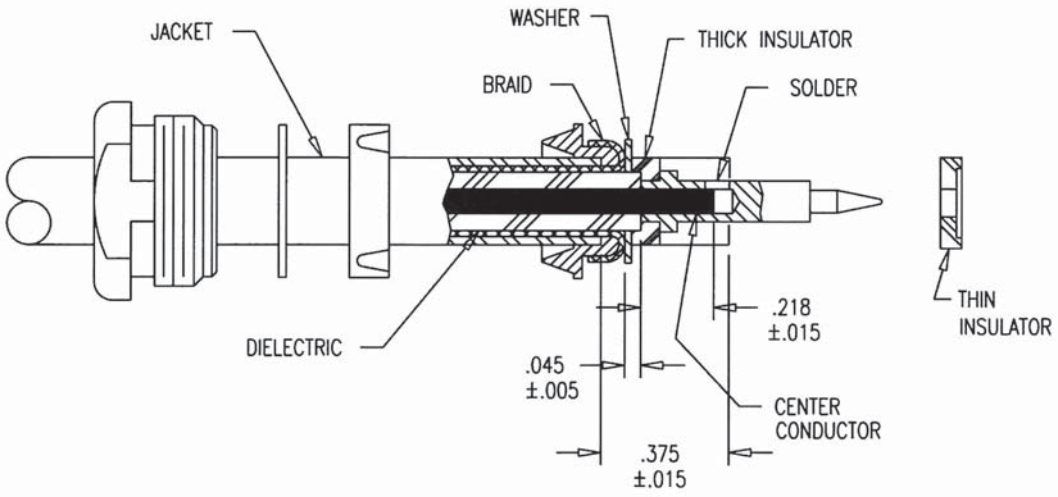
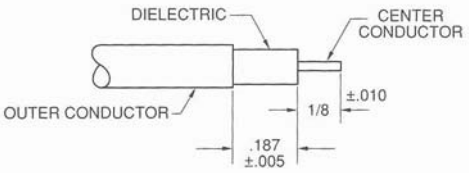
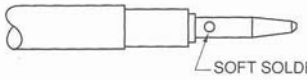


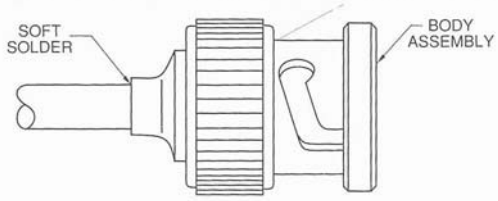
1. WITH CLAMP NUT, SLIP WASHER & GASKET ON CABLE, REMOVE JACKET TO .375 ±.015 DIM.
2. SLIDE BRAID CLAMP OVER BRAID AGAINST JACKET EDGE. COMB OUT BRAID WIRES, FOLD BACK OVER BRAID CLAMP & TRIM AS SHOWN.
3. REMOVE DIELECTRIC TO .045 ±.005 DIM. & TRIM CENTER CONDUCTOR TO .218 ±.015 DIM.
4. SLIDE WASHER OVER DIELECTRIC & AGAINST BRAID. PLACE THICK INSULATOR ON CONTACT & ASSEMBLE ON CABLE CENTER CONDUCTOR WITH DIELECTRIC BOTTOMED IN C'BORE AND SOLDER CONTACT IN POSITION. (DO NOT OVERHEAT)
5. ASSEMBLE THIN INSULATOR ON CONTACT WITH C'BORE TOWARD CONTACT TIP & THREAD ASSEMBLY SECURELY INTO CONNECTOR BODY.
   RECOMMENDED TORQUE: 55–60 IN. LBS.



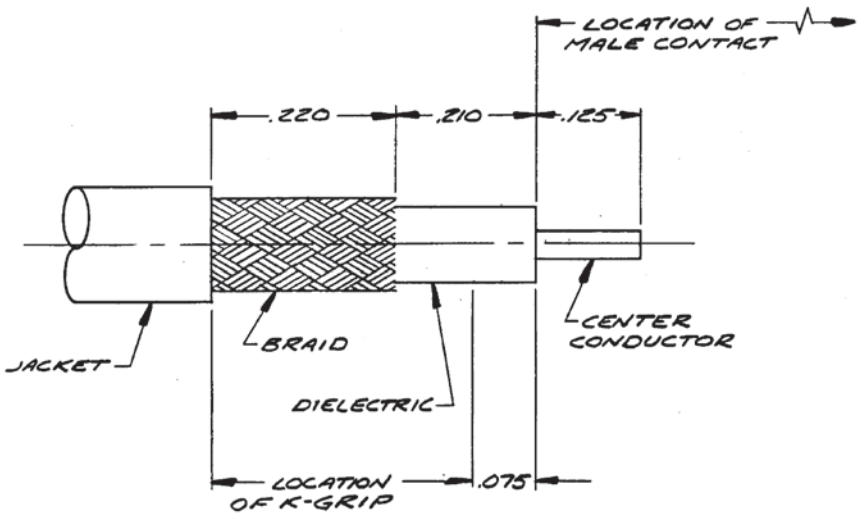
1. Remove outer conductor and dielectric to dimensions shown. (Care must be taken to remove all metal particles from dielectric surfaces.)

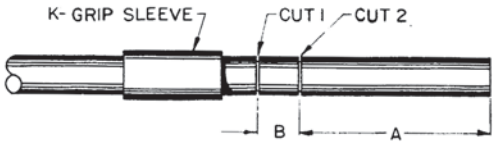


2. Assemble center contact in position against dielectric face & soft solder.



3. Place solder preform on cable, insert cable into body assembly until bottomed, hold in place and solder. (Apply a small amount of non-acid flux and heat at point directly behind body assembly on outer conductor.


LOCATION OF
MALE CONTACT
.220
.210
.125
JACKET
BRAID
DIELECTRIC
CENTER
CONDUCTOR
LOCATION
OF K-GRIP
.075



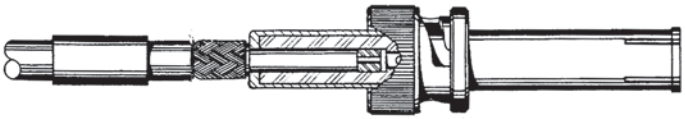
1. Cut cable end square, slide shrink tubing and K-grip sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

2. Remove jacket to dimension "A", flare or bluge back braid and trim with scissors at edge of jacket.

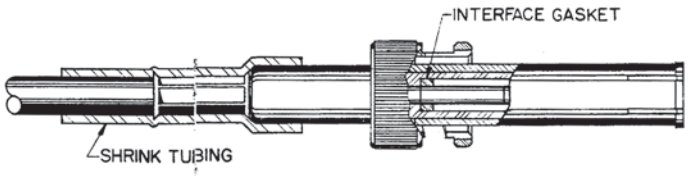
3. Remove jacket to dimension "B."

4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Place cable seal gasket over center conductor against dielectric then solder contact to center conductor. Gasket must be under compression after soldering is completed.



6. Push connector over dielectric and under braid until contact bottoms in insulator.



7. Slide K-grip sleeve over K-grip and braid to within 1/64 inch of shoulder of body and form hex. Then place tubing in position and shrink onto body and cable by heating (300°F Max). Install interface gasket over contact. (When Supplied) When Weatherproof Sleeve is used Heat Shrink Tubing is not required.

DASH NO.	TRIM CODE	TRIM DIMENSIONS A	B	C	D
-1	CP474	15/16	3/16	.890	15/64
-2	CP475	1 3/4	3/16	1.627	5/16
-3	CP476	2 35/64	3/16	2.415	5/16
-9	CP489	1	3/16	.948	15/64

UNLESS OTHERWISE SPECIFIED:

1. TOLERANCES: FRACTIONS ± .010 DECIMALS ± .004 ANGLES ± 0° 30' T. I. R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED THE SUM OF THEIR TOLERANCES.
2. REMOVE ALL BURRS. BREAK SHARP EDGES .005 MAX.
3. NO FILLETS PERMITTED.
4. SURFACE ROUGHNESS 63 MICROINCHES RMS MAX.
5. ALL DIMENSIONS PRIOR TO PLATING.

STEP 1. Prepare cable as shown in Figure 1. Cable end must be square. If it is not, use hacksaw to make new cut. Wrap tape around cable to guide jacketing cut. Remove jacket with knife. Cut off outer conductor and foam with hacksaw. Do not damage inner conductor. Use file to remove burrs and chamfer end of inner conductor. Clean exposed inner conductor of foam particles with garnet cloth. Wire brush copper particles from foam.

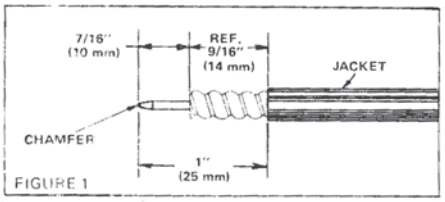


FIGURE 1

STEP 2. Place boot and clamping nut on cable with opening of boot toward cable end. See Figure 2. Secure clamping nut in place with tape, exposing outer conductor to dimension shown. Cut tabs into outer conductor to depth and intervals shown. Use mallet to tap knife. Use clamping nut as stop for knife.

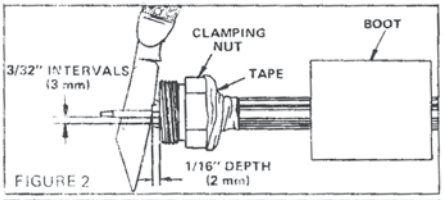


FIGURE 2

STEP 3. Turn tabs up 90 degrees with point of knife as shown in Figure 3. Remove tape from clamping nut.

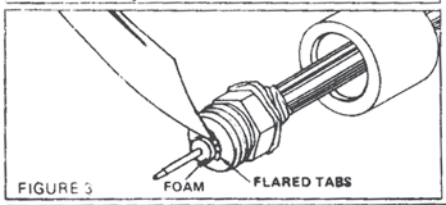


FIGURE 3

STEP 4. Cut off foam flush with flared outer conductor. Do not cut into inner conductor. See Figure 4. Remove all copper particles from foam.

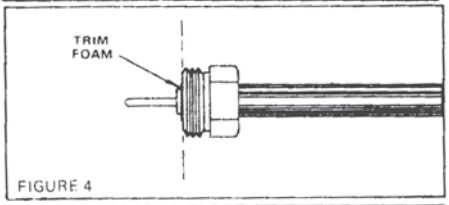


FIGURE 4

STEP 5. Add flare ring and outer body as shown in Figure 5. Screw outer body to clamping nut and tighten to compress flared tabs against clamping nut. Turn outer body only; do not turn clamping nut. Disassemble connector and inspect flare for regularity and flatness to clamping nut.

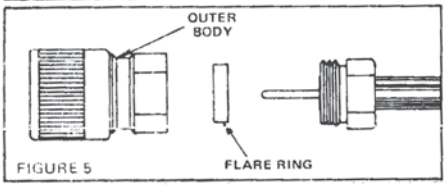


FIGURE 5

STEP 6. Seat inner connector assembly and flare ring into outer body. Refer to Figure 6. Inner assembly must be fully inserted into outer body as indicated by dotted lines.

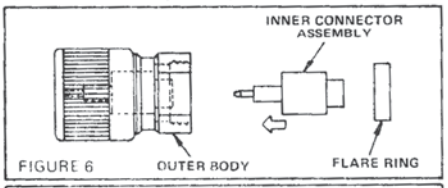


FIGURE 6

STEP 7. Slide outer body onto inner connector and screw it to clamping nut. Tighten connection. Turn outer body only; do not turn clamping nut. See Figure 7.

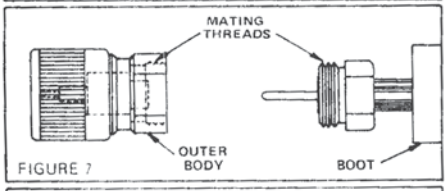


FIGURE 7

STEP 8. Place boot over assembly and seat it in groove of outer body. Refer to assembled connector in Figure 8.

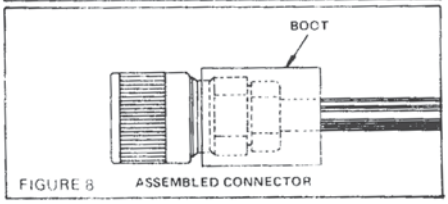
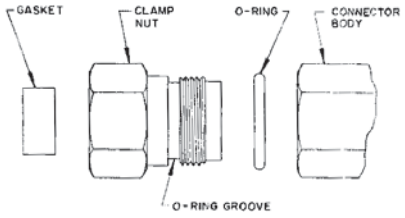
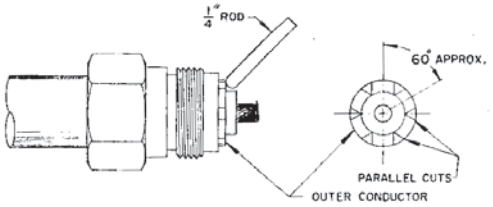
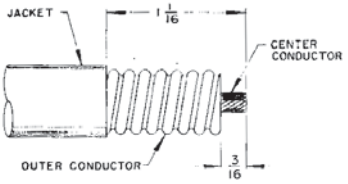


FIGURE 8

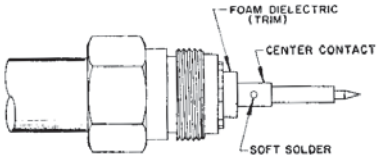




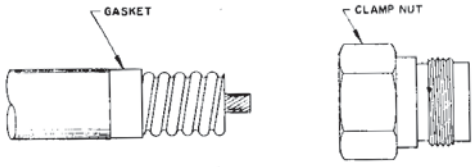
USING A KNIFE AND MALLET MAKE 6 CUTS IN THE CABLE MAKE THE CUTS BY PLACING THE KNIFE AGAINST THE CENTER CONDUCTOR AND CUTTING TOWARD AND UP TO THE CLAMP NUT FACE. MAKE 2 PARALLEL CUTS ONE ON EACH SIDE OF THE CENTER CONDUCTOR AND THEN MAKE 4 MORE CUTS AT 60 DEG. TO THE FIRST TWO CUTS AS SHOWN, WITH THE TIP OF THE KNIFE BEND EACH OF THE SECTIONS OF THE OUTER CONDUCTOR FORWARD. TAP SECTIONS AGAINST CLAMP NUT WITH MALLET AND 1/4 INCH NON-METALLIC ROD. DO NOT FLATTEN TABS, REDUCING MATERIAL THICKNESS. TRIM EXCESS TAB MATERIAL FLUSH WITH OUTER DIAMETER OF CLAMP NUT.



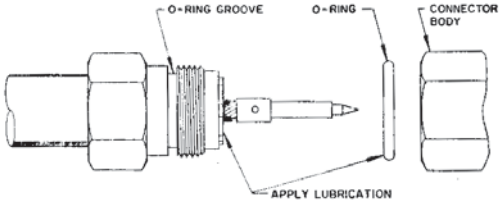
CUT CABLE END SQUARE. TRIM JACKET TO 1 1/16 DIM. TAKING CARE THAT JACKET END IS SQUARE. CUT OUTER CONDUCTOR AND FOAM DIELECTRIC TO 3/16 DIM. CAREFUL NOT TO NICK CENTER CONDUCTOR.



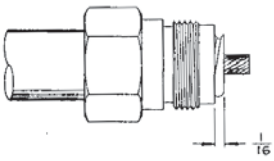
TIN CENTER CONDUCTOR AND ROUND OFF END. SLIDE CENTER CONTACT ONTO CENTER CONDUCTOR AND AGAINST DIELECTRIC. SOLDER IN PLACE, BEING CAREFUL NOT TO APPLY EXCESS HEAT AND NOT TO PUSH CONTACT INTO FOAM DIELECTRIC. TRIM DIELECTRIC FLUSH WITH FACE OF OUTER CONDUCTOR.



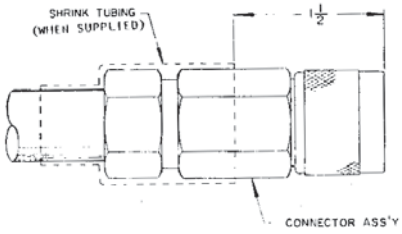
SLIDE GASKET ONTO OUTER CONDUCTOR AS SHOWN. APPLY A THIN COATING OF SILICONE GREASE TO OUTSIDE OF GASKET AND INSIDE SURFACE OF CLAMP NUT.



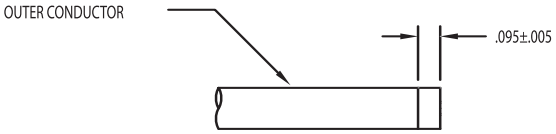
REMOVE ALL COPPER PARTICLES FROM DIELECTRIC AND SEAL EXPOSED DIELECTRIC WITH SILICONE GREASE. APPLY SILICONE GREASE TO O-RING AND INSTALL IN GROOVE ON CLAMP NUT. THEAD CONNECTOR BODY ONTO CLAMP NUT AND TIGHTEN SECURELY MAKING SURE THE CLAMP NUT IS HELD STATIONARY.



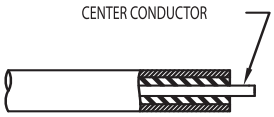
THREAD CLAMP NUT ONTO CONDUCTOR UNTIL OUTER CONDUCTOR IS EXPOSED 1/16.



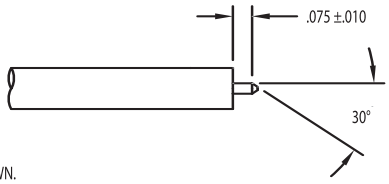
SLIDE SHRINK TUBING OVER ASSEMBLED CONNECTOR AS SHOWN AND APPLY JUST ENOUGH HEAT TO SHRINK TUBING TO OBTAIN A TIGHT SEAL. DO NOT OVERHEAT.



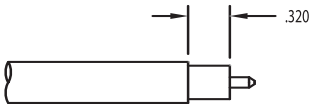
1. CUT CABLE END SQUARE & SCORE OUTER CONDUCTOR ALL AROUND TO DIMENSION SHOWN.



2. REMOVE JACKET TO SCORED MARK. THEN REMOVE DIELECTRIC TO FRONT FACE OF OUTER CONDUCTOR MAKING SURE SURFACE IS SQUARE & FREE OF BURRS. DO NOT NICK CENTER CONDUCTOR.

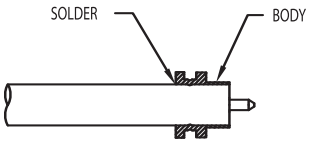


3. CHAMFER CENTER TO 30° AS SHOWN.



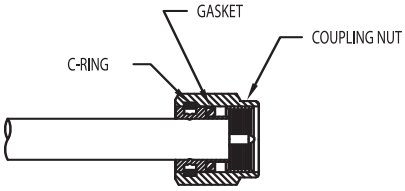
3A. WHEN USING T-FLEX402HF CABLE: SOLDER DIP CABLE PER SHEET 2 OF 3-648. BEFORE STARTING TO TRIM CABLE. TRIM JACKET TO DIMENSION SHOWN.

4. STEPS 1 THRU 3 MAY BE ACCOMPLISHED WITH EASE AND ACCURACY USING KINGS KTO-2 STRIPPING TOOL FOR RG-402/U (.141) CABLE.

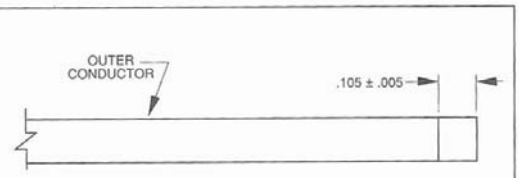


5. POSITION BODY ON CABLE SO THAT FRONT FACES OF BODY & TRIMMED CABLE ARE FLUSH. HOLDING BODY IN PLACE, SOLDER OUTER CONDUCTOR TO BODY BY APPLYING HEAT TO OUTER CONDUCTOR NEAR THE BACK OF THE BODY.

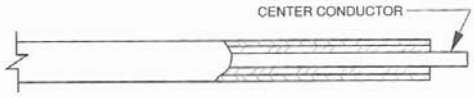
6. REMOVE ANY EXCESS DIELECTRIC THAT MAY EXTRUDE FROM CABLE DUE TO HEAT SO THAT DIELECTRIC IS FLUSH AGAIN WITH OUTER CONDUCTOR OF CABLE & CONNECTOR BODY.



7. ASSEMBLE GASKET ON BODY AND C-RING INTO GROOVE. COMPRESS C-RING WITH COMPRESSING TOOL (KINGS KTC-1) AND SNAP COUPLING NUT IN PLACE.

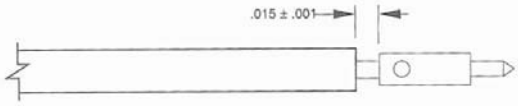


1. Cut cable end square. Score outer conductor all around to dim. shown.

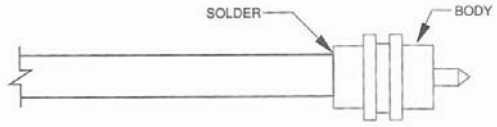


2. Remove jacket to scored mark. Then remove dielectric to front face of outer conductor making sure surface is square and free of burrs. Do not nick center conductor.

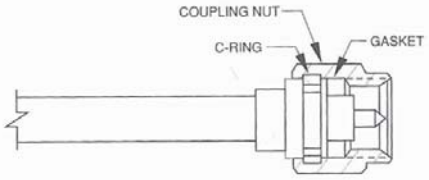
3. Steps 1 thru 3 may be accomplished with ease and accuracy using Kings KTO-2A stripping tool for RG-402/U (.141) cable or KTO-3A for RG-405/U (.085) cable.



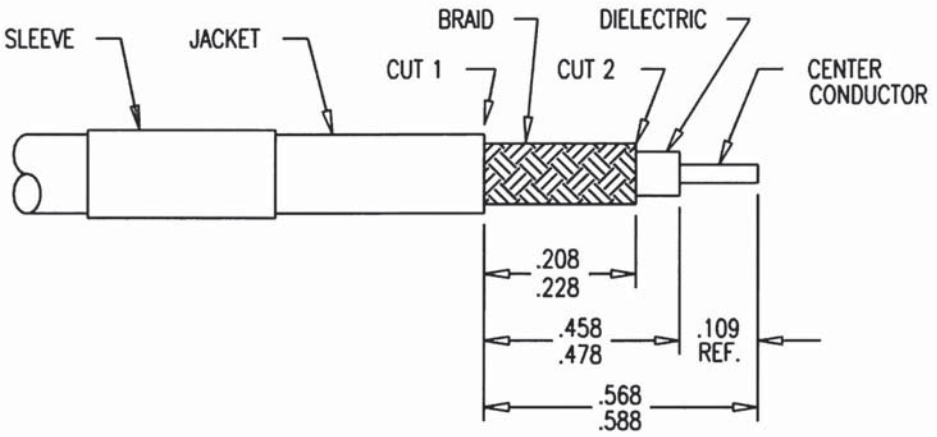
4. Solder contact to center conductor with .015 ± .001 gap as shown.



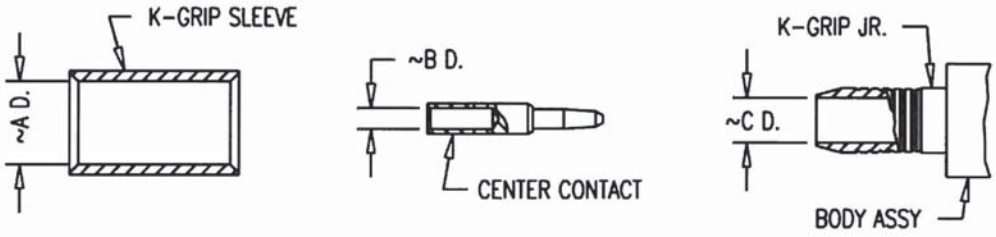
5. Position body on cable so that cable stops at inside shoulder. Holding body in place, solder outer conductor to body by applying heat to outer conductor near the back of the body.



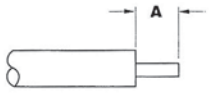
6. Assemble gasket on body and C-Ring into groove. Compress C-Ring with compressing tool (Kings KTC-1) and snap coupling nut in place.



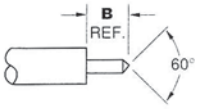
1. CUT CABLE END SQUARE. SLIDE K-GRIP SLEEVE OVER JACKET AND MAKE CUTS 1 AND 2 THROUGH JACKET ONLY.
2. REMOVE END OF JACKET UP TO CUT 2, FLARE OR BULGE BACK BRAID AND TRIM WITH SCISSORS AT EDGE OF JACKET.
3. REMOVE JACKET BETWEEN CUTS 1 AND 2 EXPOSING .218 ±.010 LENGTH OF BRAID.
4. TRIM DIELECTRIC TO .468 ±.010 DIM., EXPOSED CENTER CONDUCTOR WILL BE .109 REF.
5. PLACE CENTER CONTACT ON CABLE AGAINST DIELECTRIC AND CRIMP OR SOLDER IN PLACE.
6. PUSH K-GRIP JR. OVER DIELECTRIC AND UNDER BRAID UNTIL DIELECTRIC BOTTOMS IN CONNECTOR.
7. SLIDE K-GRIP SLEEVE OVER K-GRIP JR. AND BRAID TO SHOULDER OF BODY ASSEMBLY AND FORM HEX USING APPLICABLE CRIMP TOOL AND DIE.



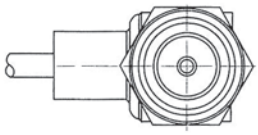
MILITARY PART NO.	KINGS PART NO.	PIECE PART DIMS			*KINGS DIE SIZE
		A	B	C	
M39012/20-0002 M39012/20-0003	KC-59-197 KC-59-246	.207 .220	.042	.122	2061



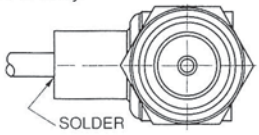
1. Trim cable to dimension shown. Recommended tooling: KTO-3A (ROTO-STRIP) for .085 S.R. Cable or KTO-2A (ROTO-STRIP) for .141 S.R. Cable.



2. Point cable as shown. Recommended tooling KTO-3A (ROTO-STRIP) .085 S.R. or KTO-2A (ROTO-STRIP) .141 S.R.

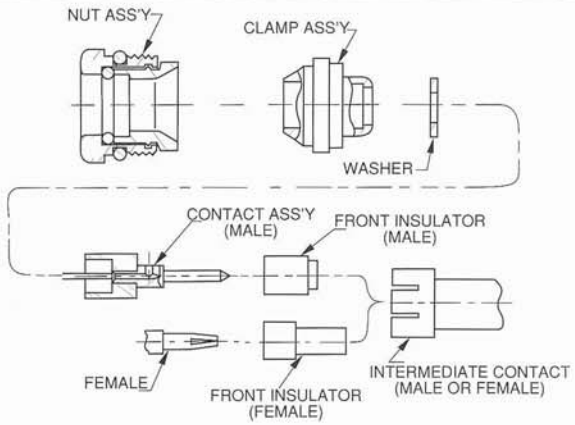


3. Insert cable into connector making sure cable seats against internal shoulder of body.



4. Solder cable onto body as shown.

S/R CABLE	A	B
.086	.065 .075	.070
.141	.080 .090	.085



1. Cut cable end square. Trim jacket, and outer shield to dimensions shown. Secure shield ends with "scotch" tape.

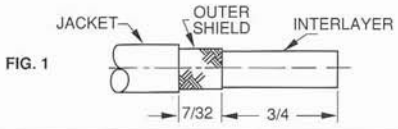


FIG. 1

2. Slide nut ass'y over outer shield, butting internal shoulder against jacket edge. Remove "scotch" tape and flare outer shield against nut ass'y internal taper (Fig. 2). Trim interlayer to 7/32" dim. and secure inner shield ends with "scotch" tape.

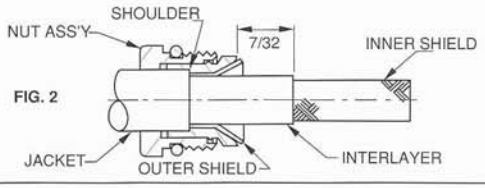


FIG. 2

3. Slide clamp ass'y over interlayer and inner shield pressing it back firmly against outer shield and remove tape (Fig. 3). Comb out inner shield, fold back as shown (Fig. 3) and trim to 1/32" dim. Assemble washer over dielectric against inner shield. Trim dielectric and center conductor to 5/16" and 3/32" dimensions.

