ For RG-174, 179, 187, 188, 316/U cables only, slit jacket back .100" (2.5mm) as shown. Before attaching center contact TFE sleeve (not shown) over cable dielectric and under braid. For 31-71016, before attaching center contact. Slide metal spacer/TFE sleeve (not shown) over cable dielectric and under braid. The center contact should butt against the dielectric and TFE sleeve.

Step 2



Step 3



Step 1

Strip cable jacket, braid, and dielectric to dimensions in table above. [for RG-62,71,210/U cable, trim an additional .039" (1.0mm) of insulation off center conductor and add bushing] 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

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. When using RG-62, 71, 210, install bushing over center conductor before installing contact.

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 specified in table above.

* for pneumatic crimp tool 227-60, use die sets indicated in this column