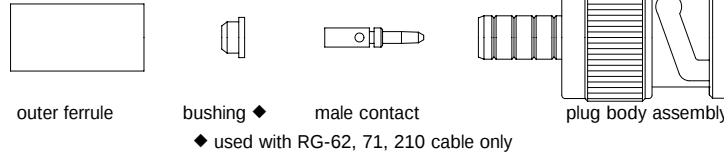


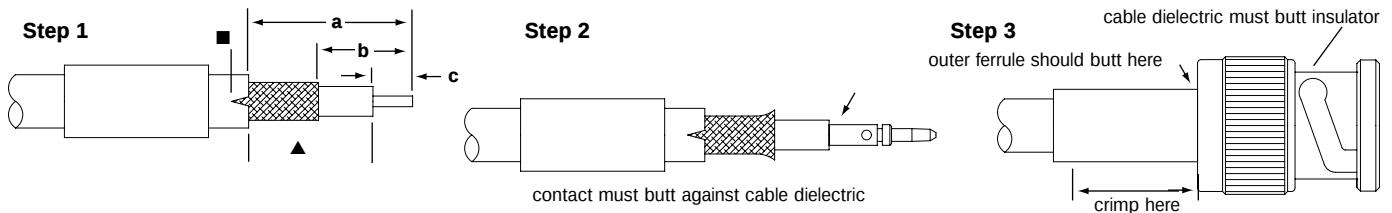
Assembly Instructions-C26 BNC

Amphenol®

3-PIECE 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*	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	.654(16.6)	.323(8.2)	.118(3.0)
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.