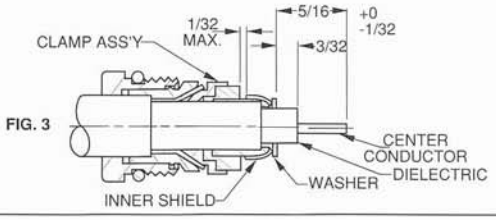


FIG. 3

4. Place contact ass'y over dielectric and center conductor. Butt against washer and solder contact to center conductor as shown (Fig. 4). Assemble front insulator and intermediate contact.

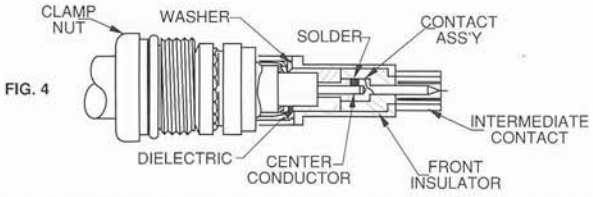


FIG. 4

5. Insert parts into body ass'y and tighten clamp nut securely. Recommended torque 30-35 in./lbs.

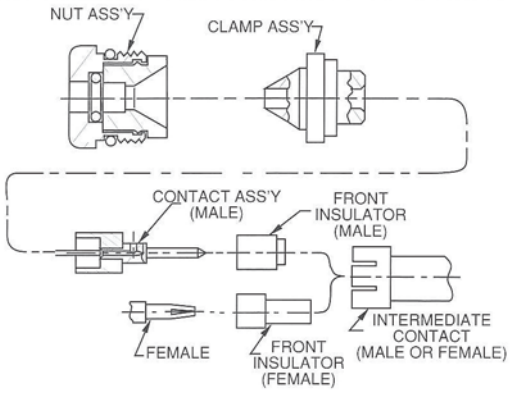


FIG. 1

1. Cut cable end square. Trim cable as shown in Fig. 1 and secure braid with scotch "magic" tape.

2. Insert cable into nut ass'y butting jacket edge against internal shoulder. Remove tape and flare braid against nut ass'y internal taper. Slide clamp ass'y over dielectrics and fillers pressing firmly against flared braid as shown in Fig. 2.

3. Trim inner conductor A to 3/16 and fold back over clamp ass'y (Fig. 2). Trim inner conductor B to 9/32 (Fig. 2).

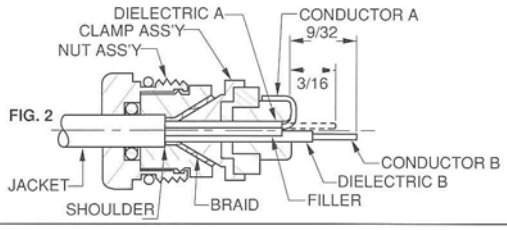


FIG. 2

4. Place contact ass'y over dielectric and inner conductor B and solder contact to inner conductor B as shown in Fig. 3.

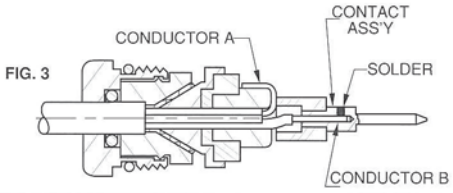


FIG. 3

5. Place front insulator on center contact and assemble intermediate contact pressing inner conductor A against clamp ass'y as in Fig. 4

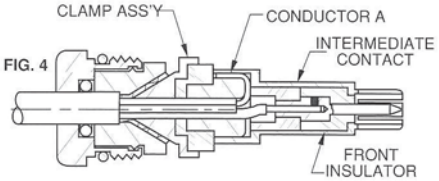
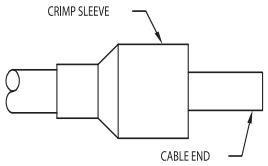
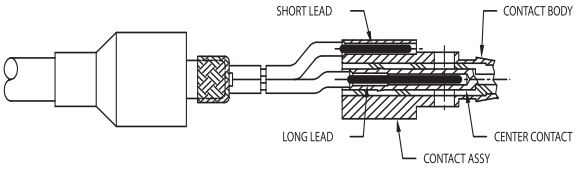


FIG. 4

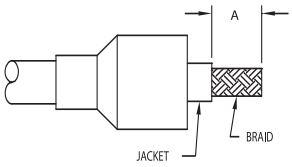
6. Insert parts into body ass'y and tighten clamp nut securely. Recommended torque 30-35 inch-pounds.



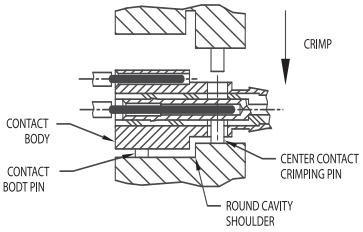
CUT CABLE END SQUARE AND SLIDE CRIMP SLEEVE OVER CABLE AS SHOWN.



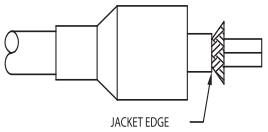
REMOVE THE DIELECTRICS AND INSERT CENTER CONDUCTORS (LONG LEAD IN CENTER, SHORT LEAD IN CONTACT BODY) INTO CONTACT ASSY. A GENTILE ROCKING MOTION OF THE CABLE WILL FACILITATE ENTRY OF THE LEADS.



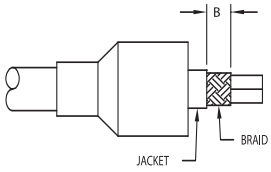
REMOVE JACKET TO " A " DIMENSION



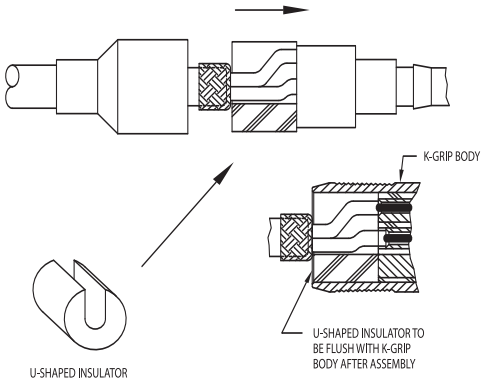
PLACE APPROPRIATE CRIMP DIE INTO CRIMPING TOOL. INSERT CONTACT ASSEMBLY, WITH CABLE CONDUCTORS IN PLACE, AGAINST THE ROUND DIE CAVITY SHOULDER. LINE UP CENTER CONTACT CRIMPING PINS WITH CLEARANCE HOLES (MAKE SURE THAT THE CONDUCTOR INSERTED IN THE CONTACT BODY IS IN LINE WITH THE CONTACT BODY PIN). CRIMP CAREFULLY.



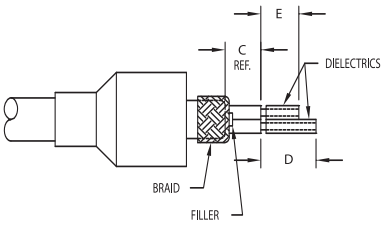
FLARE OR BULGE BACK BRAID AND TRIM WITH SCISSORS AT EDGE OF JACKET



REMOVE JACKET TO " B " DIMENSION, TAKING CARE NOT TO NICK BRAID.

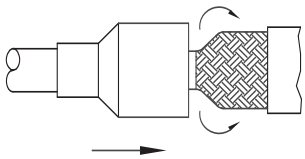


SLIDE U-SHAPED INSULATOR INTO GAP BETWEEN CONTACT ASSEMBLY AND BRAID. USING INSULATOR SNAP IN CONTACT ASSEMBLY INTO K-GRIP BODY.

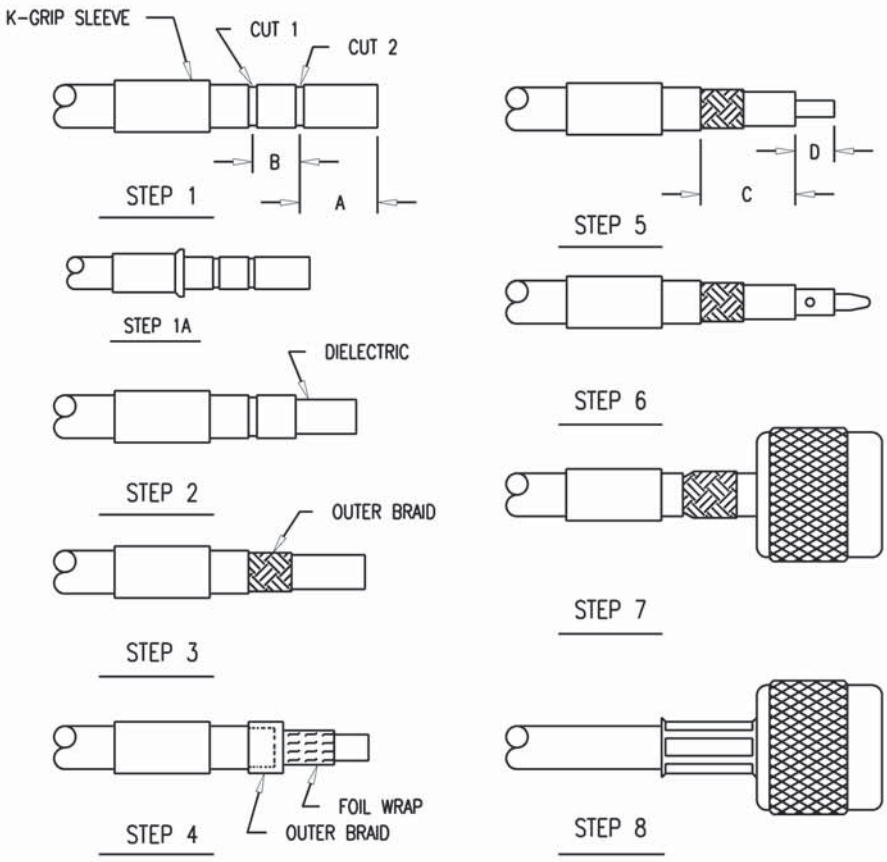


FOLD BACK BRAID AND TRIM BOTH FILLERS FLUSH WITH FOLD. THEN CUT THRU BOTH DIELECTRICS. AT " D " DIMENSION (DO NOT NICK CONDUCTORS AND DO NOT REMOVE DIELECTRICS). NEXT, TRIM ONE OF THE LEADS TO THE " E " DIMENSION, THE REMAINING LONG LEAD WILL BE INSERTED INTO THE CENTER CONTACT IN THE NEXT STEP.

DASH NO	A	B	C	D	E	UNITS
-1	.350	.375	.410	.315	.172	IN.
	8.9	9.5	10.4	8.0	4.4	mm



FOLD BRAID BACK OVER K-GRIP BODY, SLIDE CRIMP SLEEVE OVER BRAID AND BODY. CRIMP WITH HEX CAVITY OF DIE.



STEP 1.
CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE OVER JACKET. (CAUTION: WHEN USING A SINGLE STEP W/P SLEEVE, SLIDE SMALL END OVER CABLE FIRST AS SHOWN, SEE STEP 1A.) WITH JACKET TRIM JIG MAKE CUTS 1 AND 2 IN JACKET.

STEP 2.
REMOVE JACKET TO DIMENSION "A". FLARE OR BULGE BACK OUTER BRAID, (FLAT STRIP BRAID AND FOIL WRAP WHEN APPLICABLE) AND TRIM AT EDGE OF JACKET.

STEP 3.
REMOVE JACKET TO DIMENSION "B".

STEP 4. (FOR CABLES WITH FOIL WRAP)
FOLD BACK OUTER BRAID (OR IN SOME CASES FLAT STRIP BRAID) AT JACKET SHOULDER AND REMOVE FOIL WRAP. BE SURE NOT TO DAMAGE EITHER BRAID WHEN REMOVING FOIL WRAP. FOLD DOWN BRAID BACK IN PLACE OVER DIELECTRIC TAKING CARE TO LEAVE STRANDS IN PLACE AS MUCH AS POSSIBLE.

STEP 5.
USING DIELECTRIC TRIM JIG, TRIM DIMENSION "C". EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO DIMENSION "D" OF TRIM CODE

STEP 6.
BOTTOM CONTACT AGAINST DIELECTRIC. SOLDER OR CRIMP CONTACT TO CENTER CONDUCTOR.

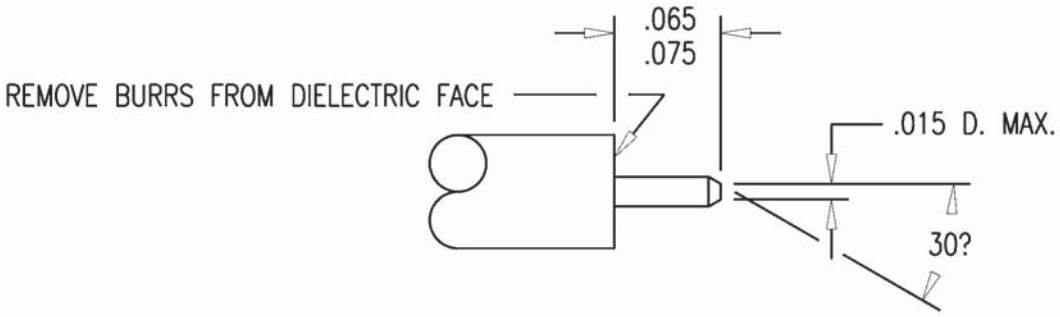
STEP 7.
FLARE OUTER BRAID (AND FLAT STRIP BRAID) BY CAREFULLY ROTATING THE DIELECTRIC. PUSH K-GRIP JR. OVER DIELECTRIC AND UNDER BOTH BRAIDS UNTIL CONTACT SNAPS IN PLACE OR DIELECTRIC BOTTOMS IN CONNECTOR.

STEP 8.
SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM HEX BY CRIMPING.

TRIM CODE CHART

DASH NO.	A	B	C	D
-1	.250	.344	.432	.156
-2	.375	.313	.500	.188
-3	.313	.281	.432	.156
-4	.281	.406	.500	.187

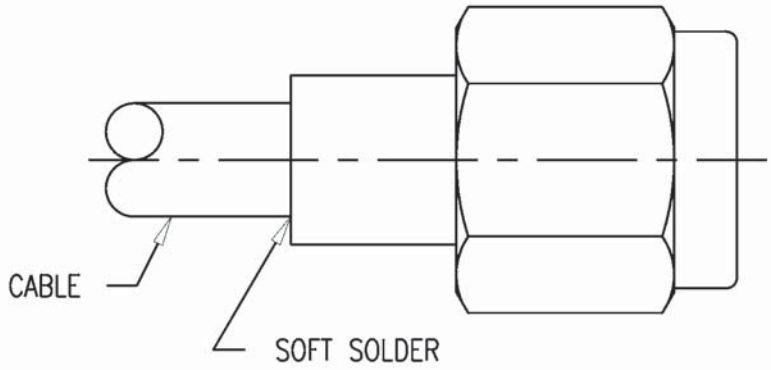
1. REMOVE CABLE OUTER CONDUCTOR AND DIELECTRIC TO .070 DIMENSION AS SHOWN.
2. CHAMFER CENTER CONDUCTOR TO 30° ANGLE AS SHOWN.



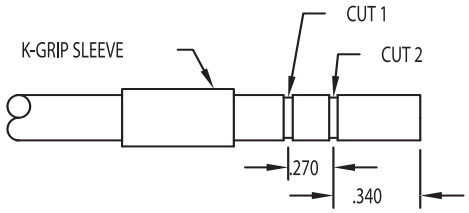
NOTE: STEP 1 & 2 MAY BE ACCOMPLISHED WITH EASE AND ACCURACY USING KINGS KTO-3 STRIPPING TOOL.

3. INSERT CABLE INTO BACK END OF CONNECTOR. PUSH CABLE IN FIRMLY UNTIL THE FACE OF CABLE BOTTOMS AGAINST REAR END OF INSULATOR. (CAUTION: EJECTION OF INSULATOR MAY BE PREVENTED BY MATING WITH A CONNECTOR OF OPPOSITE SEX).

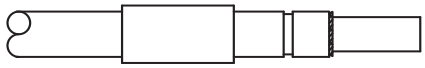
INSERT CABLE IN POSITION SHOWN



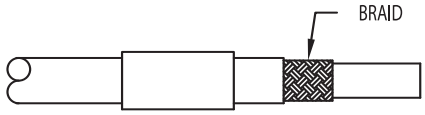
4. SOLDER BACK END OF CONNECTOR.



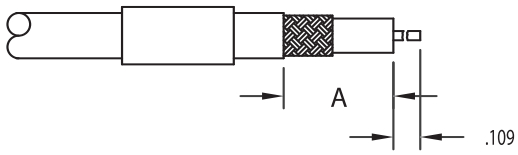
1. CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE OVER JACKET & WITH TRIM JIG MAKE CUTS 1 AND 2 IN JACKET.



2. REMOVE JACKET TO DIMENSION .340, FLARE OR BULGE BACK BRAID & TRIM WITH SCISSORS AT EDGE OF JACKET.



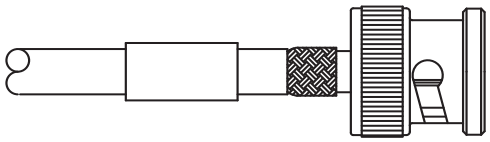
3. REMOVE JACKET TO DIMENSION .270.



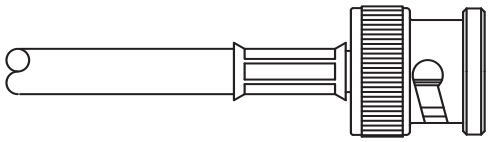
4. TRIM TO DIMENSION A. EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO .109 DIMENSION.

5. SOLDER CONTACT FOR THE STRAIGHT CONNECTOR ONLY, THEN PROCEED TO STEP 7.

6. CONTACT NOT USED FOR THE ANGLE CONNECTOR. PROCEED TO STEP 7, THEN SOLDER CABLE CENTER CONDUCTOR TO CONNECTOR CENTER CONTACT.

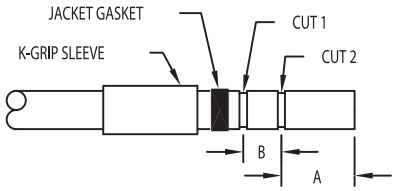


7. CAREFULLY INSERT CABLE INTO CONNECTOR. PUSH K-GRIP JR. OVER DIELECTRIC & UNDER BRAID.

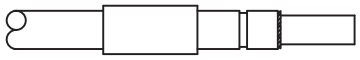


8. SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM BY CRIMPING.

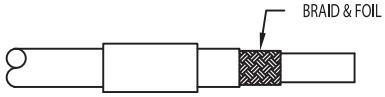
KINGS NO.	A
3-483-1	.390
3-483-2	.500



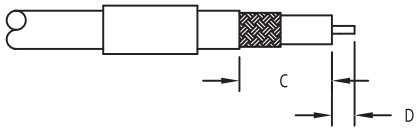
1. CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE AND GASKET OVER JACKET & WITH JACKET TRIM JIG MAKE CUTS 1 AND 2 IN JACKET.



2. REMOVE JACKET TO DIMENSION "A", FLARE OR BULGE BACK BRAID AND FOIL & TRIM WITH SCISSORS AT EDGE OF JACKET.

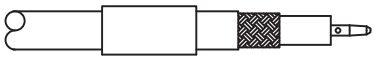


3. REMOVE JACKET TO DIMENSION "B".

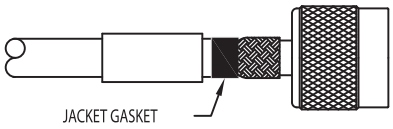


4. USING DIELECTRIC TRIM JIG, TRIM DIMENSION "C". EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO DIMENSION "D" OF TRIM CODE.

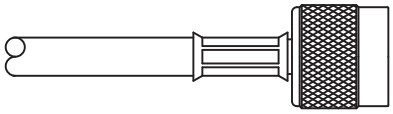
TRIM CODE CHART			
A	B	C	D
.250	.344	.432	.156



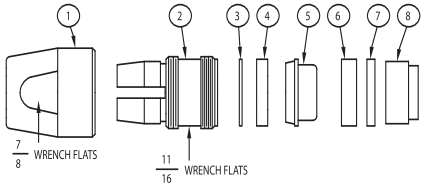
5. SOLDER OR CRIMP CONTACT TO CENTER CONDUCTOR.



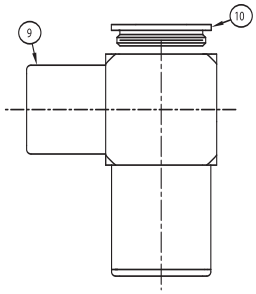
6. PUSH K-GRIP JR. OVER DIELECTRIC AND FOIL AND UNDER BRALD UNTIL DIELECTRIC BOTTOMS IN CONNECTOR. SLIDE JACKET GASKET FLUSH WITH JACKET EDGE.

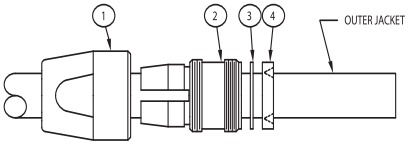


7. SLIDE K-GRIP SLEEVE OVER GASKET AND AGAINST SHOULDER ON BODY AND FORM HEX.

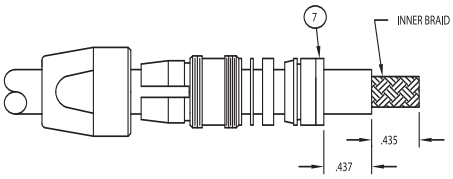


NOTE: CARE MUST BE TAKEN WHEN TRIMMING CABLE THAT THE BRAIDS, INSULATOR AND CONDUCTORS OF THE CABLE ARE NOT NICKED OR DAMAGED.

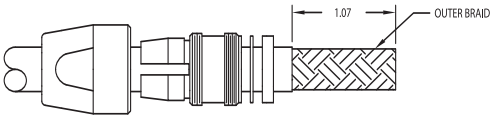




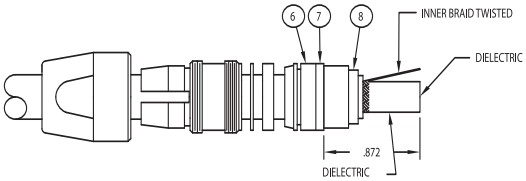
1. CUT CABLE END SQUARE. PLACE NUT, ITEM 1 . COLLET, ITEM 2 , THIN WASHER ITEM 3 AND VEE GASKET, ITEM 4 OVER THE JACKET.



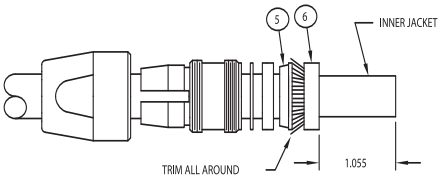
4. SLIDE THICK WASHER, ITEM 7 OVER INNER JACKET AND AGAINST OUTER GROUND RING. REMOVE INNER JACKET TO .437 DIMENSION. DO NOT NICK THE BRAID. LENGTH OF INNER BRAID TO BE .435.



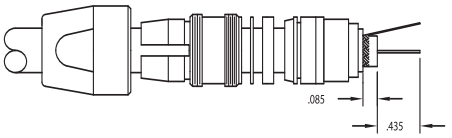
2. REMOVE OUTER JACKET TO 1.07 DIMENSION SHOWN.



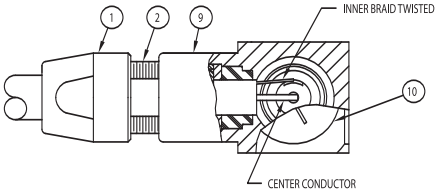
5. PLACE INSULATOR, ITEM 8 OVER THE INNER JACKET AND SEAT AGAINST THE THICK WASHER, ITEM 7 TO .872 DIMENSION. COMB OUT INNER BRAID AND TWIST WIRE STRANDS INTO ONE LEAD AS SHOWN. INNER BRAID MAY BE TRIMMED AS REQUIRED TO FACILITATE TWISTING.



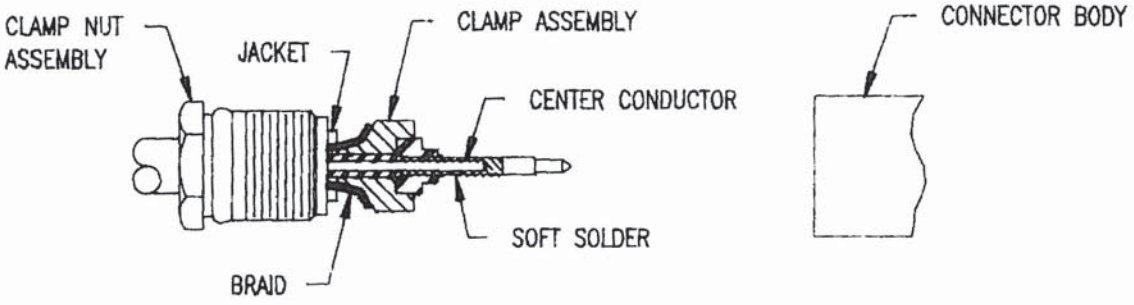
3. PLACE BRAID CLAMP, ITEM 5 OVER THE OUTER BRAID AND SEAT AGAINST THE OUTER JACKET. FOLD THE OUTER BRAID BACK OVER THE BRAID CLAMP, AND PRESS THE OUTER GROUND RING, ITEM 6 OVER THE BRAID CLAMP SO THAT THE OUTER GROUND RING IS FLUSH TO THE EDGE OF THE BRAID CLAMP. (1.055 DIMENSION) TRIM EXCESS BRAID THAT EXTENDS BEYOND THE OUTER DIAMETER OF THE BRAID CLAMP.



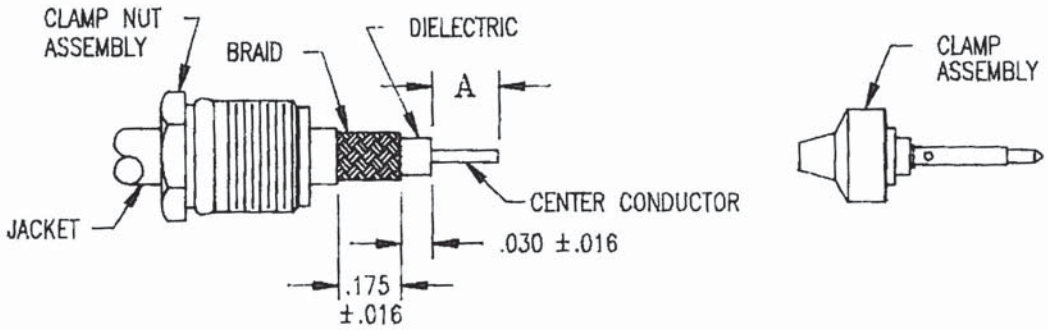
6. REMOVE DIELECTRIC TO .085 DIMENSION. EXPOSED CENTER CONDUTOR TO BE .435 DIMENSION.



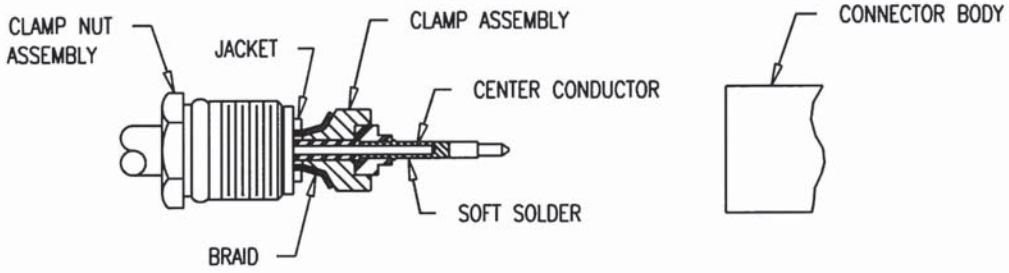
7. SLIDE CABLY ASSEMBLY INTO BODY, ITEM 9 , AND ALIGN AS SHOWN, PLACING THE CENTER CONDUCTOR INTO THE SLOTTED CENTER CONTACT, AND THE TWISTED INNER BRAID TO BE PLACED ON THE INTERMEDIATE CONTACT TAB. TIGHTEN COLLET, ITEM 2 , TO BODY WITH A MINIMUM OF 80 IN-LBS OF TORQUE. (IT IS RECOMMENDED NOT TO EXCEED 125 INCH LBS. OF TORQUE). LOCK CLAMP NUT, ITEM 1 , TO COLLECT TO PREVENT ROTATION OF CABLE JACKET WITHIN THE CONNECTOR. SOLDER THE TWISTED INNER BRAID TO THE INTERMEDIATE CONTACT TAB, THEN SOLDER THE CENTER CONDUCTOR TO THE CENTER CONTACT.
THREAD SCREW CAP, ITEM 10 , INTO BODY AND TIGHTEN SECURELY.



