

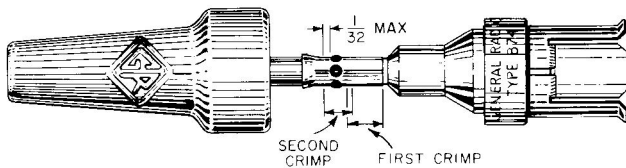
**Q.** Pull back cable to seat insulating bead against outer transition piece; align either key slot in bead with slot of outer transition piece by rotating transition.

**R.** Squeeze braid and jacket to restore fit about cable and transition.

**S.** Slide outer conductor (14) over insulating bead and outer transition piece; long key in conductor must engage slot in transition.

**T.** Bring coupling nut forward and thread on outer conductor.

**U.** Grip coupling nut with special wrench (0874-2611), insert outer-conductor wrench (15) in assembly and tighten firmly by rotating coupling nut. From 6 to 15 foot-pounds torque should be applied; there is *no* danger of overtightening.

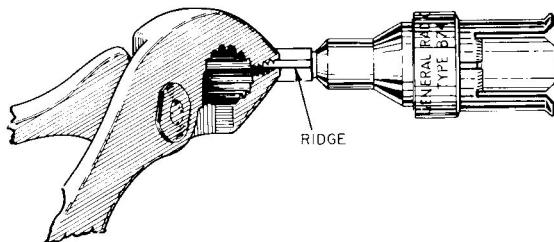


**V.** Slide ferrule forward over braid to within 1/64 inch of flare of outer transition piece; no braid should show through perforations.

**W.** Crimp ferrule as indicated using special tool (874-TO58). Crimps should overlap. To use, disengage ratchet lock by squeezing handles together, carefully position ferrule in 0.215-inch die with corners of hex centered over perforations, and squeeze handles together until ratchet lock releases.

**X.** Slide cable guard forward and seat snugly over coupling nut.

## ALTERNATE CRIMPING PROCEDURE



If special tool not available:

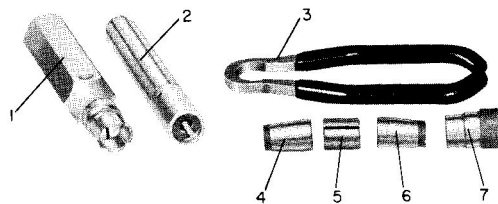
**A.** Substitute plain ferrule provided and perform steps A through U above. Slide ferrule over braid, to within 1/64 inch of flare of outer transition piece.

**B.** Press assembly against a fixed surface. Using pliers, pinch ridge of surplus metal longitudinally on ferrule, beginning at transition end, until tight crimp is accomplished.

**C.** Slide cable guard forward and seat snugly over coupling nut.

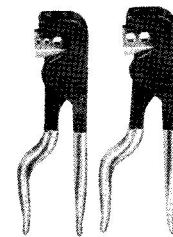
## SPECIAL TOOLS

### Type 874-TOK TOOL KIT



- |   |  |
|---|--|
| 1. Outer-conductor wrench ....(0874-2610) | 4. Front-ring expander (red) (0874-6820) |
| 2. Inner-conductor wrench ....(0874-2611) | 5. Keeper for ring expanders (0874-6840) |
| 3. Coupling-nut wrench ....(0874-6801)    | 6. Back-ring expander (green)(0874-6800) |
| 7. Ring pusher .....(0874-6830)           |  |

Type  
874-TO58



Type  
874-TO8

### CRIMPING TOOLS

## GENERAL RADIO COMPANY WEST CONCORD, MASSACHUSETTS

- |   |   |  |   |
|---|---|--|---|
| • NEW YORK: Broad Ave. at Linden<br>Ridgefield, N. J. | • SYRACUSE: Pickard Bldg., East Molloy Rd.<br>Syracuse 11, New York | • PHILADELPHIA: 1150 York Rd.<br>Abington, Pa.               | • WASHINGTON: 8055 13th St.<br>Silver Spring, Md. |
| • FLORIDA: 113 East Colonial Dr.<br>Orlando, Fla.     | • SAN FRANCISCO: 1186 Los Altos Ave.<br>Los Altos, Cal.             | • LOS ANGELES: 1000 North Seward St.<br>Los Angeles 38, Cal. | • CHICAGO: 6605 West North Ave.<br>Oak Park, Ill. |
|   |   |  | • CANADA: 99 Floral Pkwy.<br>Toronto 15, Ont.     |