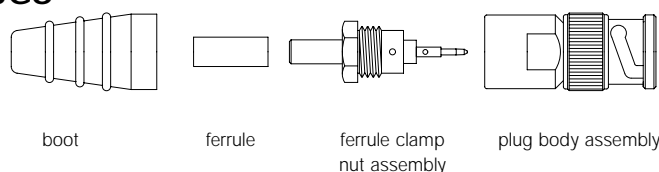
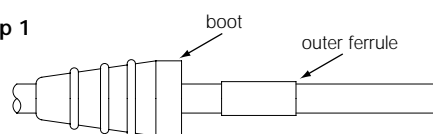


## ORIGINAL CRIMP PLUGS



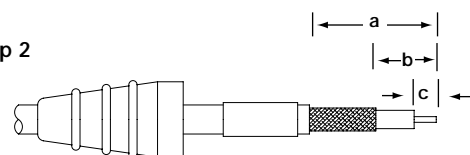
Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data			Stripping Dimensions, inches (mm)		
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944*	a	b	c
31-351	BNC Plug	58, 141	—	.213(5.4)	227-1221-11	.922(23.4)	.516(13.1)	.250(6.3)
31-359	BNC Plug	59, 62, 140	—	.255(6.5)	227-1221-13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



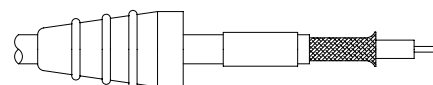
**Step 1** Install boot and slide outer ferrule onto cable as shown prior to stripping cable.

### Step 2



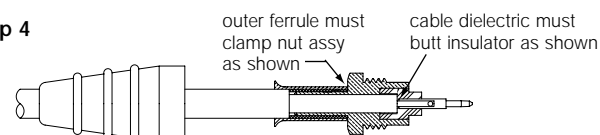
**Step 2** Strip cable jacket, braid and dielectric to dimensions shown. See attached table for dimensions. All cuts are to be sharp and square. Important: DO NOT nick braid, dielectric, and center conductor when cutting. Tin center conductor using soft solder per QQ-S-571 comp Sn 60. Avoid excessive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

### Step 3



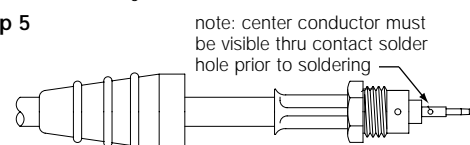
**Step 3** Slightly flare out end of cable braid as so as to facilitate insertion onto ferrule clamp nut assembly. Important: DO NOT comb out braid.

### Step 4



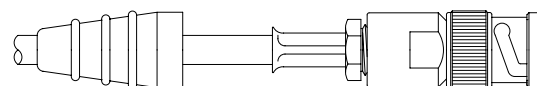
**Step 4** Install ferrule clamp nut assembly onto cable so that ferrule portion slides under braid and insulator butts flush against cable dielectric. Slide outer ferrule over braid and up against nut. Make sure no slack exists in braid. Crimp outer ferrule with tool specified in table above, keeping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

### Step 5



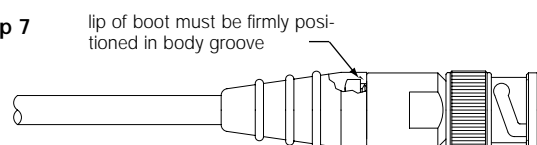
**Step 5** Soft solder center conductor to contact using rosin core per QQ-S-571 comp Sn 60. DO NOT get any solder on outside surfaces of contact.

### 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

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