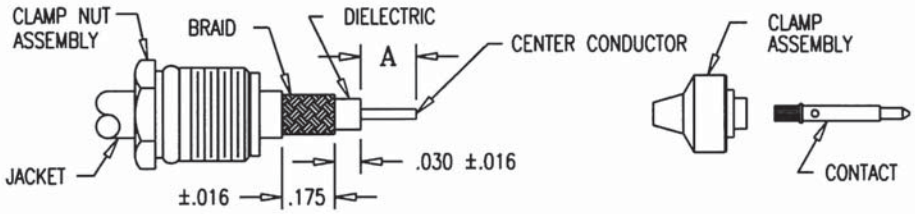
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE. SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.



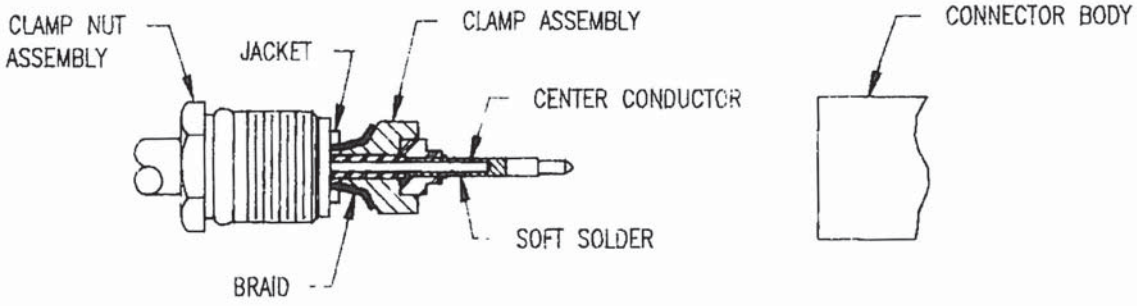
KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016
872-40-101	152-00001	.220
876-63-3	95-RG-180	
871-57-3	152-00001	



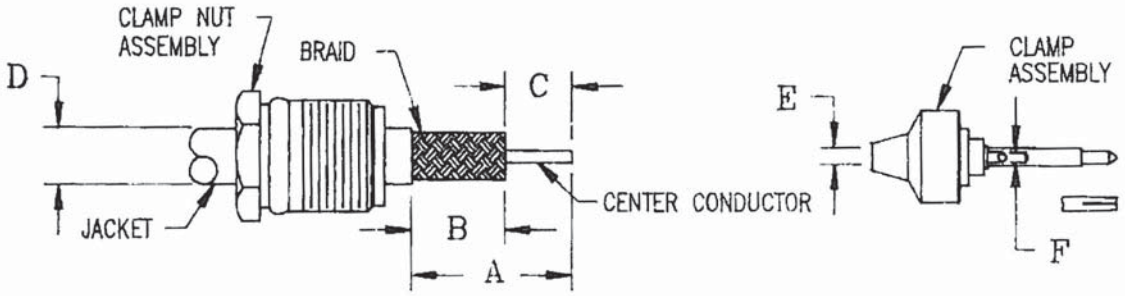
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE. PRESS CONTACT INTO INSULATOR UNTIL BOTTOMED AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE. SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.
4. WHEN USING M17/84-RG223 CABLE, A SMALL AMOUNT OF O-RING LUBE MAY BE USED TO FACILITATE CABLE JACKET ENTRY THROUGH THE INTERNAL O-RING. IF DESIRED, THE INTERNAL O-RING MAY BE DISCARDED WHEN USING THIS CABLE.



MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016
55-3009 55-3109 56-3109 56-3009 57-3009 58-3009 59-3009	875-82-17 875-82-3 876-61-3 876-61-17 873-48-3 871-51-3 872-45-3	28-RG058 60-RG142 84-RG223 155-00001 158-00001 167-00001	.160
55-3010 55-3110 56-3010 56-3110 57-3010 58-3010 59-3010	875-85-17 875-85-3 876-67-17 876-67-3 873-49-3 871-55-3 872-46-3	111-RG303 170-00001	.160
55-3030 55-3130 56-3030 56-3130 57-3030 58-3030 59-3030	875-86-17 875-86-3 876-62-17 876-62-3 873-50-3 871-56-3 872-40-3	152-00001	.220

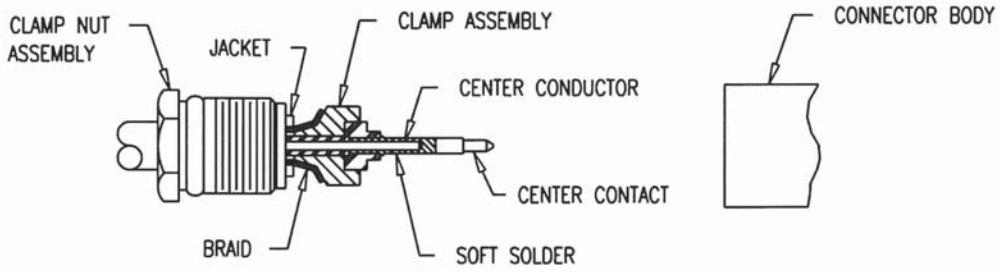


1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.

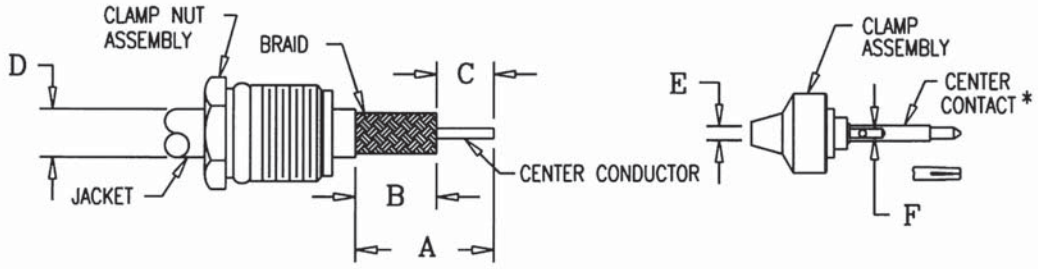


MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016	B DIM ±.016	C DIM ±.016	D DIM	E DIM	F DIM
26-0101 27-0101 28-0101 29-0101 30-0101	125-67-5 123-12-5 122-27-5 121-23-5 126-55-5	028-RG058 084-RG223 128-RG400 060-RG142	.600	.380	.220	.220	.120	.050
26-0102 27-0102 28-0102 29-0102 30-0102	125-72-5 123-13-5 122-28-5 121-26-5 126-54-5	29-RG59 * 030-RG062 90-RG71 97-RG210	.660	.440	.220	.259	.150	.050
26-0103 27-0103 28-0103 29-0103 30-0103	125-73-5 123-14-5 122-29-5 121-27-5 126-56-5	054-RG122	.600	.380	.220	.180	.100	.050

* FOR AIR SPACED CABLE USE INSULATOR BUSHING SUPPLIED REDUCE "B" DIM (DIELECTRIC ONLY) BY .032 AND INCREASE "C" DIM TO .250

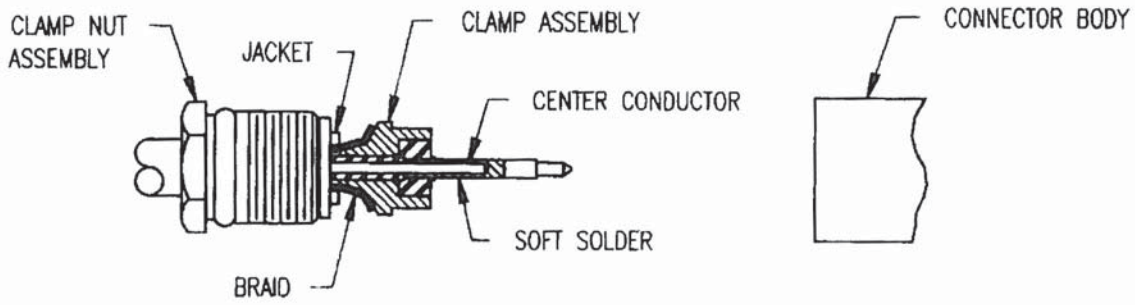


1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE SOLDER CENTER CONDUCTOR.
   WHEN CENTER CONTACT IS SUPPLIED LOOSE INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC AND BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE. PRESS CENTER CONTACT INTO INSULATOR UNTIL BOTTOMED AND CENTER CONDUCTOR IS VISIBLE THROUGH SOLDER HOLE. SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.

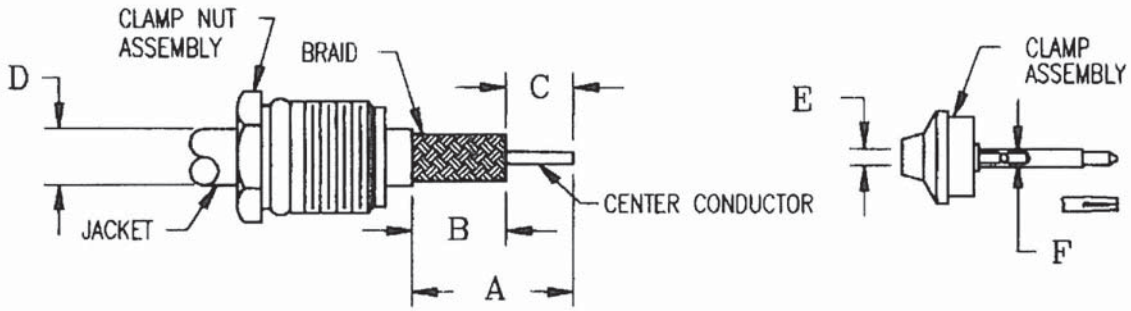


MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016	B DIM ±.016	C DIM ±.016	D DIM	E DIM	F DIM
26-0104 27-0104 28-0104 29-0104 30-0104	125-74-5 123-15-5 122-30-5 121-28-5 126-61-5	111-RG303	.600	.380	.220	.180	.120	.050
26-0117 27-0117 28-0117 29-0117 30-0117	125-75-5 123-16-5 122-31-5 121-29-5 126-62-5	110-RG302	.660	.440	.220	.220	.150	.050
26-0018 27-0018 28-0018 29-0018 30-0118	125-76-5 123-17-5 122-32-5 121-30-5 126-56-5	113-RG316 119-RG174	.545	.220	.325	.127	.065	.025

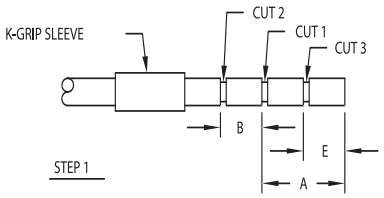
* CENTER CONTACT SUPPLIED LOOSE WITH RG316/RG174 CONNECTORS



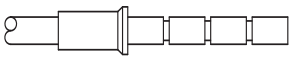
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 65 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.



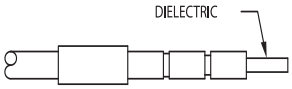
MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016	B DIM ±.016	C DIM ±.016	D DIM	E DIM	F DIM
1-0005 2-0003 2-0006 3-0012 5-0101	1205-35-5 1203-10-5 1201-9-5 1202-9-5 1206-23-5	6-RG11 62-RG144 65-RG165 74-RG213 75-RG214 77-RG216 86-00001	.750	.468	.281	.44	.295	.098
1-0015	1205-37-5	RG-217	.718	.500	.218	.57	.38	.113



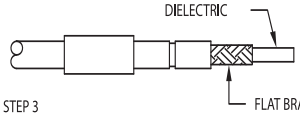
STEP 1



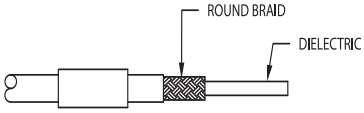
STEP 1A



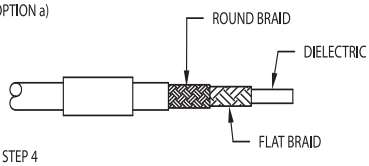
STEP 2



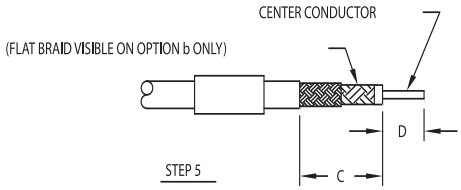
STEP 3
(OPTION b ONLY)



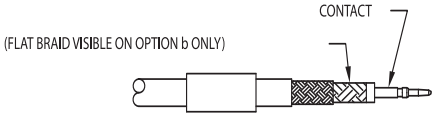
STEP 4
(OPTION a)



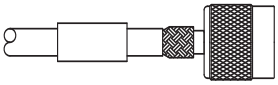
STEP 4
(OPTION b)



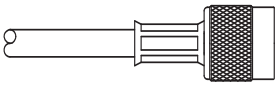
STEP 5



STEP 6



STEP 7



STEP 8

STEP 1 (OPTION a & b):
CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE (SHRINK TUBING OPTIONAL) OVER JACKET.
(CAUTION: WHEN USING A SINGLE STEP W/P SLEEVE, SLIDE SMALL END OVER CABLE FIRST
AS SHOWN, SEE STEP 1A) MAKE CUTS 1 AND 2 IN JACKET. (OPTION b ONLY):
MAKE ADDITIONAL CUT 3 IN JACKET.

STEP 2 (OPTION a & b):
REMOVE JACKET TO DIMENSION "A" (OPTION a) OR "E" (OPTION b). REMOVE ROUND BRAID AND FLAT BRAID AT EDGE OF JACKET. BE SURE ENDS OF FLAT BRAID ARE FLAT AGAINST DIELECTRIC. (IF USING OPTION a PROCEED TO STEP 4).

STEP 3 (OPTION b ONLY):
REMOVE JACKET TO DIMENSION "A". FLAIR OR BULGE BACK ROUND BRAID ONLY AND TRIM AT EDGE OF JACKET.

STEP 4 (OPTION a & b):
REMOVE JACKET TO DIMENSION "B". FLAT BRAID IS VISIBLE ON OPTION b ONLY.

STEP 5 (OPTION a & b):
TRIM DIELECTRIC TO DIMENSION "C". EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO DIMENSION "D".

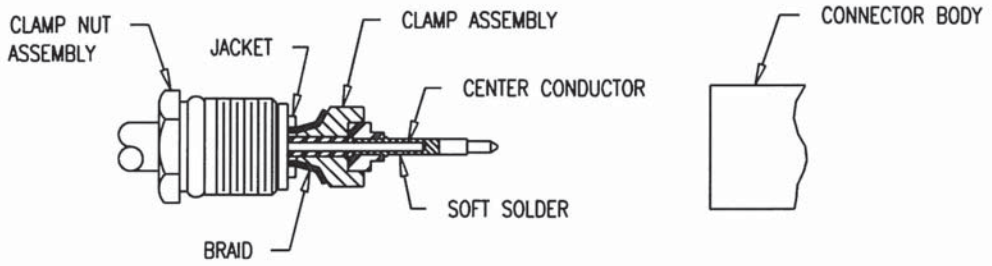
STEP 6 (OPTION a & b):
PLACE CONTACT ON CENTER CONDUCTOR AND BOTTOM AGAINST DIELECTRIC. SOLDER OR CRIMP CONTACT IN PLACE.

STEP 7 (OPTION a & b):
PUSH THE K-GRIP BODY OVER THE DIELECTRIC AND FLAT BRAID AND UNDER ROUND BRAID UNTIL CONTACT SNAPS IN PLACE. (ONCE THE FLAT BRAID IS UNDER THE K-GRIP BODY, A CAREFUL ROTATION OF THE DIELECTRIC AND FLAT BRAID WILL EASE ASSEMBLY UNDER THE ROUND BRAID).

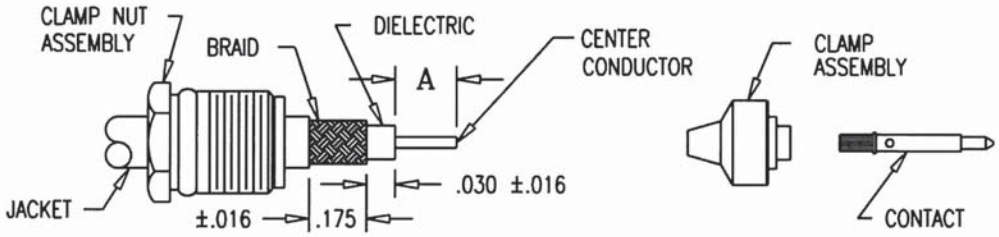
STEP 8 (OPTION a & b):
SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM HEX BY CRIMPING.
(HEAT SHRINK TUBING AS REQUIRED)

TRIM CODE CHART

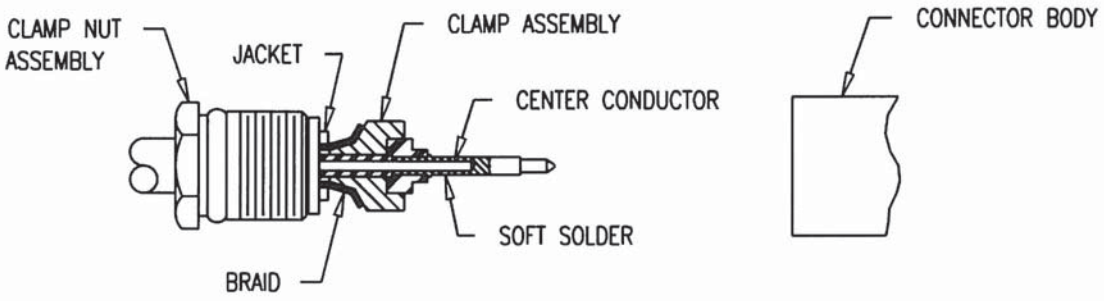
DASH NO.	OPTION	A	B	C	D	E
-1	a	.275	.312	.432	.156	——
	b					.210
-2	a	.375		.500	.188	——
	b					.260
-3	a	.293		.512	.094	——
	b					.166
-4	a	.625		.750	.188	——
	b					.260
-5	a	.218	.250	.398	.093	——
	b					.140
-6	a	.250	.343	.437	.156	——
	b					.210
-7	a	.552	.270	.634	.188	——
	b					.260
-8	a	.275	.281	.400	.156	——
	b					.210
-9	a	.563	.312	.687	.188	——
	b					.260



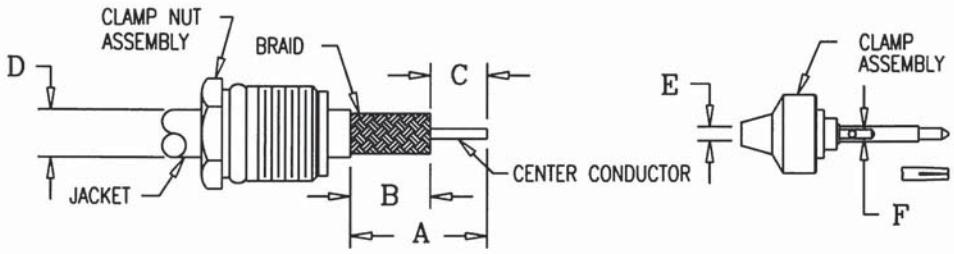
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE. PRESS CONTACT INTO INSULATOR UNTIL BOTTOMED AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE. SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.



MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016
55-3006 55-3106 56-3006 56-3106 57-3006 58-3006 59-3006	875-83-17 875-83-3 876-65-17 876-65-3 873-45-3 871-53-3 872-42-3	93-RG178 169-00001	.220
55-3007 55-3107 56-3007 56-3107 57-3007 58-3007 59-3007	875-81-17 875-81-3 876-60-17 876-60-3 873-46-3 871-52-3 872-43-3	119-RG174 173-00001 113-RG316 172-00001	.220
55-3008 55-3108 56-3008 56-3108 57-3008 58-3008 59-3008	875-84-17 875-84-3 876-66-17 876-66-3 873-47-3 871-54-3 872-44-3	54-RG122 157-00001	.220



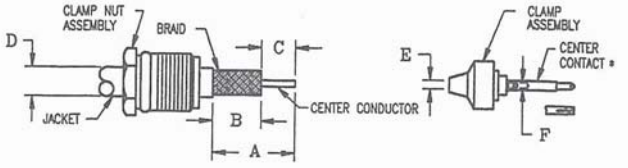
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC & BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE THROUGH CONTACT SOLDER HOLE SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH/LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.



MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016	B DIM ±.016	C DIM ±.016	D DIM	E DIM	F DIM
16-0101 17-0101 18-0102 19-0101 20-0101	755-74-5 753-8-5 751-14-5 752-28-5 756-9-5	028-RG058 084-RG223 128-RG400 060-RG142	.563	.343	.220	.220	.120	.050
16-0102 17-0102 18-0101 19-0102 20-0102	755-77-5 753-9-5 751-13-5 752-29-5 756-12-5	29-RG59 * 030-RG062 90-RG71 97-RG210	.625	.406	.220	.259	.150	.050
16-0103 17-0103 18-0103 19-0110	755-83-5 753-10-5 751-15-5 752-31-5	054-RG122	.563	.343	.220	.180	.100	.050

* FOR AIR SPACED CABLE USE INSULATOR BUSHING SUPPLIED REDUCE "B" DIM (DIELECTRIC ONLY) BY .032 AND INCREASE "C" DIM TO .250

MILITARY PART NO. M39012/	KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016	B DIM ±.016	C DIM ±.016	D DIM	E DIM	F DIM
16-0111 17-0111 18-0111 19-0111	755-84-5 753-11-5 751-16-5 752-32-5	111-RG303	.563	.343	.220	.180	.120	.050
16-0118 17-0118 18-0118 19-0118 20-0108	755-85-5 753-12-5 751-17-5 752-33-5 756-13-5	110-RG-302	.625	.406	.220	.220	.150	.050
16-0220 17-0220 18-0220 19-0220	755-86-5 753-13-5 751-18-5 752-34-5	113-RG316 119-RG174	.545	.220	.325	.127	.065	.025

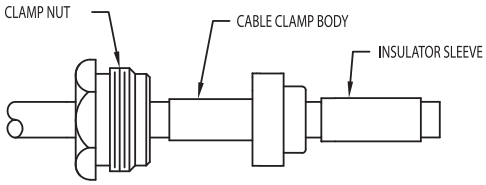


1. Cut cable end square. Slide clamp nut over jacket and trim cable to dimensions shown.

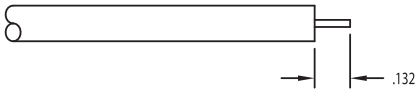
2. Insert clamp assembly between dielectric and braid until dielectric bottoms in assembly and center conductor is visible through contact solder hole solder center conductor.

When center contact is supplied loose insert clamp assembly between dielectric and braid until dielectric bottoms in assembly and center conductor is visible. Press center contact into insulator until bottomed and center conductor is visible through solder hole. Solder center conductor.

3. Insert cable assembly into connector body, slide clamp assembly forward until seated and tighten clamp nut to a torque of 30 inch/lbs. When tightening the clamp nut assembly make sure only the nut turns, do not rotate body, damage to the center conductor might occur.

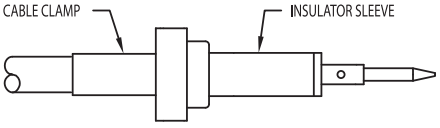


1. CUT CABLE END SQUARE AND SLIDE CLAMP NUT, CABLE CLAMP BODY AND INSULATOR SLEEVE ONTO CABLE.

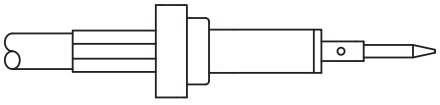


2. REMOVE JACKET TO DIMENSION SHOWN.

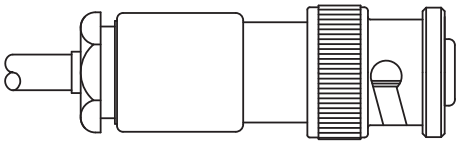
3. SOLDER OR CRIMP CONTACT TO CENTER CONDUCTOR.



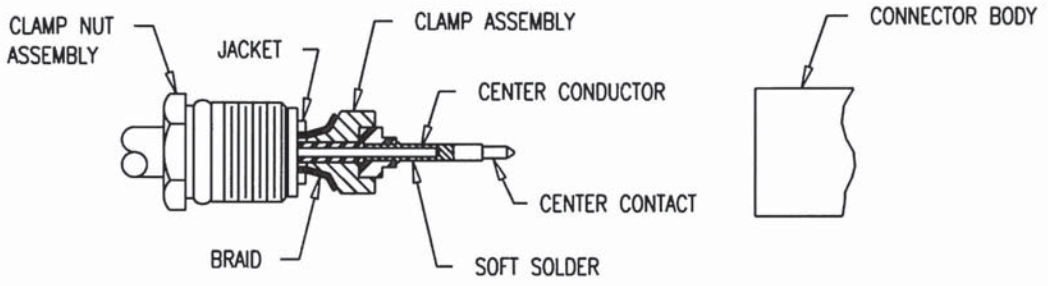
4. PUSH THE INSULATOR SLEEVE AGAINST THE CENTER CONTACT UNTIL BOTTOMED, THEN PUSH CABLE CLAMP BODY UNTIL BOTTOMED AGAINST INSULATOR SLEEVE, WHILE HOLDING THE CABLE CLAMP BODY AND THE INSULATOR SLEEVE AGAINST THE CONTACT, CRIMP THE CABLE CLAMP BODY IN PLACE AND FORM HEX.



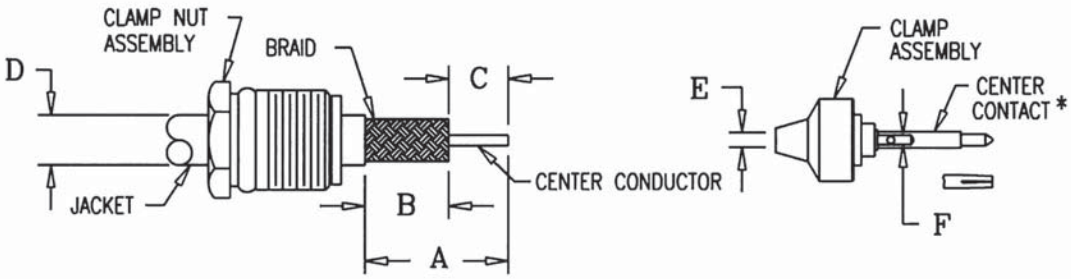
5. FINSISHED CRIMP ASSY.



6. PUSH THE CRIMP ASSEMBLY INTO THE BODY UNTIL BOTTOMED, WRENCH TIGHTEN CLAMP NUT INTO CONNECTOR BODY. RECOMMENDED TORQUE 30-35 INCH-POUNDS.

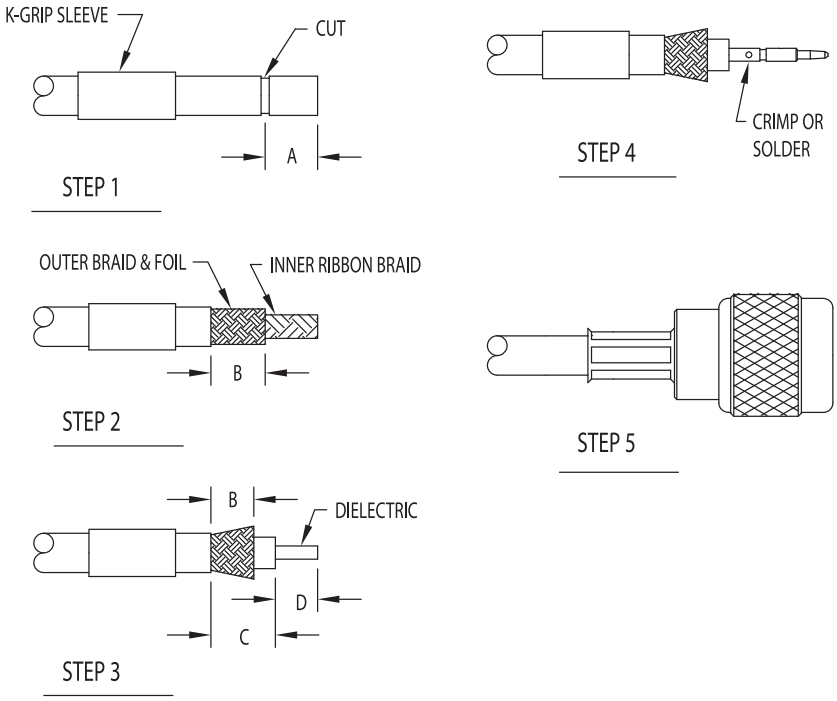


1. CUT CABLE END SQUARE. SLIDE CLAMP NUT OVER JACKET & TRIM CABLE TO DIM'S SHOWN.
2. INSERT CLAMP ASSEMBLY BETWEEN DIELECTRIC AND BRAID UNTIL DIELECTRIC BOTTOMS IN ASSEMBLY AND CENTER CONDUCTOR IS VISIBLE. PRESS CENTER CONTACT INTO INSULATOR UNTIL BOTTOMED AND CENTER CONDUCTOR IS VISIBLE THROUGH SOLDER HOLE. SOLDER CENTER CONDUCTOR.
3. INSERT CABLE ASSEMBLY INTO CONNECTOR BODY, SLIDE CLAMP ASSEMBLY FORWARD UNTIL SEATED AND TIGHTEN CLAMP NUT TO A TORQUE OF 30 INCH-LBS. WHEN TIGHTENING THE CLAMP NUT ASSEMBLY MAKE SURE ONLY THE NUT TURNS, DO NOT ROTATE BODY, DAMAGE TO THE CENTER CONDUCTOR MIGHT OCCUR.



KINGS PART NO.	CABLE PART NO. M17/	A DIM ±.016	B DIM ±.016	C DIM ±.016	D DIM	E DIM	F DIM
752-38-5	152-00001 (RD-316)	.532	.219	.313	.127	.065	.033
1202-16-5	113-RG316 119-RG174	.530	.210	.320			
1202-17-5	RAYTHEON 48152-1 152-00001 (RD-316)						

NOTES:
* 1. CENTER CONTACT SUPPLIED LOOSE



STEP 1.
CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE OVER JACKET AND MAKE CUT IN JACKET AT DIMENSION A.

STEP 2.
REMOVE JACKET TO DIMENSION "A".
TRIM OUTER WOVEN BRAID LAYER TO DIMENSION "B".
CAREFULLY FOLD BACK THE REMAINING OUTER WOVEN BRAID LAYER JUST ENOUGH TO CUT AWAY THE THIN FOIL WRAP BETWEEN THE TWO BRAIDS. FOLD THE OUTER BRAID BACK IN POSITION.

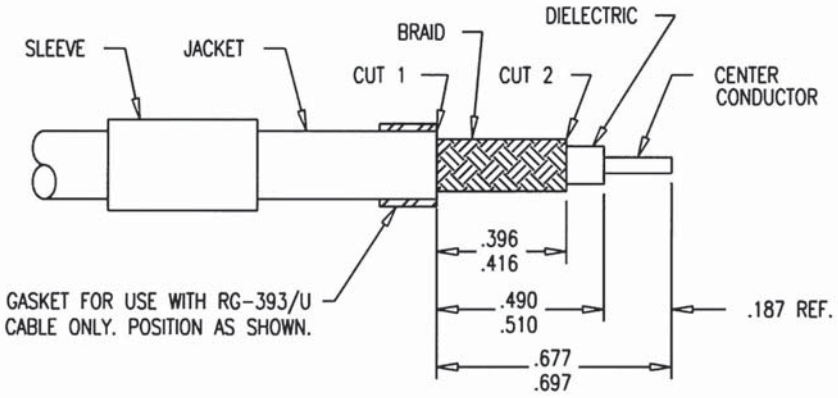
STEP 3.
FLARE RIBBON BRAID SLIGHTLY WITH FINGERS TO EDGE OF OUTER BRAID AND FOIL LAYERS. RIBBON SHOULD NOT BE TANGLED OR SHARPLY BENT. TRIM INNER RIBBON BRAID TO "B" DIMENSION SAME AS OUTER BRAID. TRIM DIELECTRIC TO "C" DIMENSION. TRIM CENTER CONDUCTOR TO "D" DIMENSION.

STEP 4.
PLACE CENTER CONTACT ON CENTER CONDUCTOR, BUTT UP AGAINST DIELECTRIC AND CRIMP OR SOLDER IN PLACE.

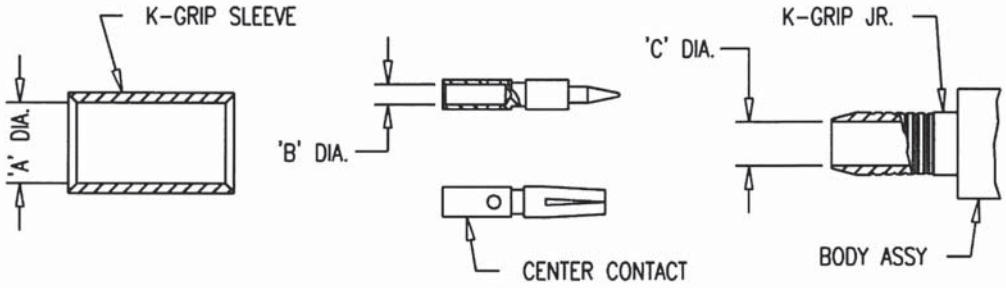
STEP 5.
ASSEMBLY K-GRIP END OF CONNECTOR BODY ASSEMBLY OVER DIELECTRIC AND UNDER FLARED BRAIDS, PUSHING CONTACT FIRMLY FORWARD UNTIL CONTACT GROOVE SNAPS INTO INTERNAL SHOULDER OF INSULATOR. SLIDE K-GRIP SLEEVE FORWARD OVER BOTH BRAID AGAINST BODY SHOULDER AND CRIMP HEX. USING KINGS CRIMP TOOL KTH-1000 AND DIE SHOWN IN CHART BELOW.

TRIM CODE CHART

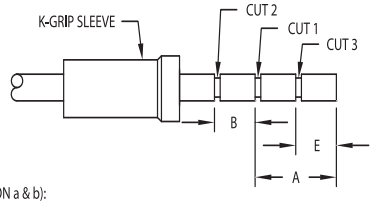
CONNECTOR	A	B	C	D	DIE SIZE
1205-65-5	5/8	9/32	.425	3/16	KTH-2005
1206-31-5					
1202-25-5					
821-8-5					
825-15-5					
846-6-5	13/16	9/32	.611	3/16	KTH-2005
845-8-5					



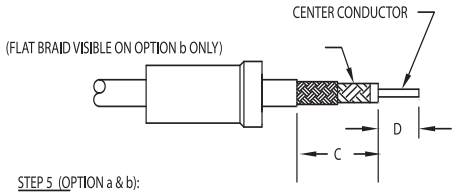
1. CUT CABLE END SQUARE. SLIDE K-GRIP SLEEVE OVER JACKET & MAKE CUTS 1 & 2 THROUGH JACKET ONLY.
2. REMOVE END OF JACKET UP TO CUT 2, FLARE OR BULGE BACK BRAID & TRIM WITH SCISSORS AT EDGE OF JACKET.
3. REMOVE JACKET BETWEEN CUTS 1 & 2 EXPOSING .406 ±.010 LENGTH OF BRAID.
4. TRIM DIELECTRIC TO .500 ±.010 DIM., EXPOSED CENTER CONDUCTOR WILL BE .187 REF.
5. PLACE CENTER CONTACT ON CABLE AGAINST DIELECTRIC & CRIMP OR SOLDER IN PLACE.
6. PUSH K-GRIP JR. OVER DIELECTRIC AND UNDER BRAID UNTIL DIELECTRIC BOTTOMS IN CONNECTOR.
7. SLIDE K-GRIP SLEEVE OVER K-GRIP & BRAID TO SHOULDER OF BODY ASSY & FORM HEX USING APPLICABLE CRIMP TOOL & DIE.



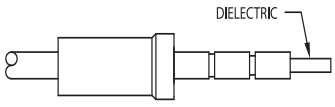
MILITARY PART NO.	KINGS PART NO.	PIECE PART DIM'S			SLEEVE (CRIMP TOOL M22520/5-01	EQUIV. KINGS DIE SIZE *
		A	B	C	DIE SIZE M22520/5-25	
M39012/01-0017	1205-68-5	.420	.092	.297	CLOSURE A	KTH-2004
M39012/01-0018	1205-69-5	.440				



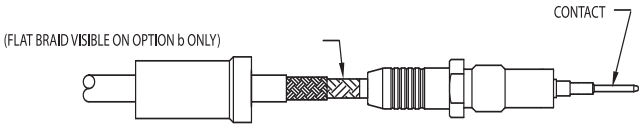
STEP 1 (OPTION a & b):
CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE OVER JACKET.
(CAUTION: WHEN USING A SINGLE STEP W/P SLEEVE, SLIDE SMALL END OVER CABLE FIRST AS SHOWN. MAKE CUTS 1 AND 2 IN JACKET.
(OPTION b ONLY): MAKE ADDITIONAL CUT 3 IN JACKET.



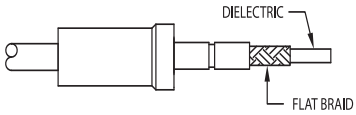
STEP 5 (OPTION a & b):
TRIM DIELECTRIC TO DIMENSION "C". EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO DIMENSION "D".



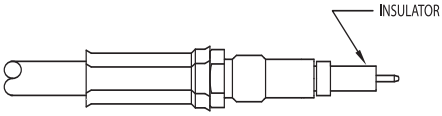
STEP 2 (OPTION a & b):
REMOVE JACKET TO DIMENSION "A" (OPTION a) OR "E" (OPTION b).
REMOVE ROUND BRAID AND FLAT BRAID AT EDGE OF JACKET. BE SURE ENDS OF FLAT BRAID ARE FLAT AGAINST DIELECTRIC. (IF USING OPTION a PROCEED TO STEP 4).



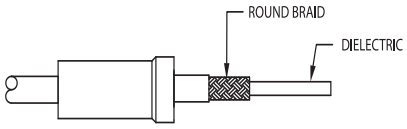
STEP 6 (OPTION a & b):
PUSH THE K-GRIP BODY OVER THE DIELECTRIC AND FLAT BRAID AND UNDER THE ROUND BRAID (ONCE THE FLAT BRAID IS UNDER THE K-GRIP BODY, A CAREFUL ROTATION OF THE DIELECTRIC AND FLAT BRAID WILL EASE ASSEMBLY UNDER THE ROUND BRAID). THE CABLE CENTER CONDUTOR WILL BE VISIBLE THROUGH THE CONTACT INSPECTION HOLES. CRIMP OR SOLDER THE CONTACT.



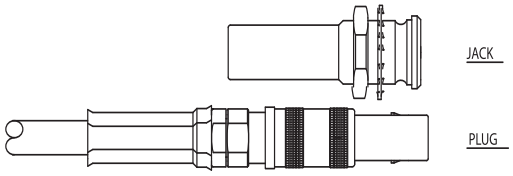
STEP 3 (OPTION b ONLY):
REMOVE JACKET TO DIMENSION "A". FLAIR OR BULGE BACK ROUND BRAID ONLY AND TRIM AT EDGE OF JACKET.



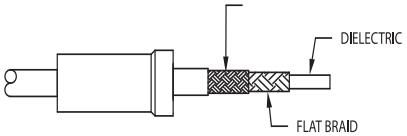
STEP 7
SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM HEX BY CRIMPING. INSTALL THE INSULATOR.



STEP 4 (OPTION a):
REMOVE JACKET TO DIMENSION "B". FLAT BRAID IS VISIBLE ON OPTION b ONLY.
ROUND BRAID



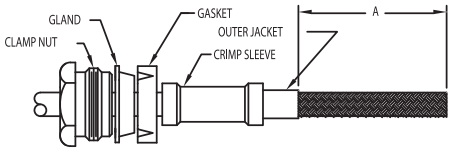
STEP 8
SCREW THE OUTER BODY ONTO THE CRIMPED ASSEMBLY USING A MINIMUM TORQUE OF 5 INCH POUNDS AND A MAXIMUM TORQUE OF 10 INCH POUNDS.



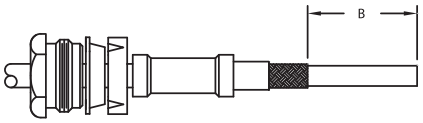
STEP 4 (OPTION b):
REMOVE JACKET TO DIMENSION "B". FLAT BRAID IS VISIBLE ON OPTION b ONLY.

TRIM CODE CHART

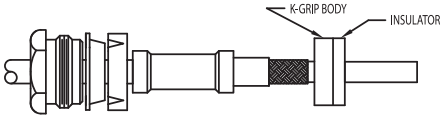
DASH NO.	OPTION	A	B	C	D	E
-1	a	.625	.312	.750	.188	——
	b					.260



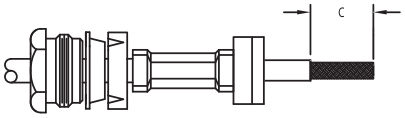
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT, GLAND, GASKET, AND CRIMP SLEEVE OVER THE OUTER JACKET. REMOVE THE OUTER JACKET TO DIMENSION "A".



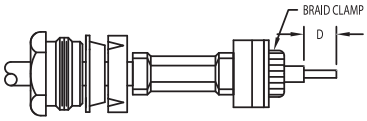
2. REMOVE THE OUTER BRAID TO DIMENSION "B"



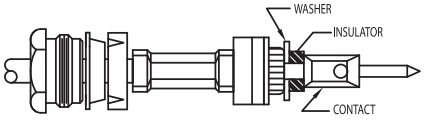
3. INSERT THE CABLE INTO THE K-GRIP BODY WITH THE BRAID OVER THE K-GRIP. SLIDE THE CRIMP SLEEVE OVER THE BRAID AND FORM A HEX WITH THE CRIMP DIE.



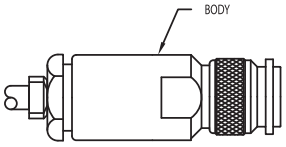
4 REMOVE THE INNER JACKET TO DIMENSION "C" .



5. PLACE THE BRAID CLAMP OVER THE INNER BRAID AND AGAINST THE INNER JACKET. COMB OUT THE BRAID AND FOLD BACK OVER THE BRAID CLAMP. TRIM EVEN WITH THE BASE OF THE BRAID CLAMP. REMOVE DIELECTRIC TO DIMENSION "D".

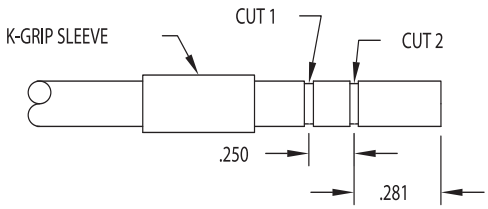


6. INSTALL THE WASHER AND INSULATOR OVER THE DIELECTRIC AND CRIMP THE CENTER CONTACT TO CENTER CONDUCTOR.

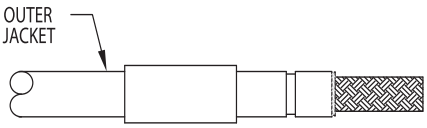


7. ASSEMBLE INNER INSULATOR, INTERMEDIATE CONTACT AND OUTER INSULATOR, THEN INSERT INTO THE BODY. SLIDE THE BACK END PARTS FORWARD. THREAD ASSEMBLY INTO THE CONNECTOR BODY AND TIGHTEN WITH 5 IN. LBS. MIN. AND 30 IN. LBS MAX TORQUE.

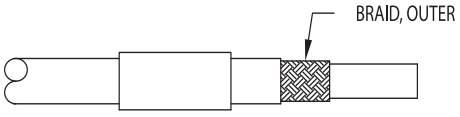
TRIM CODE CHART			
A	B	C	D
1.03	.75	.32	.156



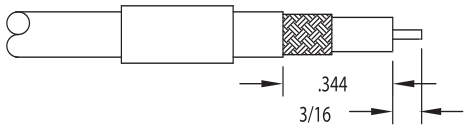
1. CUT CABLE END SQUARE, SLIDE K-GRIP SLEEVE OVER JACKET AND MAKE CUTS 1 AND 2 IN OUTER JACKET ONLY.



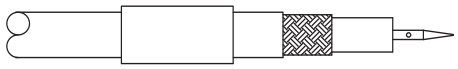
2. REMOVE OUTER JACKET TO .281 DIMENSION, FLARE OR BULGE BACK BRAID AND TRIM WITH SCISSORS AT EDGE OF OUTER JACKET



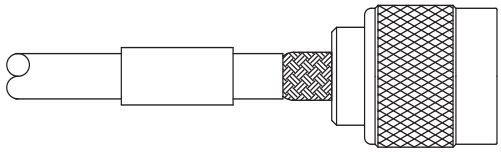
3. REMOVE JACKET TO .250 DIMENSION.



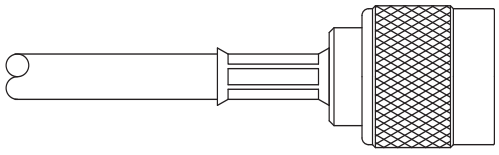
4. TRIM DIELECTRIC TO DIMENSION .344 EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO 3/16 DIMENSION.



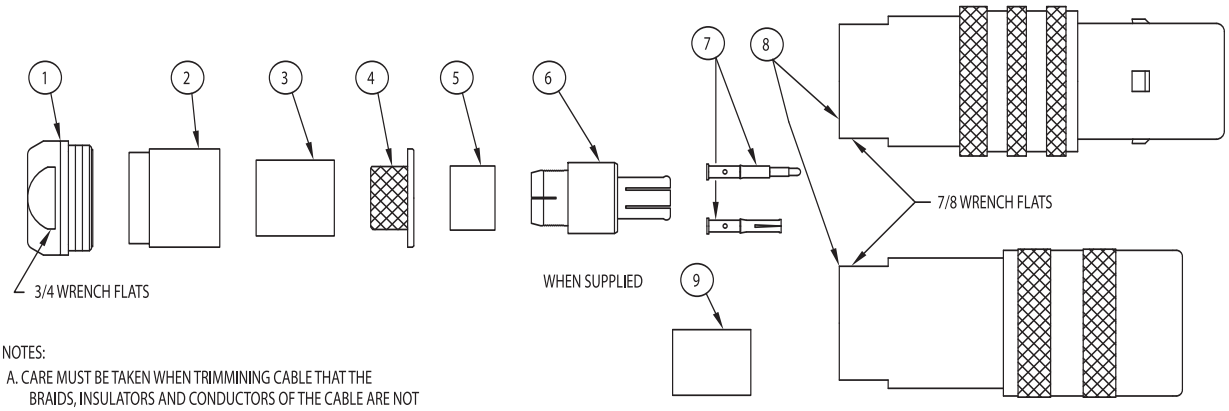
5. SOLDER OR CRIMP CONTACT TO CENTER CONDUCTOR.



6. PUSH K-GRIP JR. OVER DIELECTRIC AND UNDER BOTH BRAIDS UNTIL DIELECTRIC BOTTOMS IN CONNECTOR .



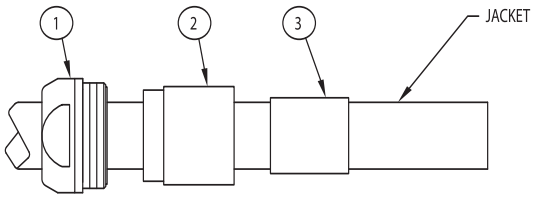
7. SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM BY CRIMPING.



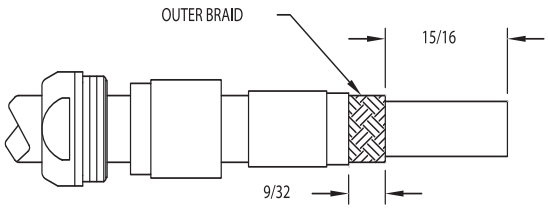
NOTES:

A. CARE MUST BE TAKEN WHEN TRIMMINING CABLE THAT THE BRAIDS, INSULATORS AND CONDUCTORS OF THE CABLE ARE NOT NICKED OR DAMAGED.

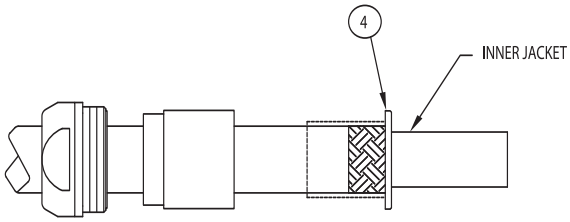
B. WHEN A THREE CAVITY DIE IS USED THE FIRST CRIMP ON THE OUTER BRAID (STEP 3) IS DONE WITH THE LARGEST CAVITY. ASSEMBLE DIE IN CRIMP TOOL FRAME USING SHANKS AJACENT TO THAT CAVITY. REVERSE THE DIE IN THE TOOL USING OTHER SHANKS WHEN CRIMPING CENTER CONTACT (STEP 5) AND INNER BRAID (STEP 6).



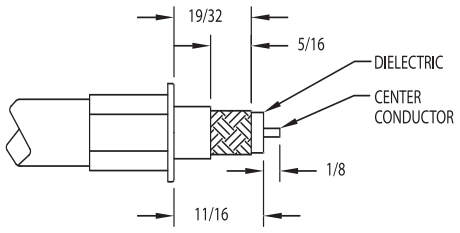
1. CUT CABLE END SQUARE. PLACE CLAMP NUT ASSEMBLY (ITEM 1), SPACER (ITEM 2) AND LARGE CRIMP SLEEVE (ITEM 3) OVER THE JACKET.



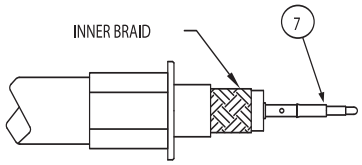
2. REMOVE JACKET AND OUTER BRAID TO 15/16 DIM. THEN REMOVE JACKET AN ADDITIONAL 9/32 EXPOSING OUTER BRAID.



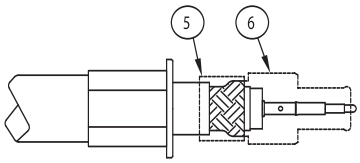
3. SLIDE K-GRIP (ITEM 4) OVER INNER JACKET AND UNDER OUTER BRAID. HOLD IN POSITION AND MOVE CRIMP SLEEVE FORWARD AGAINST SHOULDER AND CRIMP IN PLACE USING APPROPRIATE HEX DIE.



4 A. REMOVE INNER JACKET AND INNER BRAID TO 19/32 DIM. REMOVE INNER JACKET AN ADDITIONAL 5/16 EXPOSING INNER BRAID.
B. REMOVE DIELECTRIC TO 11/16 DIM. AND CUT CENTER CONDUCTOR TO BE 1/8 LONG.



5. PLACE THE MALE OR FEMALE CONNECTOR CONTACT (ITEM 7) ON THE CABLE CENTER CONDUCTOR, BOTTOM AGAINST DIELECTRIC AND SOLDER OR CRIMP IN PLACE.



6. PLACE SMALL SLEEVE (ITEM 5) OVER INNER BRAID OF CABLE. SLIDE BODY ASSEMBLY (ITEM 6) OVER THE DIELECTRIC AND UNDER THE INNER BRAID UNTIL THE CENTER CONTACT LOCKS IN PLACE IN BODY ASSEMBLY. (NOTE; CAUTION MUST BE EXERCISED NOT TO ALLOW ANY BRAID STRANDS TO REMAIN INSIDE THE BODY ASSEMBLY. ALL BRAID MUST BE ON THE OUTSIDE OF THE BODY). SLIDE CRIMP SLEEVE FORWARD OVER BOTH THE BODY AND BRAID TO THE BODY SHOULDER. CRIMP IN PLACE. PUSH ALL LOOSE PARTS FORWARD ON CABLE AND INSERT INTO MAIN CONNECTOR BODY (ITEM 8). THREAD CLAMP NUT ASSEMBLY INTO BODY AND LOCK SECURELY.

"U" SPACER, ITEM 9 IS SUPPLIED ONLY WITH SMALL CABLE CONNECTORS. IT IS PLACED OVER ITEM 5 AFTER CRIMPING & BEFORE THREADING CABLE ASSEMBLY INTO BODY.

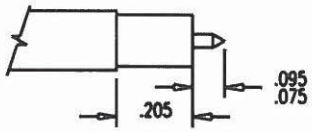
RECOMMENDED TORQUE: 80 IN LBS.

CABLING PROCEDURE FOR M17/130-00004

1. CUT CABLE END SQUARE

2. WHEN USING T-FLEX402HF CABLE SOLDER DIP CABLE PER SHEET 2 OF 3-648.

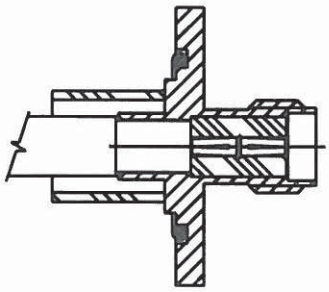
3. TRIM CABLE TO DIMENSIONS SHOWN.



4. INSERT TRIMMED CABLE INTO CONNECTOR.

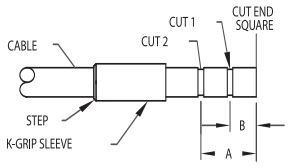
   BOTTOM CABLE AGAINST INSULATOR (ASSEMBLE MATING CONNECTOR

   TO PREVENT INSULATOR MOVEMENT).



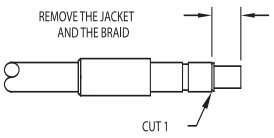
5. SOLDER CABLE IN BODY

1.



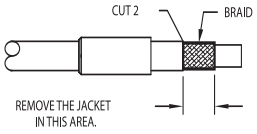
1. CUT THE CABLE-END SQUARE. SLIDE THE K-GRIP SLEEVE ONTO THE CABLE. MAKE "CUT 1" AND "CUT 2" IN THE JACKET.

2.



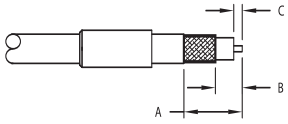
2. REMOVE THE JACKET AND THE BRAID TO DIMENSION B. TO REMOVE THE BRAID: FLARE BACK OR BULGE BACK THE BRAID AND TRIM WITH SCISSORS AT "CUT 1"

3.



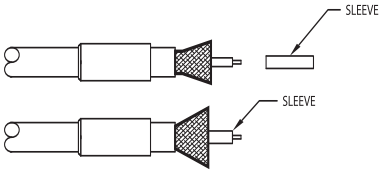
3. REMOVE JACKET TO DIMENSION A

4.



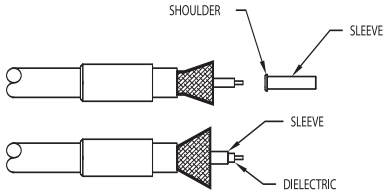
4. TRIM DIELECTRIC FROM CABLE END TO DIMENSION "C". EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO DIMENSION "C".

4A.



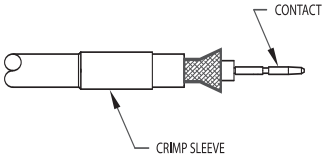
4A. FLARE BRAID TO PERMIT INSERTION OF SLEEVE, SHOULDER END FIRST, OVER DIELECTRIC AND UNDER BRAID.

4B.



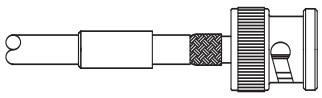
4A. FLARE BRAID TO PERMIT INSERTION OF SLEEVE, SHOULDER END FIRST, OVER DIELECTRIC AND UNDER BRAID. A SHORT LENGTH OF DIELECTRIC SHOULD BE VISIBLE.

5.



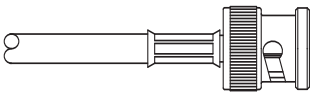
5. WITH THE BRAID FLARED, SLIDE CONTACT INTO POSITION AND CRIMP CONTACT TO CENTER CONDUCTOR.

6.



6. PUSH K-GRIP JR. OVER DIELECTRIC & UNDER BRAID UNTIL CENTER CONTACT IS LOCKED IN INSULATOR (THIS CAN BE CHECKED BY APPLYING SLIGHT FINGER PRESSURE TO THE CABLE).

7.



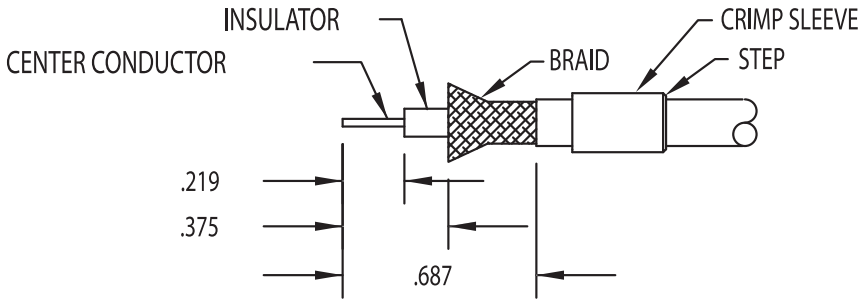
7. SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM BY CRIMPING.

DASH NO	A	B	C
-1	.624	.312	.155
-2	.624	.312	.249
-3	.687	.375	.187
-4	.668	.356	.200
-5	.687	.375	.219
-6	.540	.250	.150

NOTES:
1. STEP 4A APPLIES ONLY TO CONNECTORS SUPPLIED W/PLASTIC SLEEVE
2. STEP 4B APPLIES ONLY TO CONNECTORS SUPPLIED W/METAL SLEEVE

735 CABLE INSTALLATION INSTRUCTIONS USING KINGS DIE SET KTH-2185

1. SLIDE CRIMP SLEEVE ONTO CABLE WITH STEP LOCATED AWAY FROM THE CONNECTOR BODY.



3. SLIDE THE CONTACT ALL THE WAY ONTO THE CENTER CONDUCTOR. BE SURE THAT CONTACT BUTTS AGAINST THE DIELECTRIC. CRIMP CONTACT TO CENTER CONDUCTOR. REQUIRED DIE FLAT DIMENSIONS ARE .042". USE OF APPROVED 12 POINT CRIMP TOOLS IS OPTIONAL.

4. SLIGHTLY FAN OUT THE BRAID AT THE END. PUSH CABLE INTO CONNECTOR UNTIL CONTACT SNAPS INTO PLACE. ALL BRAID WIRES MUST BE OVER THE SUPPORT SLEEVE. FOIL MUST BE UNDER SUPPORT SLEEVE.

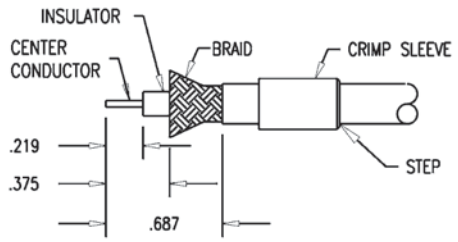
5. DRESS THE BRAID EVENLY AROUND THE SUPPORT SLEEVE. SLIDE CRIMP SLEEVE FORWARD OVER BRAID AND AGAINST CONNECTOR. FORM BY CRIMPING. REQUIRED DIE FLAT DIMENSIONS ARE .178".

INSTALLATION INSTRUCTIONS

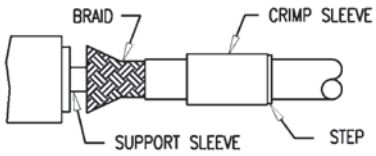
CARD COLOR RED/BLACK MARKING

FOR 735-TYPE CABLE USING KTH-2185

1. SLIDE CRIMP SLEEVE ONTO CABLE WITH STEP LOCATED AWAY.
2. STRIP CABLE AS SHOWN BELOW. THE LENGTHS IN THIS PICTURE ARE ACTUAL SIZE AND MAY BE USED AS GAUGE.



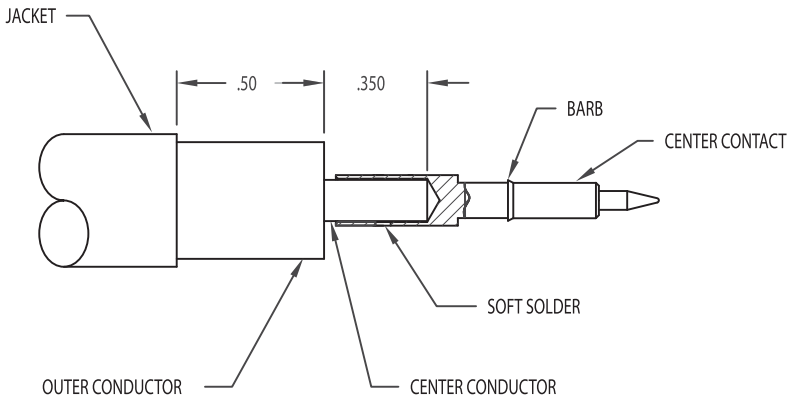
3. SLIDE THE CONTACT ALL THE WAY ON TO THE CENTER CONDUCTOR. BE SURE THAT CONTACT BUTTS AGAINST THE DIELECTRIC. CRIMP CONTACT TO CENTER CONDUCTOR. REQUIRED DIE FLAT DIMENSIONS ARE .042". USE OF APPROVED 12 POINT CRIMP TOOLS IS OPTIONAL.



4. SLIGHTLY FAN OUT THE BRAID AT THE END. PUSH CABLE INTO CONNECTOR UNTIL CONTACT SNAPS INTO PLACE. ALL BRAID WIRES MUST BE OVER THE SUPPORT SLEEVE. FOIL MUST BE UNDER SUPPORT SLEEVE.

5. DRESS THE BRAID EVENLY AROUND THE SUPPORT SLEEVE. SLIDE CRIMP SLEEVE FORWARD OVER BRAID AND AGAINST CONNECTOR. FORM BY CRIMPING. REQUIRED DIE FLAT DIMENSIONS ARE .178".

FOR TECHNICAL SUPPORT CALL (888) 909-5551.



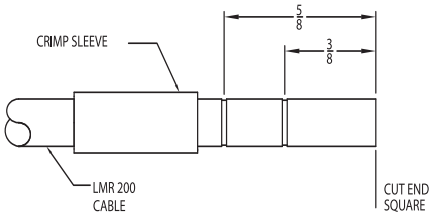
1) TRIM CABLE AS SHOWN. CARE MUST BE TAKEN TO AVOID METAL PARTICLES ON DIELECTRIC FACE.

2) BOTTOM CABLE CENTER CONDUCTOR IN CONTACT WIRE HOLE. HOLD IN POSITION AND SOFT SOLDER.

3) INSERT CONTACT INTO BODY ASSEMBLY AND PUSH CONTACT BARB INTO TEFLON INSULATOR UNTIL CABLE BOTTOMS IN BODY.

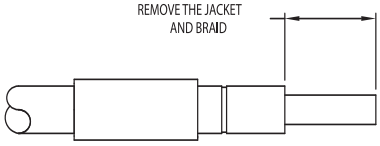
4) SOFT SOLDER BODY TO CABLE OUTER CONDUCTOR.

1.



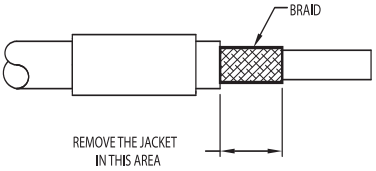
1. CUT THE CABLE-END SQUARE. SLIDE THE CRIMP SLEEVE ONTO THE CABLE. MAKE CUTS IN THE JACKET AT 3/8" AND 5/8" FROM THE END OF THE CABLE.

2.



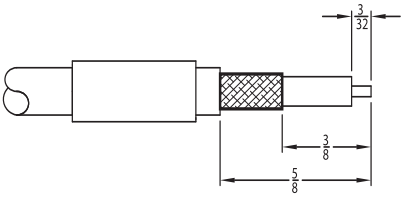
2. REMOVE THE JACKET AND BRAID TO THE FIRST CUT, 3/8" FROM THE CABLE-END. TO REMOVE THE BRAID, FLARE BACK OR BULGE THE BRAID AND TRIM WITH SCISSORS.

3.



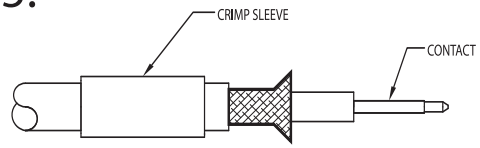
3. REMOVE THE JACKET TO THE SECOND CUT, 5/8" FROM CABLE-END.

4.



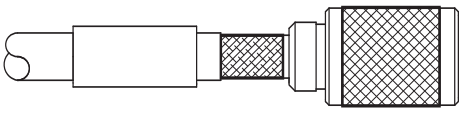
4. TRIM DELECTRIC 3/32" FROM CABLE END TO EXPOSE CENTER CONDUCTOR.

5.



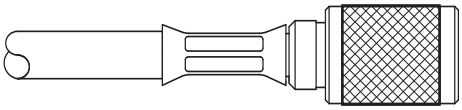
5. SLIGHTLY FLARE THE BRAID AND SLIDE CONTACT INTO POSITION AND CRIMP CONTACT TO CENTER CONDUCTOR USING KTH-1000 CRIMP TOOL AND KTH-2026 DIE SET.

6.



6. PUSH K-GRIP OF CONNECTOR OVER DIELECTRIC AND FOIL AND UNDER THE CABLE BRAID UNTIL THE DIELECTRIC BOTTOMS IN THE CONNECTOR.

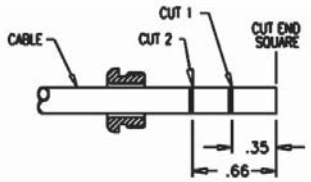
7.



7. SLIDE CRIMP SLEEVE OVER K-GRIP AND BRAID TO THE CONNECTOR BODY SHOULDER. CRIMP IN PLACE USING KTH-1000 CRIMP TOOL AND KTH-2026 DIE SET.

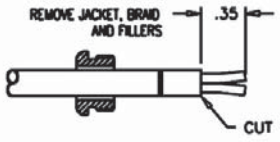
NOTES:
NO SPECIFIC ORIENTATION FOR CRIMP SLEEVE.

1.



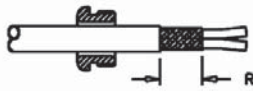
1. CUT THE CABLE-END SQUARE. SLIDE THE CLAMP NUT ONTO THE CABLE. MAKE CUT 1 AND CUT 2 IN THE JACKET.

2.



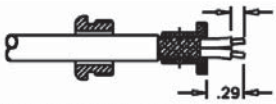
2. REMOVE JACKET, BRAID AND FILLERS TO .35 DIMENSION. TO REMOVE THE BRAID: FLARE BACK OR BULGE BACK THE BRAID AND TRIM WITH SCISSORS AT "CUT 1".

3.



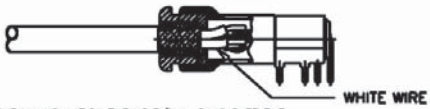
3. REMOVE CABLE OUTSIDE JACKET TO LEAVE BRAID EXPOSED.

4.



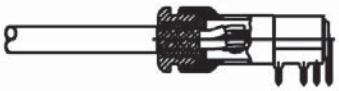
4. INSERT SOLDER TAIL OVER THE BRAID UNTIL BOTTOMED. SOFT SOLDER IN PLACE, USING RMA SOLDER.
HEAT AND APPLY SOLDER INTO THE (2) SMALLER SOLDER HOLES. AFTER SOLDERING, TRIM & STRIP WIRES TO DIMENSIONS AS SHOWN.

5.



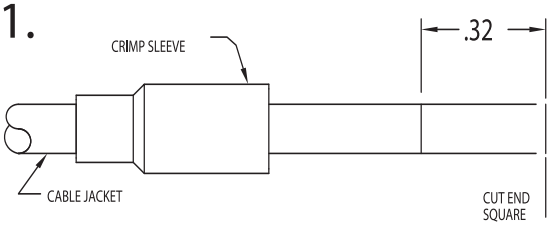
5. INSERT SHRINK INSULATION TUBING P/N 1-8449 OVER THE WHITE WIRE.
SECURE CABLE AND SOLDER TAIL TO CONNECTOR ASSEMBLY.
SOLDER WHITE SLEEVE WIRE TO CENTER CONTACT.
SOLDER CLEAR SLEEVE WIRE TO INTERMEDIATE CONTACT.
MAKE SURE NOT TO HAVE ANY SOLDER BRIDGE BETWEEN CENTER AND INTERMEDIATE CONTACTS. HEAT SHRINK INSULATION TUBING P/N 1-8449 OVER THE CENTER CONTACT/ WHITE WIRE SOLDER JOINT AS SHOWN.

6.



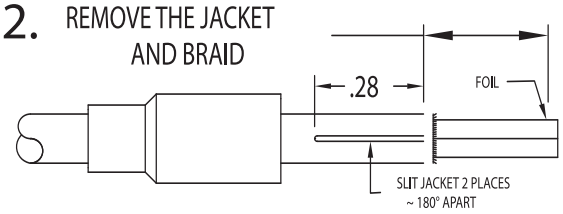
6. TORQUE CLAMP NUT TO BODY ASSEMBLY AND LOCK SECURELY.
RECOMMENDED TORQUE: 20-26 IN-LBS.
STAKE 1 PLACE ON BODY AS A THREADLOCK FEATURE TO LOCK CLAMP NUT IN PLACE.

1.



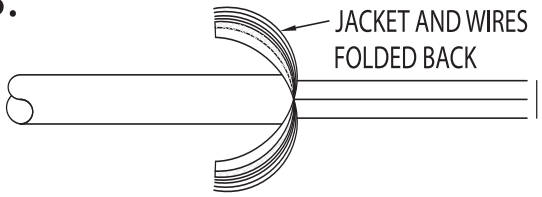
1. CUT THE CABLE-END SQUARE. SLIDE THE CRIMP SLEEVE ONTO THE CABLE. MAKE CUTS IN THE JACKET AT .32" FROM THE END OF THE CABLE.

2. REMOVE THE JACKET AND BRAID



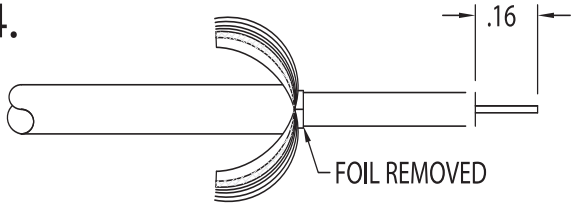
2. REMOVE THE JACKET AND BRAID TO THE FIRST CUT. SLIT THE JACKET 2 PLACES AS SHOWN .28 LONG.

3.



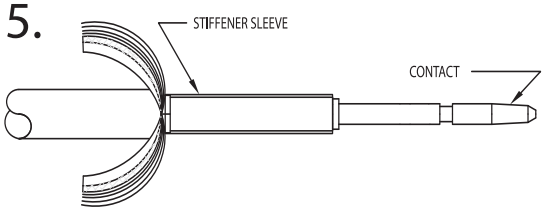
3. FOLD BACK TWO JACKET SECTIONS ALONG WITH OUTER CONDUCTOR WIRE STRANDS.

4.



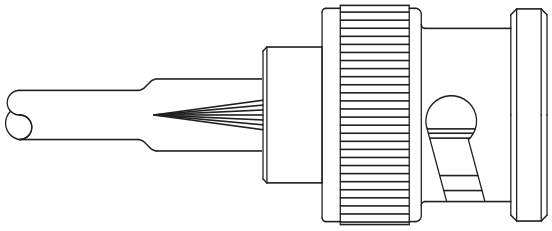
4. REMOVE FOIL AS CLOSE TO FOLDED BACK JACKET AS POSSIBLE. TRIM DIELECTRIC AS SHOWN.

5.



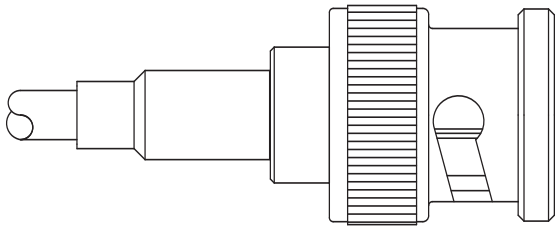
5. SLIDE STIFFENER SLEEVE OVER CABLE DIELECTRIC CRIMP CONTACT INTO PLACE WITH NAIL HEAD AGAINST DIELECTRIC.

6.



6. INSERT CONTACT INTO K-GRIP OF CONNECTOR AND SNAP INTO PLACE. FOLD WIRE AND JACKET SECTIONS OVER K-GRIP.

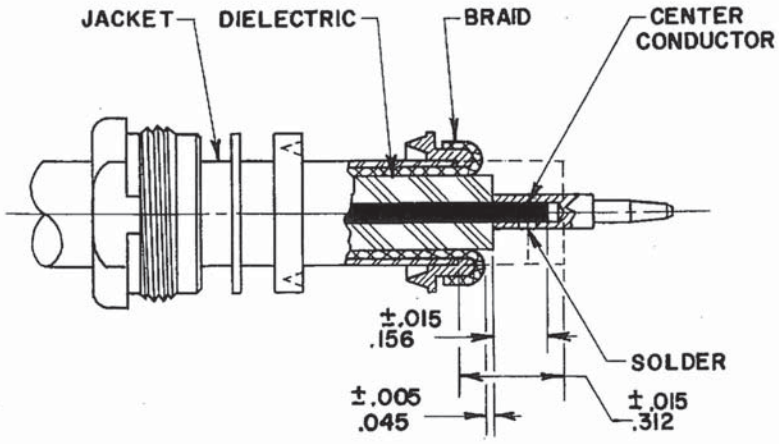
7.



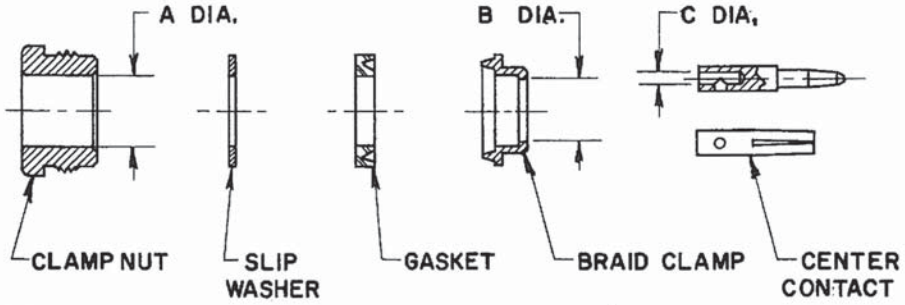
7. SLIDE CRIMP SLEEVE OVER K-GRIP AND JACKET TO THE CONNECTOR BODY SHOULDER AND CRIMP IN PLACE.

NOTES:

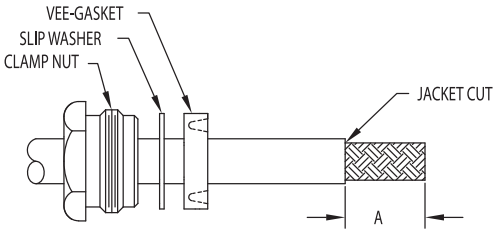
1. LARGE I.D. OF CRIMP SLEEVE TO GO OVER K-GRIP BODY OF CONNECTOR.



1. WITH CLAMP NUT, SLIP WASHER & GASKET ON CABLE, REMOVE JACKET TO .312 ± .015 DIM.
2. SLIDE BRAID CLAMP OVER BRAID AGAINST JACKET EDGE. COMB OUT BRAID WIRES, FOLD BACK OVER BRAID CLAMP & TRIM AS SHOWN.
3. REMOVE DIELECTRIC TO .045 ± .005 DIM. & TRIM CENTER CONDUCTOR TO .156 ± .015 DIM.
4. SOLDER CENTER CONTACT TO CENTER CONDUCTOR.
5. THREAD ASSEMBLY SECURELY INTO CONNECTOR BODY. RECOMMENDED TORQUE: 55-60 IN.LBS.

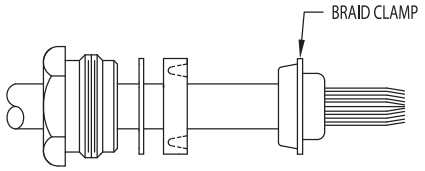


MILITARY PART NUMBER	KINGS NUMBER	CABLE USAGE	PIECE PART DIM'S. A DIA.	B DIA.	C DIA.
M39012/06-0001 M39012/08-0002 M39012/11-0001	KD-59-132 KD-19-71 KD-19-61	RG-5,6,21,143, 212,222,304/U	.35	.27	.06
M39012/06-0002 M39012/08-0001 M39012/11-0002	KD-59-119 KD-19-72 KD-19-73	RG-8,9,213, 214/U	.44	.37	.10

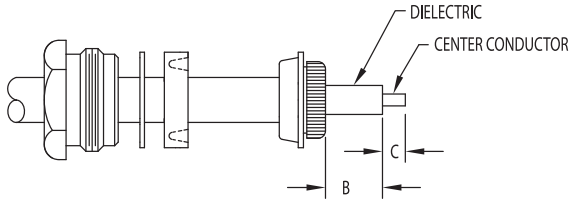


TRIM CODE CHART			
DASH NO.	A	B	C
-1	.625	.288	.218

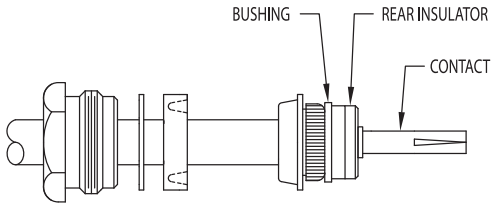
1. CUT CABLE END SQUARE, PLACE CLAMP NUT, SLIP WASHER (WHEN SUPPLIED) AND VEE-GASKET OVER JACKET. REMOVE JACKET TO DIMENSION "A".



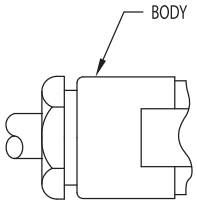
2. COMB OUT BRAID AND TAPER FORWARD. PLACE BRAID CLAMP OVER BRAID AGAINST JACKET CUT.



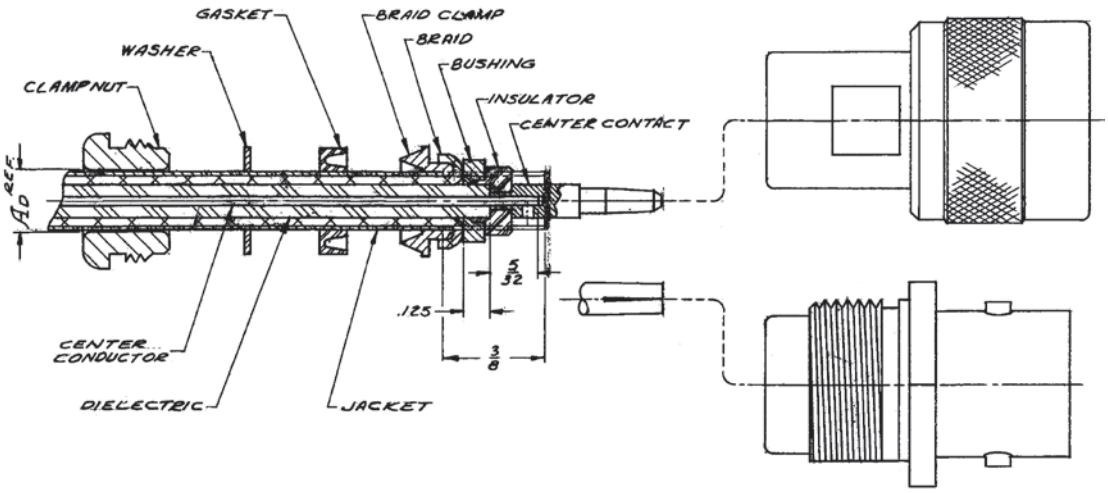
3. FOLD OUTER BRAID BACK OVER BRAID CLAMP AND TRIM AS SHOWN. REMOVE INNER JACKET TO EDGE OF OUTER BRAID. COMB OUT INNER BRAID AND FOLD BACK OVER OUTER BRAID AND BRAID CLAMP. TRIM INNER BRAID AS SHOWN. REMOVE DIELECTRIC TO DIMENSION "B". CUT CENTER CONDUCTOR TO DIMENSION "C".



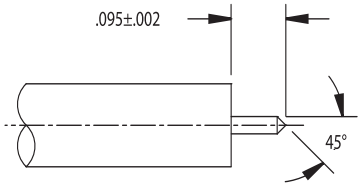
4. PLACE BUSHING AND REAR INSULATOR OVER DIELECTRIC AND AGAINST BRAID CLAMP AS SHOWN. SOLDER OR CRIMP (WHEN APPLICABLE) CONTACT TO CENTER CONDUCTOR.



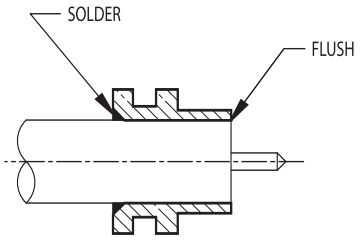
5. PLACE FRONT INSULATOR OVER CONTACT. THREAD ASSEMBLY INTO CONNECTOR BODY AND LOCK SECURELY. VEE-GASKET MUST BE SPLIT BY BRAID CLAMP. (35-40 IN-LBS RECOMMENDED TORQUE).



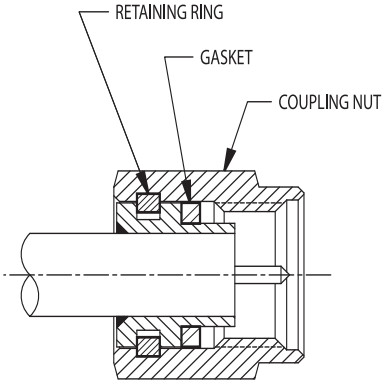
1. CUT CABLE END SQUARE. SLIDE CLAMP NUT, WASHER & GASKET OVER JACKET.
2. REMOVE JACKET TO 3/8 DIMENSION WITHOUT NICKING BRAID.
3. SLIDE BRAID CLAMP OVER BRAID AND BUTT AGAINST JACKET SHOULDER.
4. COMB OUT BRAID WIRES, FLARE OVER BRAID CLAMP SHOULDER AND TRIM AS SHOWN.
5. REMOVE DIELECTRIC TO .125 DIMENSION. DO NOT NICK CENTER CONDUCTOR.
6. CUT CENTER CONDUCTOR TO 5/32 DIMENSION AND TIN.
7. ASSEMBLE BUSHING, INSULATOR AND CENTER CONTACT ON CABLE AS SHOWN. SOLDER CONTACT IN POSITION WITHOUT DISTORTING DIELECTRIC BY OVER HEATING.
8. THREAD ASSEMBLY INTO CONNECTOR BODY AND TIGHTEN SUFFICIENTLY TO SPLIT GASKET AND INSURE GOOD CONTACT BETWEEN BRAID CLAMP AND WASHER.



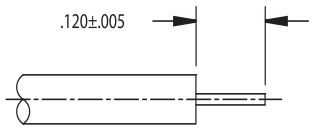
1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR. CHAMFER CENTER CONDUCTOR AS SHOWN.



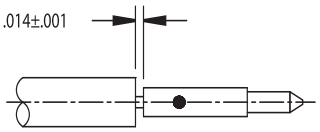
2. INSERT CABLE INTO BODY. BODY AND CABLE TO BE FLUSH AT INTERFACE. SOLDER CABLE INTO BODY. TRIM ANY EXCESS DIELECTRIC MATERIAL.



3. ASSEMBLE GASKET, RETAINING RING, AND COUPLING NUT.



1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR.



2. SOLDER CONDUCTOR TO CENTER CONTACT. LEAVE GAP AS SHOWN. CLEAN.

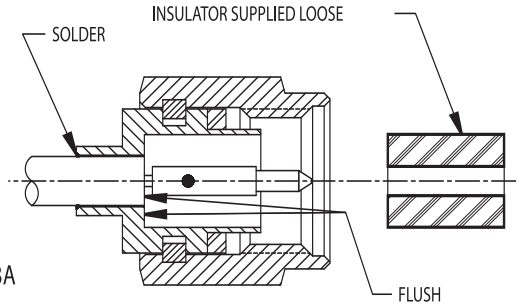


FIG. 3A

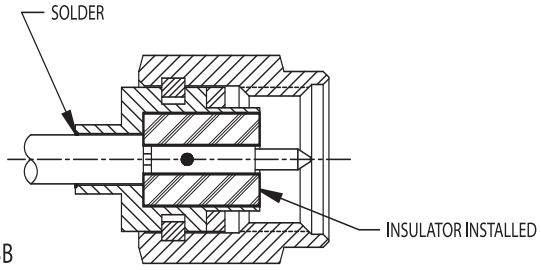
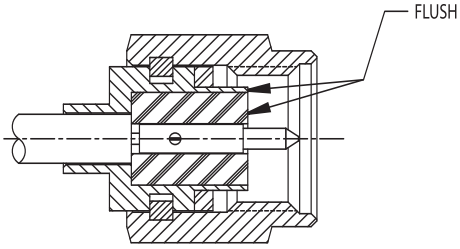
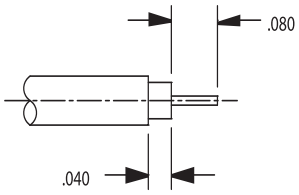


FIG. 3B

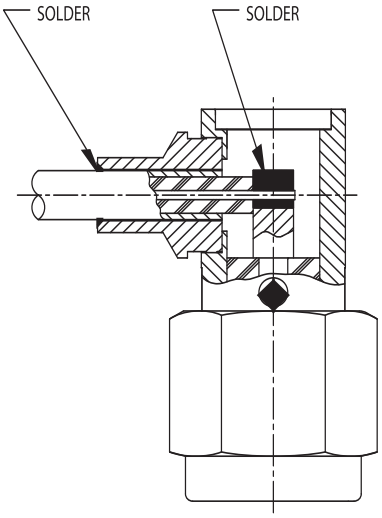
3. FOR CONNECTORS WITH INSULATORS SUPPLIED LOOSE:
INSERT CABLE INTO BODY UNTIL CABLE IS FLUSH WITH SHOULDER IN BODY. SOLDER CABLE INTO BODY. TRIM ANY EXCESS DIELECTRIC MATERIAL. CLEAN. REFER TO FIG. 3A.
FOR CONNECTORS WITH INSULATORS INSTALLED:
INSERT CABLE INTO BODY UNTIL IT BUTTS AGAINST INSULATOR. SOLDER CABLE INTO BODY. CLEAN. REFER TO FIG. 3B.



4. FOR CONNECTORS WITH INSULATORS SUPPLIED LOOSE:
PRESS IN INSULATOR FLUSH TO BODY.



1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR.



2. INSERT CABLE INTO BODY. DIELECTRIC MUST BUTT AGAINST CENTER CONTACT, AND CENTER CONDUCTOR MUST ENTER SLOT IN CONTACT. SOLDER CABLE INTO BODY. CLEAN.

3. SOLDER CONDUCTOR INTO SLOT THROUGH REAR ACCESS HOLE. CLEAN.

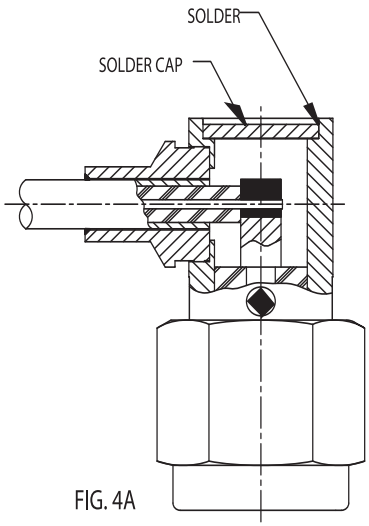


FIG. 4A

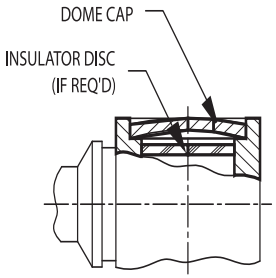


FIG. 4B

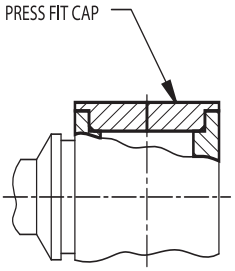
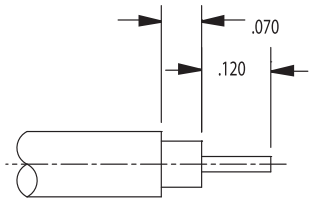
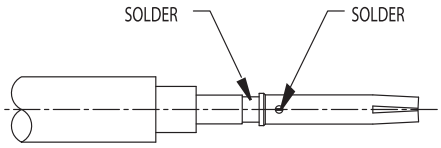


FIG. 4C

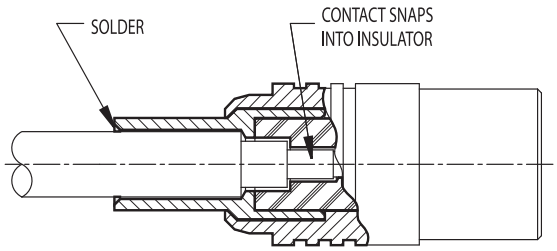
4. ASSEMBLE CAP INTO BODY:
   FOR FLAT CAPS, SOLDER CAP INTO BODY AND CLEAN (SEE FIG. 4A)
   FOR DOME CAPS, PLACE INSULATOR DISC (IF REQUIRED) INTO BODY. PLACE CAP IN BODY WITH DOME UP AND PRESS OR DIMPLE CAP. (SEE FIG. 4B)
   FOR PRESS FIT CAPS, PRESS CAP INTO BODY. (SEE FIG. 4C)



1. TRIM CABLE TO DIMENSION SHOWN. DO NOT NICK CENTER CONDUCTOR.

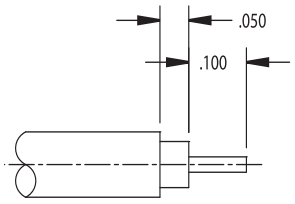


2. SOLDER CONTACT TO CENTER CONDUCTOR. CLEAN.

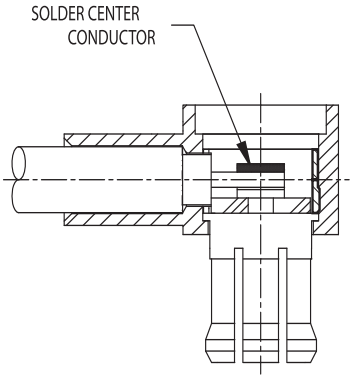


3. INSERT CENTER CONTACT INTO BODY UNTIL IT SNAPS INTO INSULATOR.

4. SOLDER CABLE JACKET TO BODY. CLEAN.

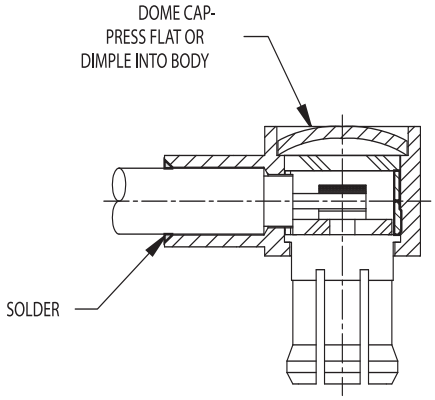


1. TRIM CABLE TO DIMENSION SHOWN. DO NOT NICK CENTER CONDUCTOR.



2. INSERT CABLE INTO BODY UNTIL CABLE BOTTOMS IN BODY. CENTER CONDUCTOR MUST ENTER SLOT IN CONTACT. SOLDER CONTACT. CLEAN.

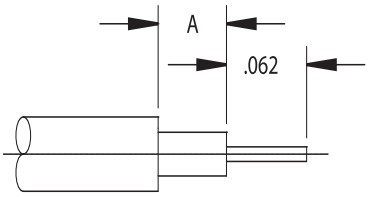
3. SOLDER CABLE JACKET INTO BODY. CLEAN.



4. PLACE INSULATOR INTO ACCESS HOLE OVER CONTACT.

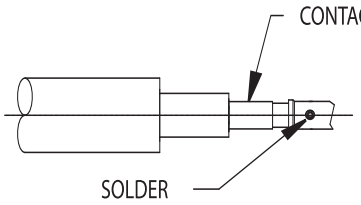
5. PLACE DOME CAP INTO BODY AND PRESS FLAT OR DIMPLE.

PART NUMBER		A
470-500-0470	471-500-0470	.040
470-500-0850	471-500-0850	.050

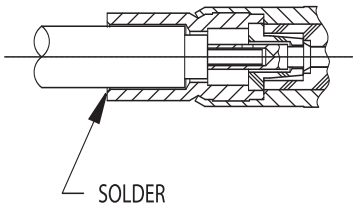


1. Trim cable to dimension shown. Do not nick center conductor.

2. Solder contact to center conductor. Clean.

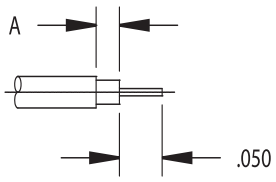


3. Insert center contact into body until it snaps into insulator.

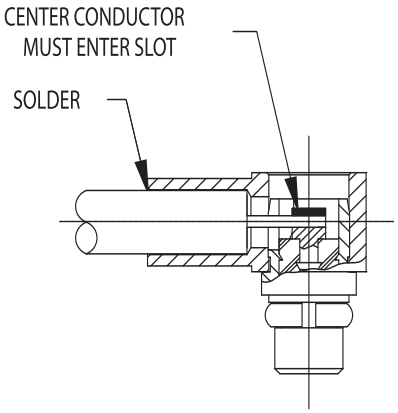


4. Solder cable jacket to body. Assure cable jacket bottoms in connector body while soldering. Allow to cool. Clean.

PART NUMBER	A
472-500-0470	.040
472-500-0850	.050

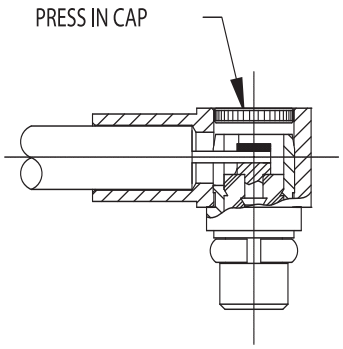


1. Trim cable to dimensions shown. Do not nick center conductor.

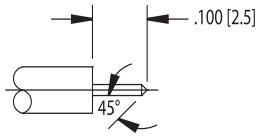


2. Insert cable into body until it butts. Center conductor must enter slot of contact.

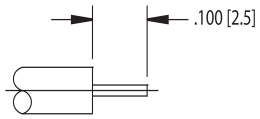
3. Solder cable jacket into body. Assure cable jacket bottoms in connector body while soldering. Allow to cool. Clean.



4. Solder center conductor of cable into slot of contact. Allow to cool. Clean. Press cap into body.



FOR RG-402 (Ø.141) CABLE



FOR RG-405 (Ø.085) CABLE

FIGURE 1

1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR. (SEE FIG. 1)

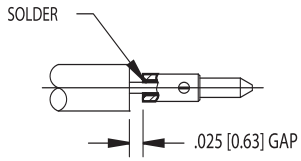


FIGURE 2

SKIP THIS STEP WHEN USING RG-402 (Ø.141) CABLE
2. SLIDE CENTER CONDUCTOR OF CABLE INTO REAR CONTACT. SET GAP BETWEEN CONTACT AND DIELECTRIC OF CABLE. SOLDER. CLEAN. (SEE FIG. 2)

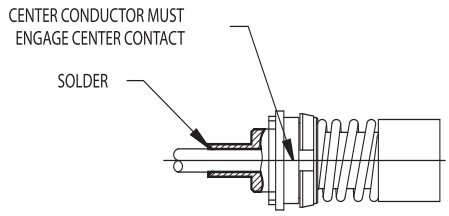


FIGURE 3

2. INSERT CABLE INTO BODY UNTIL IT BUTTS UP AGAINST COUNTERBORE. CENTER CONDUCTOR MUST ENGAGE TINES IN CENTER CONTACT. SOLDER OUTER CONDUCTOR OF CABLE TO BODY. CLEAN. (SEE FIG. 3)

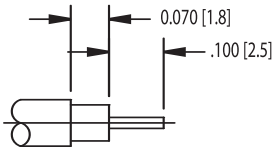


FIGURE 1

1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR. (SEE FIG. 1)

2. INSERT CABLE INTO BODY UNTIL IT BUTTS UP AGAINST COUNTERBORE. CENTER CONDUCTOR MUST ENTER SLOT IN CENTER CONTACT. SOLDER OUTER CONDUCTOR OF CABLE TO BODY. CLEAN. (SEE FIG. 2)

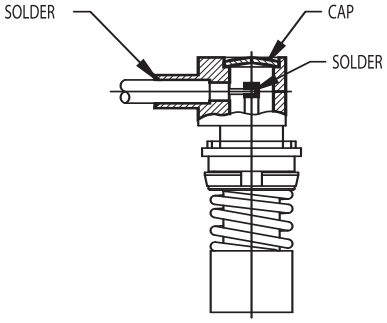
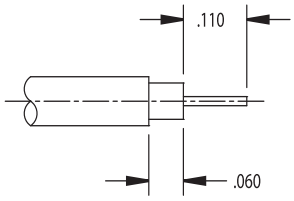


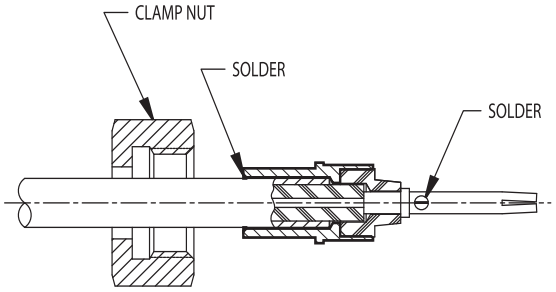
FIGURE 2

3. SOLDER CENTER CONDUCTOR OF CABLE TO CENTER CONTACT. CLEAN. (SEE FIG. 2)

4. PLACE CAP INTO BODY AS SHOWN AND DEPRESS CAP TO EXPAND INSIDE COUNTERBORE OF BODY. (SEE FIG. 2)

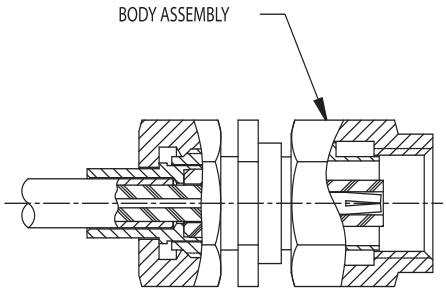


1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK THE CENTER CONDUCTOR.

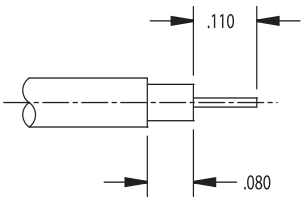


2. SLIDE CLAMP NUT OVER CABLE. INSERT CABLE INTO SLEEVE ASSEMBLY. CENTER CONDUCTOR MUST PASS THROUGH HOLE IN INSULATOR. CABLE JACKET MUST BUTT AGAINST SHOULDER INSIDE SLEEVE. SOLDER CABLE INTO SLEEVE. CLEAN.

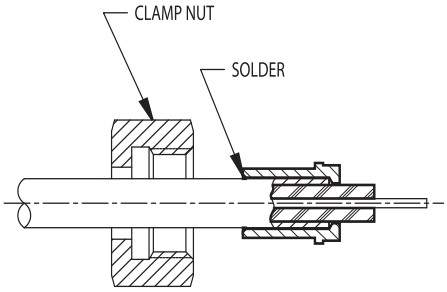
3. ASSEMBLE CENTER CONTACT TO CENTER CONDUCTOR BY INSERTING INTO HOLE OF INSULATOR. SOLDER CONDUCTOR THROUGH HOLE IN CONTACT. CLEAN.



4. ASSEMBLE SLEEVE ASSEMBLY TO BODY. SLIDE CLAMP NUT FORWARD AND CLAMP SLEEVE TO BODY. TORQUE CLAMP NUT TO 8 IN.-LBS.

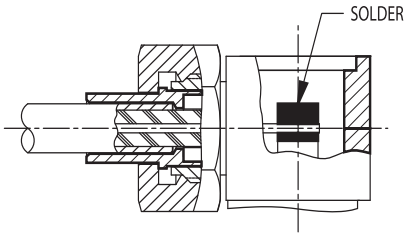


1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK THE CENTER CONDUCTOR.



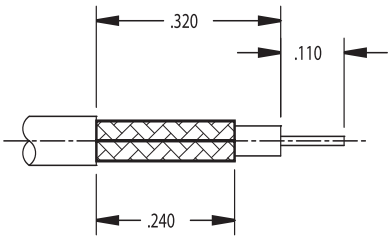
2. SLIDE CLAMP NUT OVER CABLE. INSERT CABLE INTO SLEEVE DIELECTRIC MUST PASS THROUGH HOLE IN SLEEVE. CABLE JACKET MUST BUTT AGAINST SHOULDER INSIDE SLEEVE. SOLDER CABLE INTO SLEEVE. CLEAN.

3. SOLDER CONDUCTOR INTO SLOT IN CONTACT THROUGH REAR ACCESS HOLE. CLEAN.

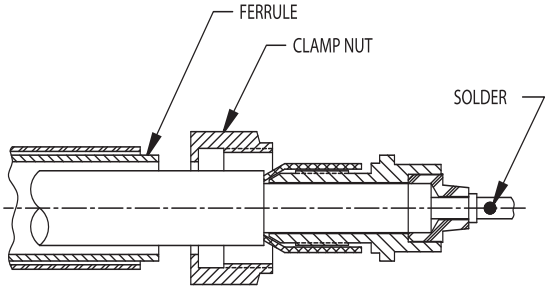


4. ASSEMBLE SLEEVE ASSEMBLY TO BODY. SLIDE CLAMP NUT FORWARD AND CLAMP SLEEVE TO BODY. TORQUE CLAMP NUT TO 8 IN.-LBS. PRESS CAP INTO BODY.

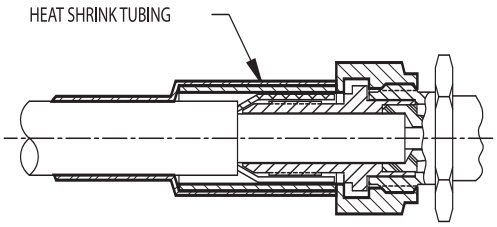
PART NUMBER			FERRULE HEX SIZE
510-800-0360	511-680-0360	511-880-0360	.105
510-800-0630	511-680-0630	511-880-0630	.128
510-800-0631	511-680-0361	511-880-0631	.151



1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR.

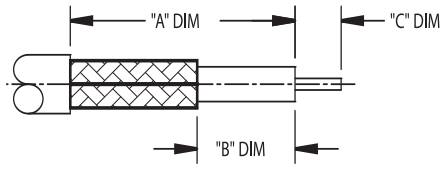


2. SLIDE SHRINK TUBING, FERRULE, AND CLAMP NUT OVER CABLE. INSERT CABLE INTO WEDGE ASSEMBLY. CENTER CONDUCTOR MUST ENTER AND PROTRUDE THROUGH HOLE IN INSULATOR. DIELECTRIC OF CABLE MUST BUTT AGAINST INSULATOR IN WEDGE. ASSEMBLE CENTER CONTACT TO WEDGE ASSEMBLY BY INSERTING CONTACT INTO HOLE IN INSULATOR. SOLDER CONTACT TO CENTER CONDUCTOR THROUGH HOLE IN CONTACT. CLEAN.

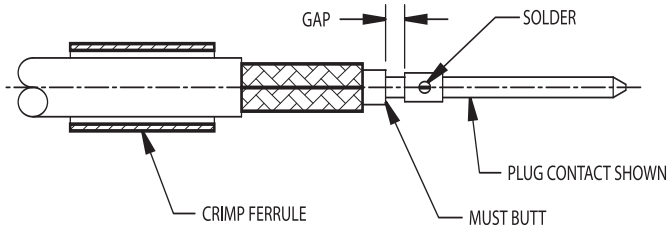


3. ASSEMBLE WEDGE ASSEMBLY TO BODY. SLIDE CLAMP NUT FORWARD AND CLAMP WEDGE TO BODY. TORQUE CLAMP NUT TP 8 IN.-LBS. SLIDE FERRULE FORWARD AND CRIMP. SLIDE SHRINK TUBING FORWARD AND HEAT SHRINK.

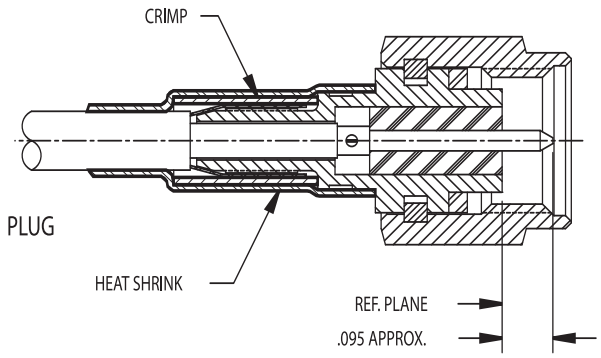
PART NUMBER		"A" DIM	"B" DIM	"C" DIM	GAP	FERRULE HEX SIZE
250-900-0630		.250	.040	.110	.000	.128
250-900-0631		.250	.040	.110	.000	.151
250-900-1160	250-900-1161	.190	.000	.100	.000	.213
251-975-0630		.380	.160	.110	.015	.128
251-975-0631		.380	.160	.110	.015	.151
251-975-1160	251-975-1161	.300	.110	.100	.000	.213
350-900-0630		.270	.060	.110	.000	.128
350-900-0631		.270	.060	.110	.000	.151
350-900-1160	350-900-1161	.218	.000	.090	.000	.213
351-900-0630		.320	.110	.110	.019	.128
351-900-0631		.320	.110	.110	.019	.151
351-900-1160	351-900-1161	.302	.092	.125	.000	.213
351-975-0630		.270	.000	.140	.000	.128
351-975-0631		.270	.000	.140	.000	.151
351-975-1160	351-975-1161	.300	.110	.100	.000	.213



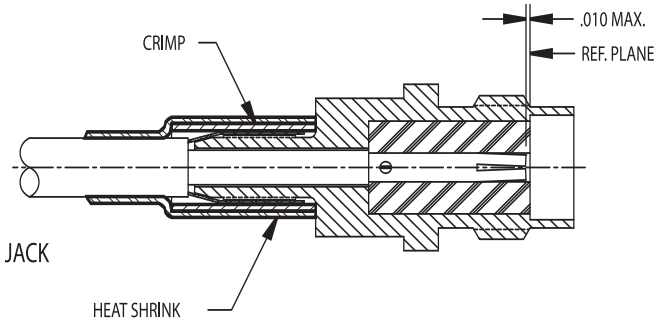
1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR.



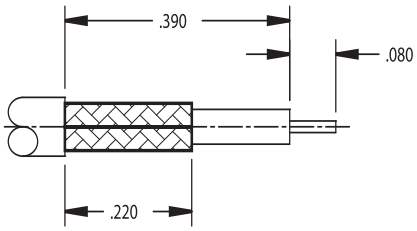
2. SLIDE FERRULE OVER CABLE. SOLDER CENTER CONTACT TO CENTER CONDUCTOR THROUGH HOLE IN CONTACT. CONTACT MUST BUTT AGAINST DIELECTRIC. CLEAN.



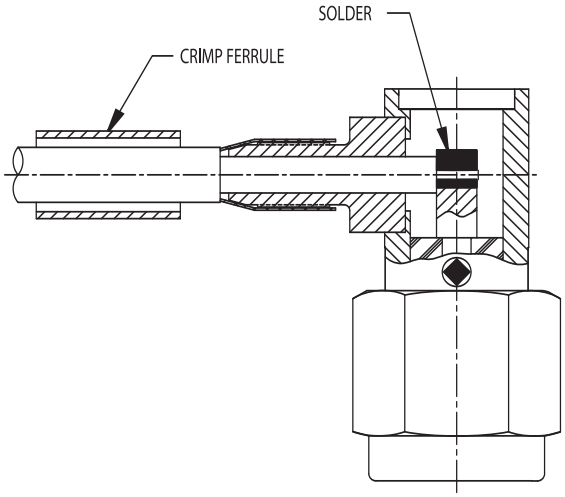
3. SLIDE FERRULE FORWARD OVER BRAID AND CRIMP. SHRINK SLEEVING OVER FERRULE AND CABLE.



PART NUMBER		FIG.	FERRULE HEX SIZE
252-900-0630		3B	.128
252-900-0631		3B	.151
252-900-1160	252-900-1161	3B	.213
352-900-0630		3A	.128
352-900-0631		3A	.151
352-900-1160	352-900-1161	3A	.213



1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR.



2. SLIDE FERRULE OVER CABLE. INSERT CABLE INTO WEDGE. CENTER CONDUCTOR MUST ENTER SLOT IN CENTER CONTACT. DIELECTRIC OF CABLE MUST BUTT AGAINST CONTACT. SOLDER CENTER CONDUCTOR INTO SLOT IN CONTACT. CLEAN.

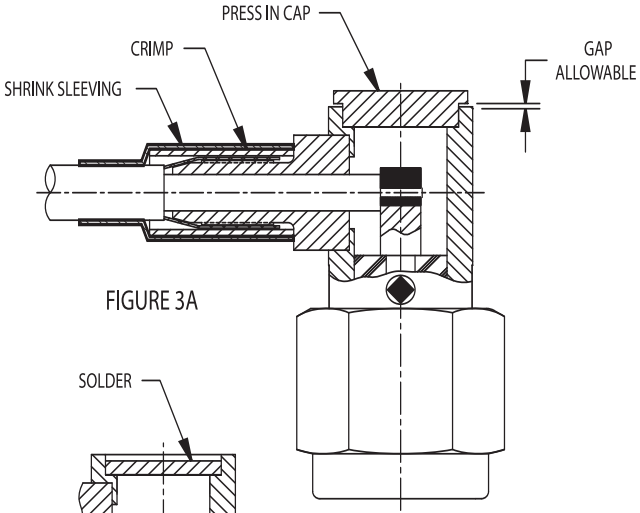


FIGURE 3A

3. SLIDE FERRULE FORWARD AND CRIMP. PRESS OR SOLDER CAP INTO BODY PER FIG. 1 OR 2.
NOTE: WHEN PRESSING IN CAP, DO NOT SEAT ON COUPLING NUT.

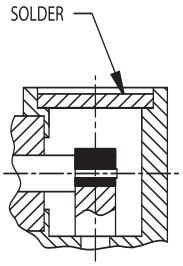
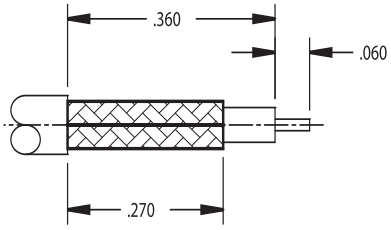


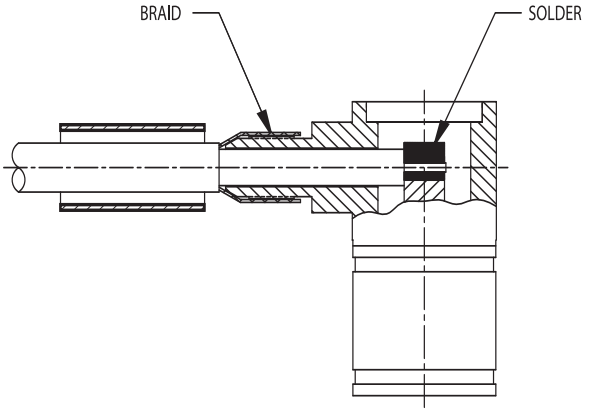
FIGURE 3B

4. SHRINK SLEEVING OVER FERRULE AND CABLE AS SHOWN.

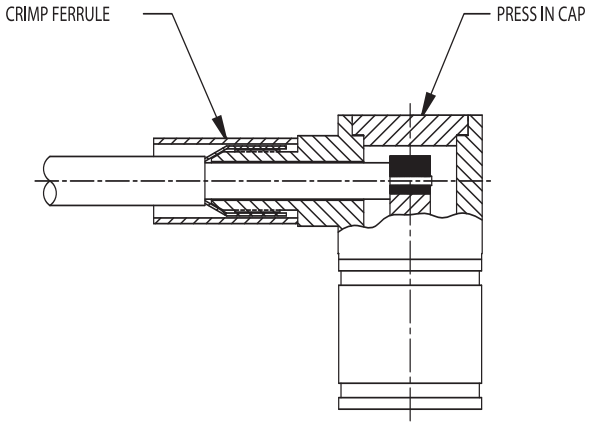
PART NUMBER	FERRULE HEX SIZE
512-900-0360	.105
512-900-0630	.128
512-900-0631	.151



1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK CENTER CONDUCTOR.

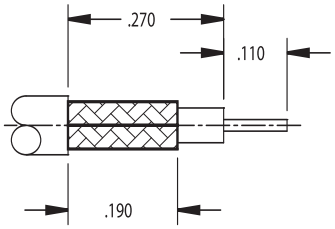


2. SLIDE FERRULE OVER CABLE. INSERT CABLE INTO WEDGE. CENTER CONDUCTOR MUST ENTER SLOT IN CENTER CONTACT. DIELECTRIC OF CABLE MUST BUTT AGAINST CONTACT. SOLDER CENTER CONDUCTOR INTO SLOT IN CONTACT. CLEAN.

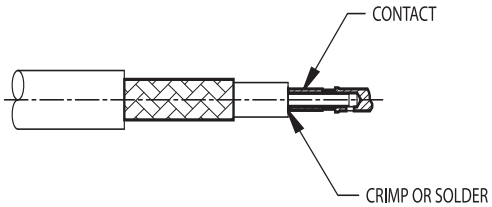


3. SLIDE FERRULE FORWARD AND CRIMP. PRESS CAP INTO BODY.

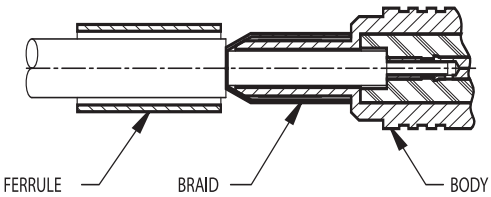
PART NUMBER	CRIMP TOOL (CENTER CONTACT)	POSITIONER	TOOL SETTING
450-900-SERIES	T 2400	P 0632	4
451-980-SERIES			



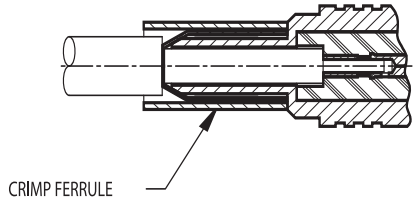
1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK BRAIDS OR CENTER CONDUCTOR.



2. SLIDE FERRULE OVER BRAID. PLACE CENTER CONTACT INTO POSITIONER OF CRIMP TOOL (SEE TABLE FOR POSITIONER AND SETTING). INSERT CABLE CENTER CONDUCTOR INTO AND CRIMP. DIELECTRIC OF CABLE MUST BUTT AGAINST SHOULDER OF CONTACT.
(NOTE: CENTER CONTACT MAY BE SOLDERED TO CENTER CONDUCTOR).

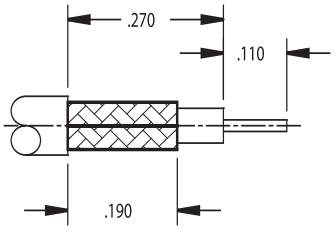


3. FLAIR BRAID. INSERT CENTER CONTACT INTO BODY UNTIL IT SNAPS INTO INSULATOR. BRAID WILL SIT OVER BARREL PORTION OF BODY.

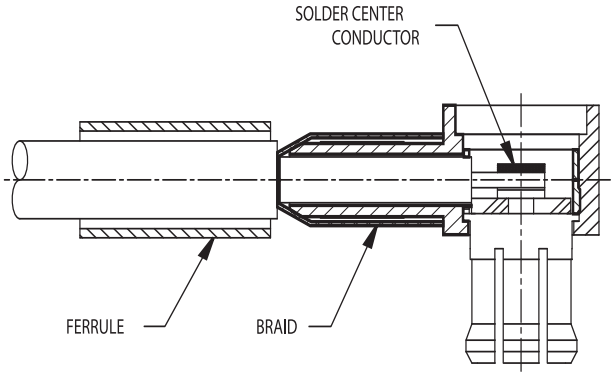


4. SLIDE FERRULE FORWARD OVER BRAID AND CRIMP WITH APPROPRIATE HEX CRIMP DIE.

PART NUMBER	FERRULE HEX SIZE
452-900-0360	.105
452-900-0630	.128
452-900-0631	.151

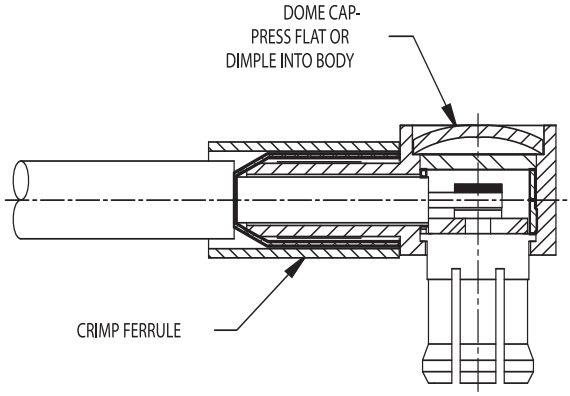


1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK BRAIDS OR CENTER CONDUCTOR.



2. SLIDE FERRULE OVER BRAID. FLAIR BRAID AND INSERT INTO BODY. CENTER CONDUCTOR MUST ENTER SLOT IN CONTACT. SOLDER CONTACT. CLEAN.

3. SLIDE FERRULE FORWARD OVER BRAID AND CRIMP WITH APPROPRIATE HEX CRIMP DIE.



4. PLACE INSULATOR INTO ACCESS HOLE OVER CENTER CONTACT.

PART NUMBER			DIM A	DIM B	DIM C	HEX SIZE
360-900-0630	360-974-0630	361-900-0630	.200 [5.1]	.220 [5.6]	.100 [2.5]	.128 [3.25]
361-922-0630			.200 [5.1]	.220 [5.6]	.100 [2.5]	.128 [3.25]

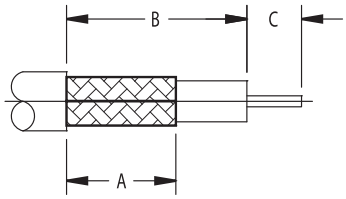


FIGURE 1

1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK BRAID OR CENTER CONDUCTOR. (SEE FIG. 1)

2. SLIDE CENTER CONDUCTOR OF CABLE INTO REAR CONTACT. SET GAP BETWEEN CONTACT AND DIELECTRIC OF CABLE. SOLDER. CLEAN. (SEE FIG. 2)

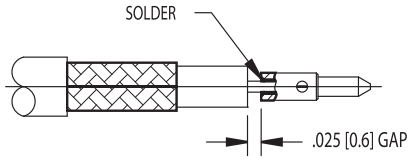


FIGURE 2

3. SLIDE FERRULE ONTO CABLE. FLAIR BRAID. INSERT CABLE INTO BODY, ALLOWING BRAID TO SLIDE OVER OUTSIDE OF BODY. INSERT CABLE UNTIL DIELECTRIC BUTTS AGAINST INSULATOR INSIDE BODY. REAR CONTACT MUST ENGAGE WITH FRONT CONTACT INSIDE BODY. (SEE FIG. 3)

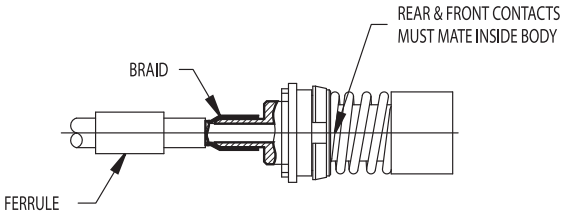


FIGURE 3

4. SLIDE FERRULE FORWARD OVER BRAID, UP TO SHOULDER AND CRIMP.

PART NUMBER	DIM A	DIM B	DIM C	HEX SIZE
362-974-0630	.200 [5.1]	.310 [7.9]	.100 [2.5]	.128 [3.25]
363-922-0630	.200 [5.1]	.330 [8.4]	.100 [2.5]	.128 [3.25]

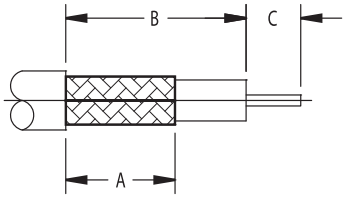


FIGURE 1

1. TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK BRAID OR CENTER CONDUCTOR. (SEE FIG. 1)

2. SLIDE FERRULE ONTO CABLE. FLAIR BRAID. INSERT CABLE INTO BODY, ALLOWING BRAID TO SLIDE OVER OUTSIDE OF BODY. CENTER CONDUCTOR MUST ENTER SLOT IN CENTER CONTACT. SOLDER CENTER CONDUCTOR TO CONTACT. CLEAN. (SEE FIG. 2)

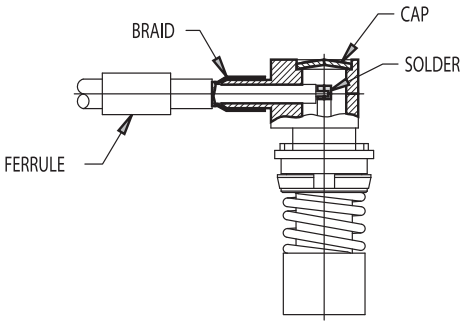
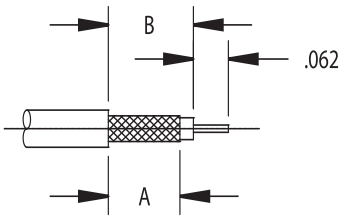


FIGURE 2

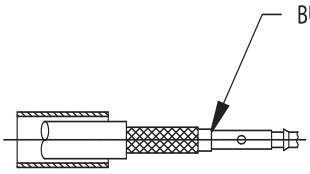
3. SLIDE FERRULE FORWARD OVER BRAID, UP TO SHOULDER AND CRIMP.

4. PLACE CAP INTO BODY AS SHOWN AND DEPRESS CAP TO EXPAND INSIDE COUNTERBORE OF BODY. (SEE FIG. 2)

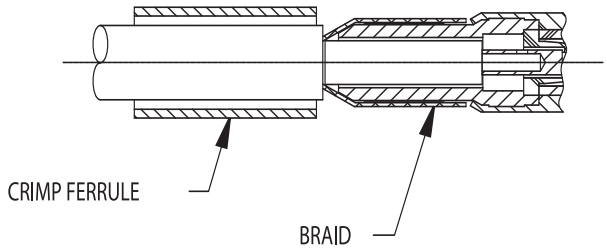
PART NUMBER		A	B	FERRULE HEX SIZE
470-900-0360	471-900-0360	.190	.225	.105
470-900-0630	471-900-0630	.190	.225	.128



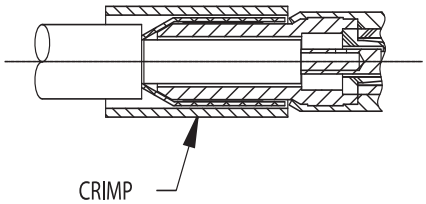
1. Trim cable to dimensions shown. Do not nick center conductor.



2. Slide ferrule over jacket. Insert center conductor of cable into contact. Dielectric of cable must butt against contact. Solder contact to center conductor. Clean.

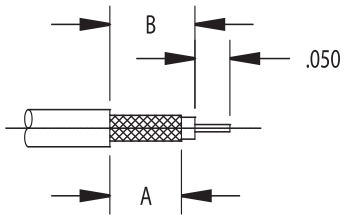


3. Flair braid. Insert center contact into body until it snaps into insulator.

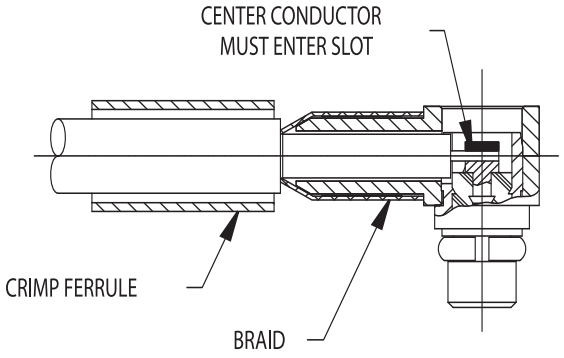


4. Slide ferrule over braid up to the shoulder of body. Crimp ferrule to retain braid. See table for hex sizes.

PART NUMBER	A	B	FERRULE HEX SIZE
472-900-0360	.190	.225	.105
472-900-0630	.190	.225	.128

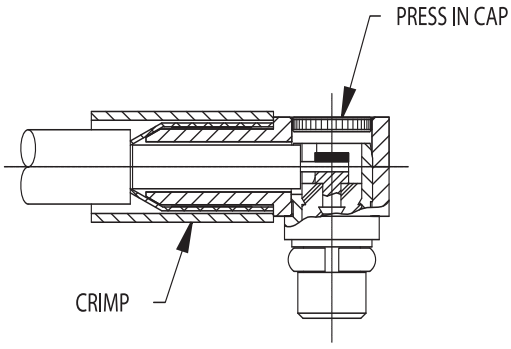


1. Trim cable to dimensions shown. Tin the center conductor.

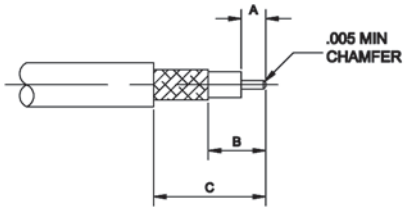


2. Slide ferrule over jacket. Flair braid. Insert cable into body. Center conductor must enter slot in contact. Solder contact. Clean.

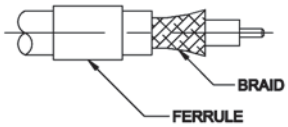
3. Slide ferrule over braid up to the shoulder of body. Crimp ferrule to retain braid. See table for hex sizes.



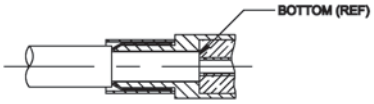
4. Press cap into body.



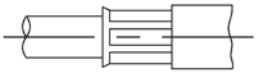
1. STRIP CABLE TO DIMENSIONS AS SHOWN.



2. SLIDE FERRULE OVER JACKET. FLARE BRAID.



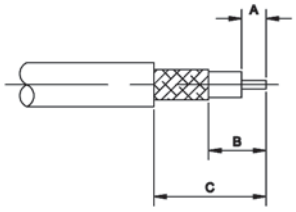
3. SLIDE CABLE INTO BODY, CENTER CONDUCTOR TO ENTER PREASSEMBLED SOCKET CONTACT, UNTIL CABLE DIELECTRIC BOTTOMS AGAINST INSULATOR. SLIDE FERRULE OVER BRAID UP TO THE SHOULDER OF BODY.



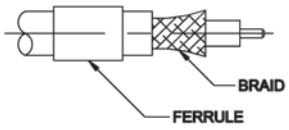
4. CRIMP THE FERRULE WITH HEX DIE.

STRIP AND HEX DIE CHART:

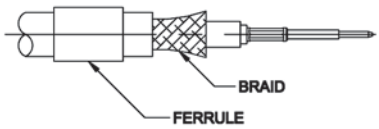
PART NUMBER	A	B	C	HEX DIE
0345-E00-28C01	.155	.312	.624	.192
0345-E00-C7201				.178



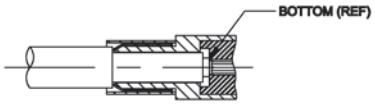
1. STRIP CABLE TO DIMENSIONS AS SHOWN.



2. SLIDE FERRULE OVER JACKET. FLARE BRAID.



3. CRIMP (OR SOLDER) CONTACT TO CABLE USING A .042" HEX DIE.

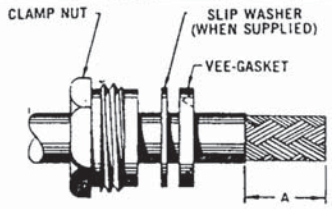


4. SLIDE CABLE INTO BODY UNTIL CABLE DIELECTRIC BOTTOMS AGAINST INSULATOR. SLIDE FERRULE OVER BRAID UP TO THE SHOULDER OF BODY.

5. CRIMP THE FERRULE WITH HEX DIE.

STRIP AND HEX DIE CHART:

PART NUMBER	A	B	C	HEX DIE
0345-E00-C7202	.150	.327	.625	.042
				.178

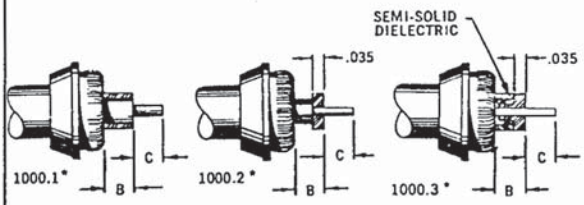


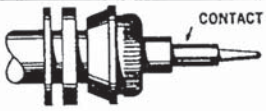
1. Cut cable end square, place clamp-nut, slip washer (when supplied), and gasket over jacket. Remove jacket to dimension "A."

2. Comb out braid and taper forward. Place braid clamp over braid against jacket cut.

3. Fold braid back over braid clamp and trim as shown above. Remove dielectric to dimension "B." Cut center conductor to dimension "C."

When cable positioning insulators are used adjust trim code dimensions as shown below, and assemble as indicated.

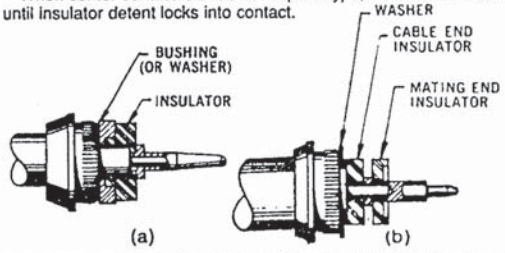


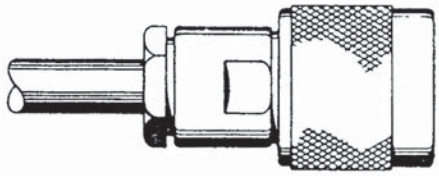


4. Solder contact to center conductor. For access type angle connectors, omit this step and proceed to step 5.

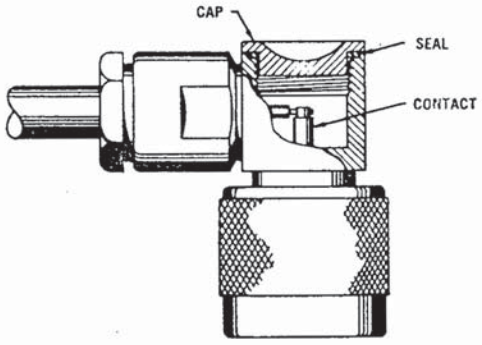
For captive contacts: (a) assemble bushing and insulator, attach contact, or (b) assemble washer and larger (cable end) insulator. Attach contact. Assemble smaller (mating end) insulator.

When center contact is undercut captive type, insert cable assembly until insulator detent locks into contact.



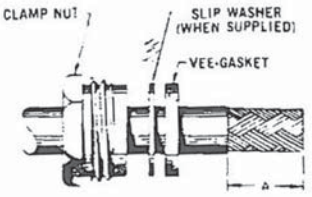


5. Thread assembly into connector, and lock securely. Vee gasket must be split by braid clamp.



6. For access type angle connectors, solder center conductor in contact groove. Close access opening.

TRIM CODE CHART			
CODE	A	B	C
1001	11/16	.440	7/64
1002	23/32	.470	7/64
1003	11/16	.420	1/8
1004	11/32	.106	7/64
1005	11/32	.040	5/32
1008	3/8	.180	1/16
1012	13/32	.128	5/32
1013	7/16	.170	5/32
1014	7/16	.118	7/32
1015	3/8	.118	5/32
1016	3/8	.046	7/32
1017	13/32	.074	3/16
1018	31/64	.065	7/32
1019	5/8	.371	5/32
1021	3/8	.096	5/32
1022	5/16	.046	5/32
1024	3/8	.046	3/16
1025	13/32	.216	3/32
1030	1/4	.045	3/32
1031	5/8	.296	7/32
1033	19/32	.327	5/32
1042	5/16	.070	1/8
1044	5/16	.105	9/64
1050	19/64	.109	7/64

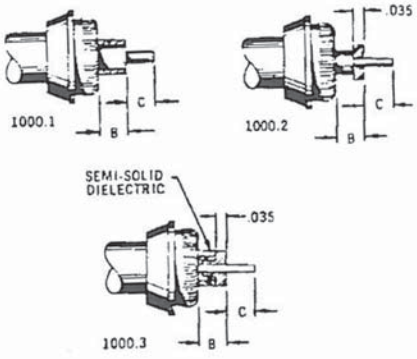


1. Cut cable end square, place clamp-nut, slip washer (when supplied), and gasket over jacket. Remove jacket to dimension "A."

2. Comb out braid and taper forward. Place braid clamp over braid against jacket cut.

3. Fold braid back over braid clamp and trim as shown above. Remove dielectric to dimension "B." Cut center conductor to dimension "C."

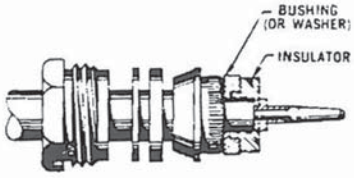
When cable positioning insulators are used adjust trim code dimensions as shown below, and assemble as indicated.

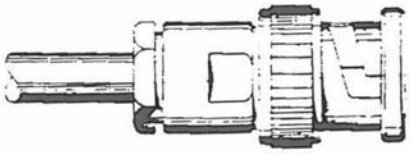


4. Solder or crimp contact to center conductor.

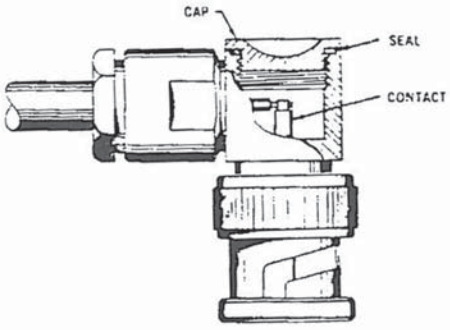
For access type angle connectors, omit this step and proceed to step 5.

For captive contacts, assemble contact capturing parts on cable before attaching contact as shown below.





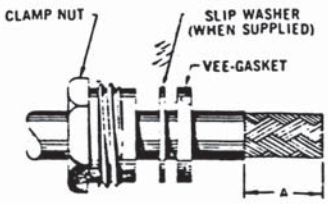
5. Thread assembly into connector, and lock securely. Vee gasket must be split by braid clamp.



6. For access type angle connectors, solder center conductor in contact groove. Close access opening.

TRIM CODE CHART

CODE	A	B	C
1006	3/4	.531	7/64

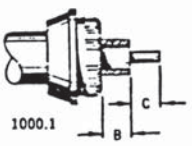


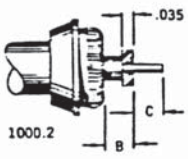
1. Cut cable end square, place clamp-nut, slip washer (when supplied), and gasket over jacket. Remove jacket to dimension "A."

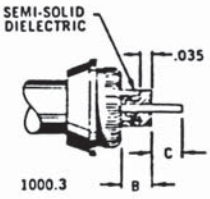
2. Comb out braid and taper forward. Place braid clamp over braid against jacket cut.

3. Fold braid back over braid clamp and trim as shown above. Remove dielectric to dimension "B." Cut center conductor to dimension "C."

When cable positioning insulators are used adjust trim code dimensions as shown below, and assemble as indicated.



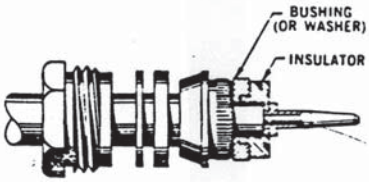


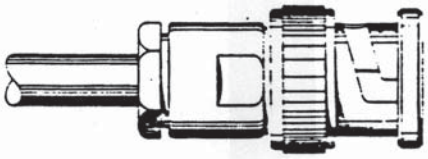


4. Solder or crimp contact to center conductor.

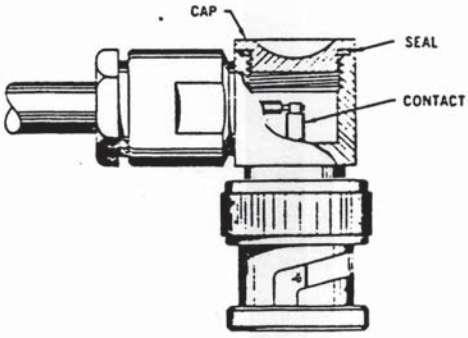
For access type angle connectors, omit this step and proceed to step 5.

For captive contacts, assemble contact capturing parts on cable before attaching contact as shown below.



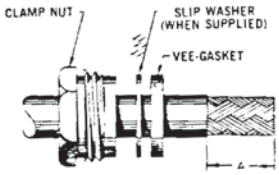


5. Thread assembly into connector, and lock securely. Vee gasket must be split by braid clamp.



6. For access type angle connectors, solder center conductor in contact groove. Close access opening.

TRIM CODE CHART			
CODE	A	B	C
1040	3/8	.070	5/32

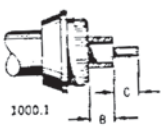


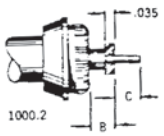
1. Cut cable end square, place clamp-nut, slip washer (when supplied), and gasket over jacket. Remove jacket to dimension "A."

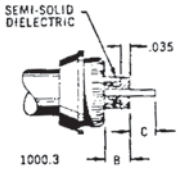
2. Comb out braid and taper forward. Place braid clamp over braid against jacket cut.

3. Fold braid back over braid clamp and trim as shown above. Remove dielectric to dimension "B." Cut center conductor to dimension "C."

When cable positioning insulators are used adjust trim code dimensions as shown below, and assemble as indicated.



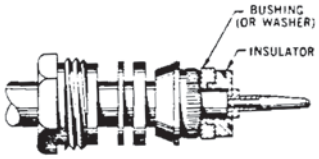


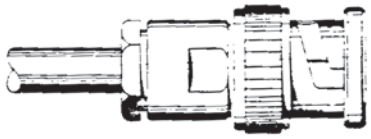


4. Solder or crimp contact to center conductor.

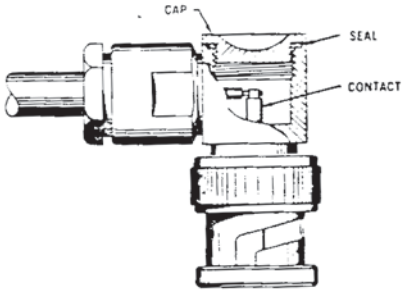
For access type angle connectors, omit this step and proceed to step 5.

For captive contacts, assemble contact capturing parts on cable before attaching contact as shown below.





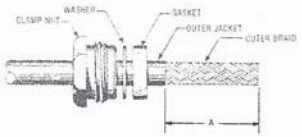
5. Thread assembly into connector, and lock securely. Vee gasket must be split by braid clamp.



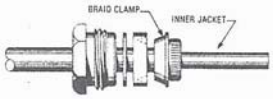
6. For access type angle connectors, solder center conductor in contact groove. Close access opening.

TRIM CODE CHART

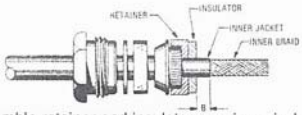
CODE	A	B	C
1052	1/2	.140	7/32



1. Cut cable end square. Slide clamp nut, washer and gasket over jacket. Remove outer jacket to dimension "A."

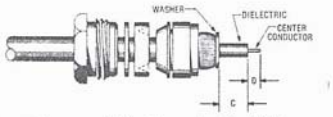


2. Place braid clamp over outer braid and against jacket cut. Comb out braid and fold back over braid clamp. Trim as shown.



3. Assemble retainer and insulator over inner jacket. Remove inner jacket to dimension "B."

4. Place braid clamp over inner braid and against inner jacket cut. Comb out braid and fold back over braid clamp. Trim even with base of braid clamp.

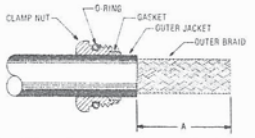


5. Place washer over dielectric against braid. Trim dielectric to dimension "C" and center conductor to dimension "D."

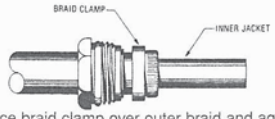
6. Solder center contact to center conductor.

7. Assemble inner insulator, contact and outer insulator, then insert into body. Slide back end parts forward. Thread assembly into connector body and lock securely.

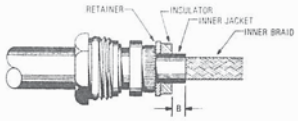
TRIM CODE CHART				
CODE	A	B	C	D
1301	.69	.096	.210	.094
1302	.69	.125	.214	.080
1303	.69	.096	.166	.141



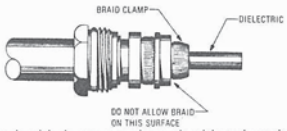
1. Cut cable end square. Assemble O-ring. Slide clamp nut and gasket over jacket. Remove outer jacket to dimension "A."



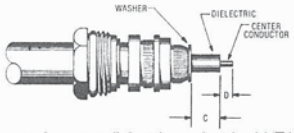
2. Place braid clamp over outer braid and against jacket cut. Comb out braid and fold back over braid clamp. Trim as shown.



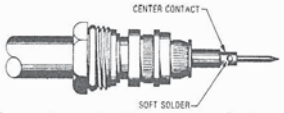
3. Assemble retainer and insulator over inner jacket. Remove inner jacket to dimension "B."



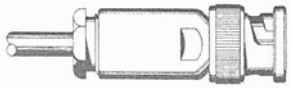
4. Place braid clamp over inner braid and against inner jacket cut. Comb out braid and fold back over braid clamp. Trim even with base of braid clamp.



5. Place washer over dielectric against braid. Trim dielectric to dimension "C" and center conductor to dimension "D."

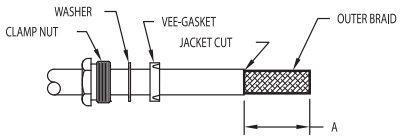


6. Solder center contact to center conductor.



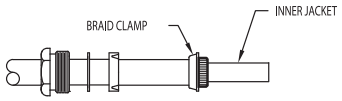
7. Assemble inner insulator, contact and outer insulator, then insert into body. Slide back end parts forward. Thread assembly into connector body and lock securely.

TRIM CODE CHART				
CODE	A	B	C	D
1301A	11/16	.096	.210	3/32

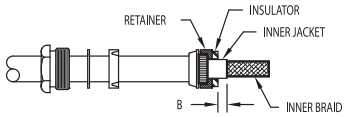


TRIM CODE CHART			
A	B	C	D
.69	.096	.102	.094

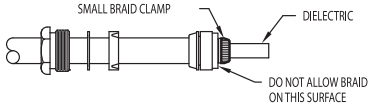
1. CUT CABLE END SQUARE, SLIDE CLAMP NUT, WASHER AND VEE-GASKET OVER JACKET. REMOVE OUTER JACKET TO DIMENSION "A".



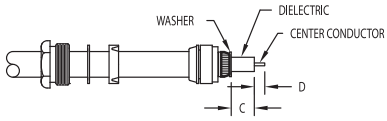
2. PLACE BRAID CLAMP OVER OUTER BRAID AND AGAINST JACKET CUT. COMB OUT BRAID AND FOLD BACK OVER BRAID CLAMP. TRIM AS SHOWN.



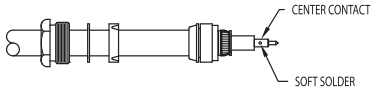
3. ASSEMBLE RETAINER AND INSULATOR OVER INNER JACKET. REMOVE INNER JACKET TO DIMENSION "B".



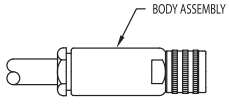
4. PLACE SMALL BRAID CLAMP OVER INNER BRAID AND AGAINST INNER JACKET CUT. COMB OUT BRAID AND FOLD BACK OVER SMALL CLAMP. TRIM EVEN WITH BASE OF BRAID CLAMP.



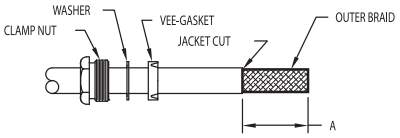
5. PLACE WASHER OVER DIELECTRIC AND AGAINST BRAID. TRIM DIELECTRIC TO DIMENSION "C" AND CENTER CONDUCTOR TO DIMENSION "D".



6. SOLDER CENTER CONTACT TO CENTER CONDUCTOR.

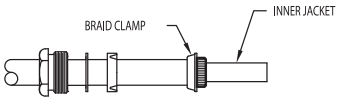


7. SLIDE BACK END PARTS FORWARD. ASSEMBLE INNER INSULATOR, INTERMEDIATE CONTACT AND OUTER INSULATOR. THREAD INTO CONNECTOR BODY AND TORQUE TO 30-35 IN.LBS.

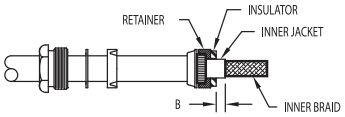


TRIM CODE CHART			
A	B	C	D
.69	.096	.243	.110

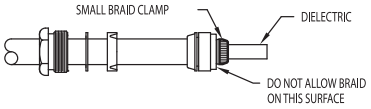
1. CUT CABLE END SQUARE, SLIDE CLAMP NUT, WASHER AND VEE-GASKET OVER JACKET. REMOVE OUTER JACKET TO DIMENSION "A".



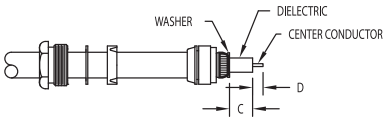
2. PLACE BRAID CLAMP OVER OUTER BRAID AND AGAINST JACKET CUT. COMB OUT BRAID AND FOLD BACK OVER BRAID CLAMP. TRIM AS SHOWN.



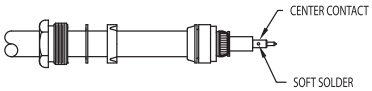
3. ASSEMBLE RETAINER AND INSULATOR OVER INNER JACKET. REMOVE INNER JACKET TO DIMENSION "B".



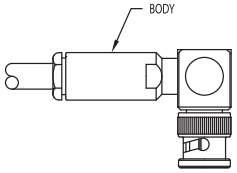
4. PLACE SMALL BRAID CLAMP OVER INNER BRAID AND AGAINST INNER JACKET CUT. COMB OUT BRAID AND FOLD BACK OVER SMALL CLAMP. TRIM EVEN WITH BASE OF BRAID CLAMP.



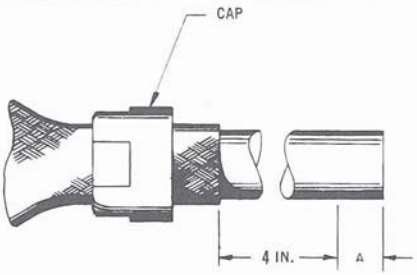
5. PLACE WASHER OVER DIELECTRIC AND AGAINST BRAID. TRIM DIELECTRIC TO DIMENSION "C" AND CENTER CONDUCTOR TO DIMENSION "D".



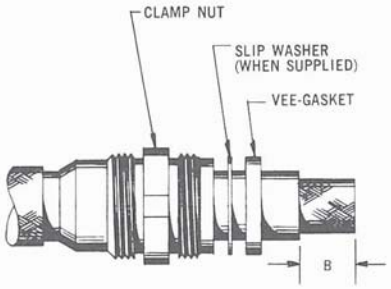
6. SOLDER CENTER CONTACT TO CENTER CONDUCTOR.



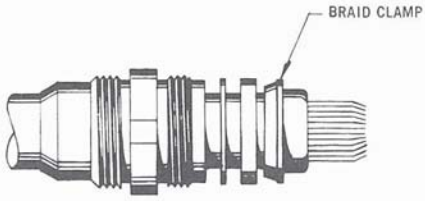
7. SLIDE BACK END PARTS FORWARD THREAD ASSEMBLY INTO CONNECTOR BODY AND TORQUE TO 35 IN LBS.



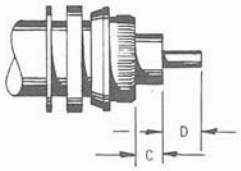
1. Cut cable end square. Slide cap over armor braid. Remove armor to dimension "A" and bulge back approximately 4".



2. Place clamp-nut, slip washer (when supplied), and gasket over jacket. Remove jacket to dimension "B."

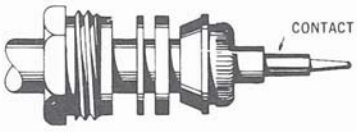


3. Comb out braid and taper forward. Place braid clamp over braid against jacket cut.

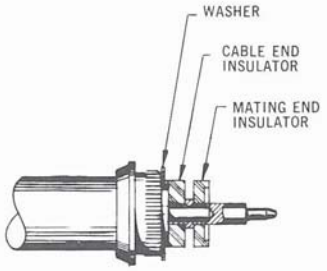


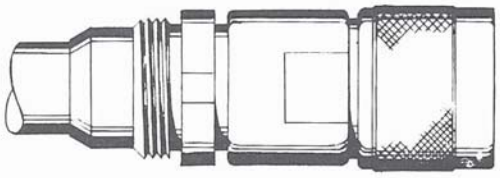
4. Fold braid back over braid clamp and trim as shown above. Remove dielectric to dimension "C." Cut center conductor to dimension "D."

TRIM CODE CHART				
CODE	A	B	C	D
1601	1-5/32	3/8	.046	3/16
1606	1-1/8	9/32	.040	1/8
1607	1-3/32	1/4	.040	3/32
1608	1-5/32	3/8	.046	7/32

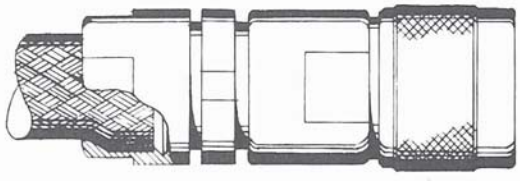


5. Solder contact to center conductor. For captive contacts, assemble contact capturing parts on cable before attaching contact as shown below.

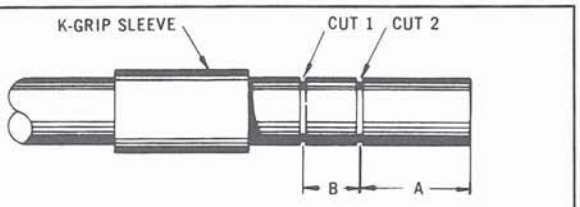




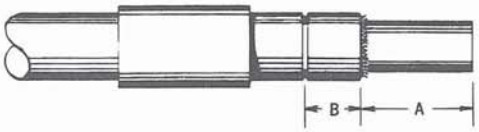
6. Thread assembly into connector, and lock securely. Vee gasket must be split by braid clamp.



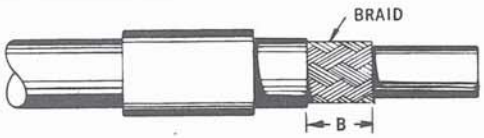
7. Slide armor braid forward over tapered end of nut, and trim as shown. Tighten cap securely with wrench.



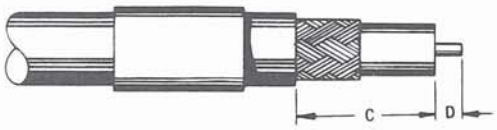
1. Cut cable end square, slide K-GRIP sleeve over jacket and make cuts 1 and 2 in jacket.



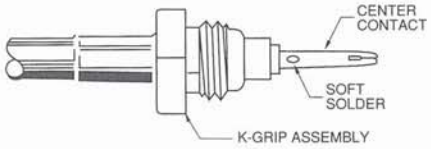
2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.



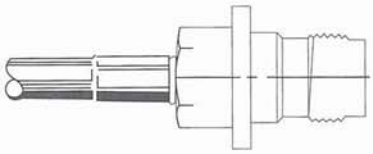
3. Remove jacket to dimension "B."



4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

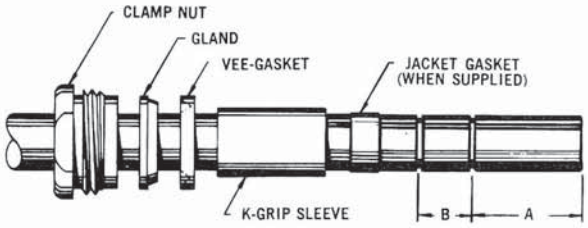


5. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. Slide K-GRIP sleeve against shoulder on body and form hex. Soft solder contact as shown.



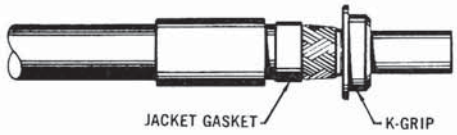
6. Thread assembly into connector, and lock securely.

TRIM CODE CHART				
CODE	A	B	C	D
432	17/64	7/32	.390	3/32
439	7/32	7/32	.345	3/32
493	1/4	9/32	.390	.140
1901	.510	.220	.450	.280

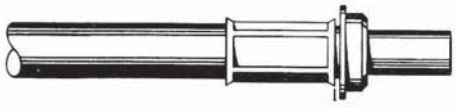


1. Cut cable end square, slide K-GRIP sleeve and back end parts over jacket. Make cuts A and B in jacket.

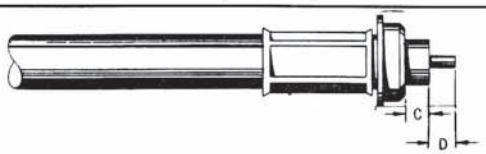
2. Remove jacket to dimension "A." Flare or bulge back braid. Trim with scissors at edge of jacket.



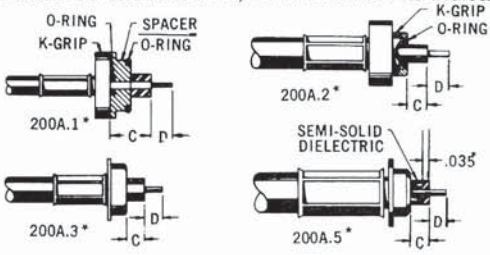
3. Remove jacket to dimension "B." Push K-GRIP over dielectric and under braid. Slide jacket gasket, when provided, forward to position flush with jacket edge. (When the "B" dimension in the trim code is 0, push the K-GRIP under both braid and jacket, butting braid against flange of K-GRIP. Teflon jackets may be slit axially ¼" in the two places to facilitate entry of the K-GRIP.



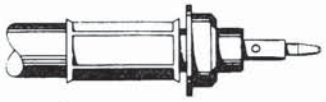
4. Slide K-GRIP sleeve against flange on K-GRIP Form hex.



5. Trim dielectric to dimension "C." Cut center conductor to dimension "D." Assemble internal O-ring seals and spacer, when provided, as shown below. When cable positioning insulators are used, adjust trim code dimensions as shown below, and assemble as indicated.

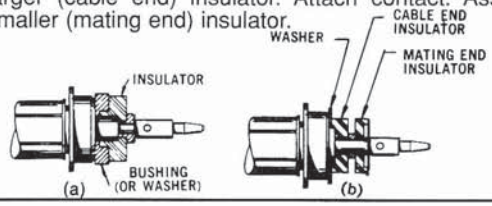


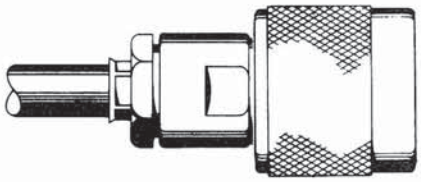
*Use appropriate dimensions from trim code chart at right.



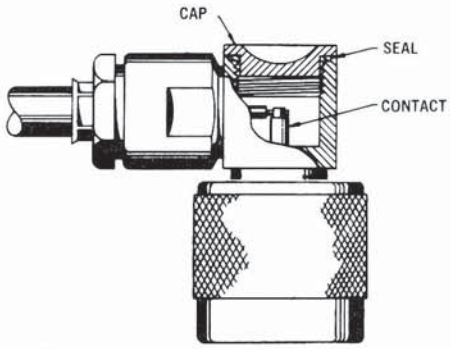
6. Solder or crimp contact to center conductor. For access type angle connectors, omit this step and proceed to step 7.

For captive contacts: (a) assemble bushing and insulator. Attach contact or (b) assemble washer and larger (cable end) insulator. Attach contact. Assemble smaller (mating end) insulator.





7. Thread assembly into connector and lock securely. Vee gasket must be split by braid clamp.



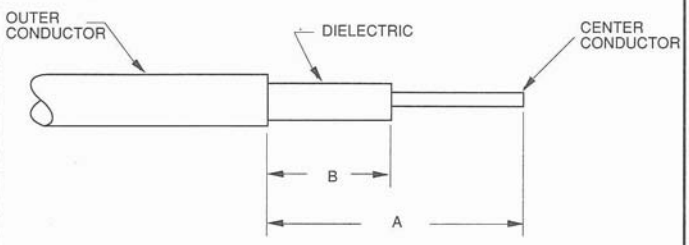
8. For access type angle connectors, solder center conductor in contact groove. Close access opening.

TRIM CODE CHART

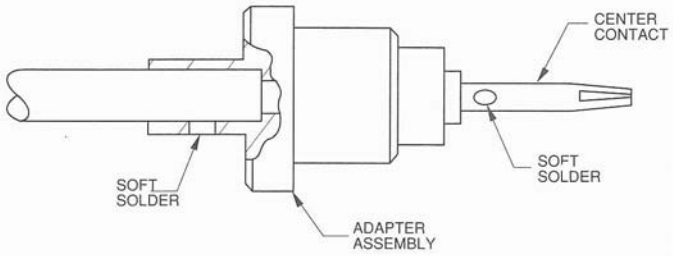
CODE	A	B	C	D
201A	1/2	7/32	.110	7/64
204A	5/8	7/32	.118	7/32
207A	9/16	7/32	.118	5/32
208A	29/32	7/32	.298	7/32
209A	19/32	7/32	.043	5/32
211A	35/64	7/32	.045	7/64
225A	3/8	0	.106	7/64
226A	9/16	3/16	.111	7/64
227A	45/64	3/16	.170	3/32
228A	37/64	3/16	.244	7/64
230A	19/32	7/32	.043	3/16
243A	9/32	0	.053	5/64

1. Cut cable end square and slide clamp nut onto outer conductor.

2. Remove outer conductor to dimension "A" and dielectric to dimension "B."

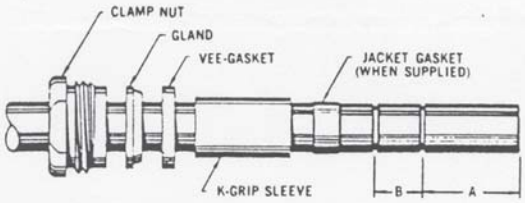


3. Insert cable into adapter assembly until bottomed. Soft solder outer conductor then center conductor as shown.



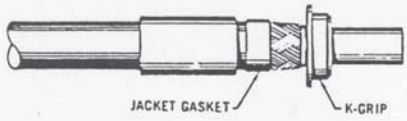
4. With connector body assembly mounted on bulkhead, insert cable assembly and lock securely with clamp nut.

TRIM CODE CHART		
CODE	A	B
2101	3/8	.125

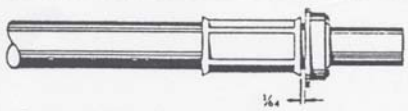


1. Cut cable end square, slide K-GRIP sleeve and back end parts over jacket. Using jacket trim jig, make cuts A and B in jacket.

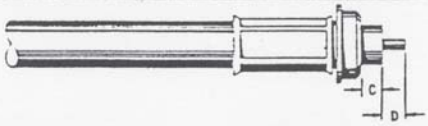
2. Remove jacket to dimension "A." Flare or bulge back braid. Trim with scissors at edge of jacket.



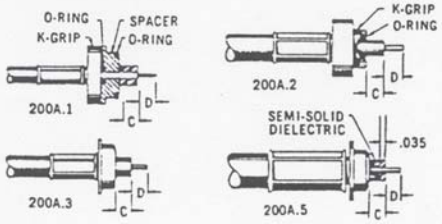
3. Remove jacket to dimension "B." Push K-GRIP over dielectric and under braid. Slide jacket gasket, when provided, forward to position flush with jacket edge. (When the "B" dimension in the trim code is 0, push the K-GRIP under both braid and jacket, butting braid against flange of K-GRIP. Teflon jackets may be slit axially ¼" in the two places to facilitate entry of the K-GRIP.)

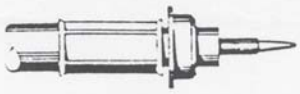


4. Slide K-GRIP sleeve against flange on K-GRIP. Form hex.



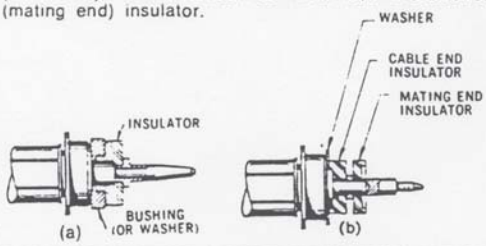
5. With dielectric trim jig, trim dielectric to dimension "C." Cut center conductor to dimension "D." Assemble internal O-ring seals and spacer, when provided, as shown below. When cable positioning insulators are used, adjust trim code dimensions as shown below, and assemble as indicated.

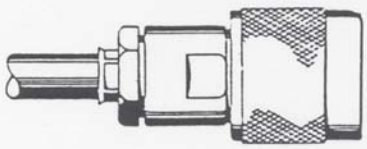




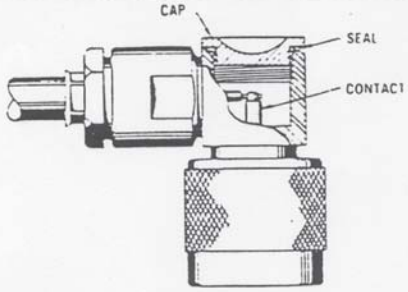
6. Solder or crimp contact to center conductor. For access type angle connectors, omit this step and proceed to step 7.

For captive contacts: (a) assemble bushing and insulator. Attach contact or (b) assemble washer and larger (cable end) insulator. Attach contact. Assemble smaller (mating end) insulator.





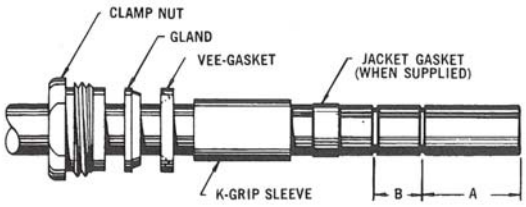
7. Thread assembly into connector and lock securely. Vee gasket must be split by braid clamp.



8. For access type angle connectors, solder center conductor in contact groove. Close access opening.

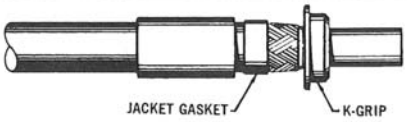
TRIM CODE CHART

CODE	A	B	C	D
213A	21/32	7/32	.041	7/32

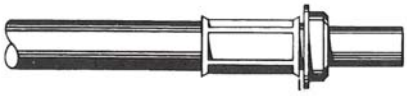


1. Cut cable end square, slide K-GRIP sleeve and back end parts over jacket. Make cuts A and B in jacket.

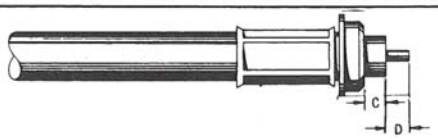
2. Remove jacket to dimension "A." Flare or bulge back braid. Trim with scissors at edge of jacket.



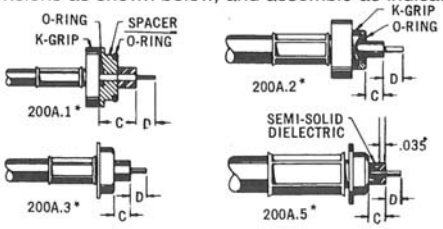
3. Remove jacket to dimension "B." Push K-GRIP over dielectric and under braid. Slide jacket gasket, when provided, forward to position flush with jacket edge. (When the "B" dimension in the trim code is 0, push the K-GRIP under both braid and jacket, butting braid against flange of K-GRIP. Teflon jackets may be slit axially ¼" in the two places to facilitate entry of the K-GRIP.



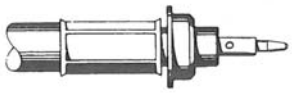
4. Slide K-GRIP sleeve against flange on K-GRIP Form hex.



5. Trim dielectric to dimension "C." Cut center conductor to dimension "D." Assemble internal O-ring seals and spacer, when provided, as shown below. When cable positioning insulators are used, adjust trim code dimensions as shown below, and assemble as indicated.

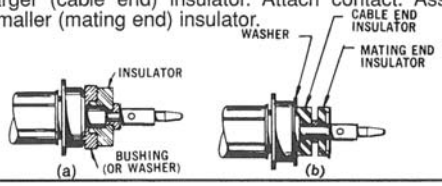


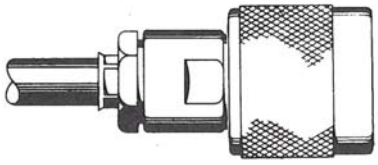
*Use appropriate dimensions from trim code chart at right.



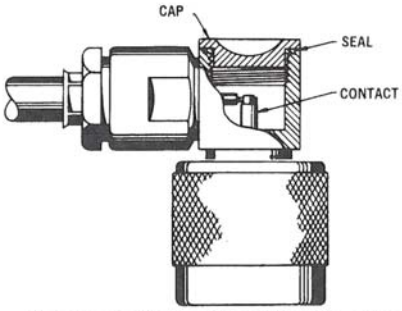
6. Solder or crimp contact to center conductor. For access type angle connectors, omit this step and proceed to step 7.

For captive contacts: (a) assemble bushing and insulator. Attach contact or (b) assemble washer and larger (cable end) insulator. Attach contact. Assemble smaller (mating end) insulator.





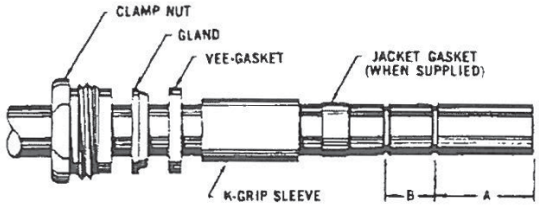
7. Thread assembly into connector and lock securely. Vee gasket must be split by braid clamp.



8. For access type angle connectors, solder center conductor in contact groove. Close access opening.

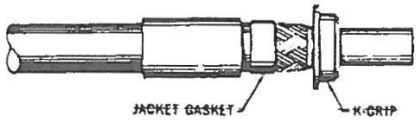
TRIM CODE CHART

CODE	A	B	C	D
201A	1/2	7/32	.110	7/64
204A	5/8	7/32	.118	7/32
207A	9/16	7/32	.118	5/32
208A	29/32	7/32	.298	7/32
209A	19/32	7/32	.043	5/32
211A	35/64	7/32	.045	7/64
225A	3/8	0	.106	7/64
226A	9/16	3/16	.111	7/64
227A	45/64	3/16	.170	3/32
228A	37/64	3/16	.244	7/64
230A	19/32	7/32	.043	3/16
243A	9/32	0	.053	5/64

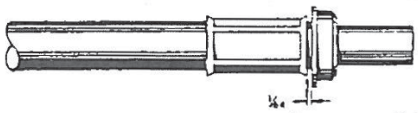


1. Cut cable end square, slide K-GRIP sleeve and back end parts over jacket. Using jacket trim jig, make cuts A and B in jacket.

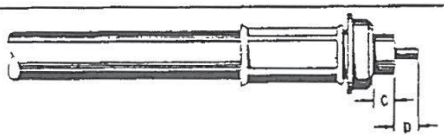
2. Remove jacket to dimension "A." Flare or bulge back braid. Trim with scissors at edge of jacket.



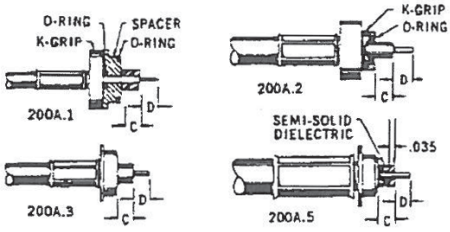
3. Remove jacket to dimension "B." Push K-GRIP over dielectric and under braid. Slide jacket gasket, when provided, forward to position flush with jacket edge. (When the "B" dimension in the trim code is 0, push the K-GRIP under both braid and jacket, butting braid against flange of K-GRIP. Teflon jackets may be slit axially ¼" in the two places to facilitate entry of the K-GRIP.)

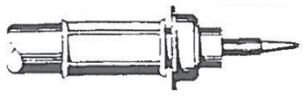


4. Slide K-GRIP sleeve against flange on K-GRIP. Form hex.



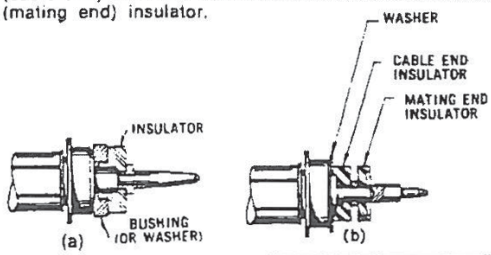
5. With dielectric trim jig, trim dielectric to dimension "C." Cut center conductor to dimension "D." Assemble internal O-ring seals and spacer, when provided, as shown below. When cable positioning insulators are used, adjust trim code dimensions as shown below, and assemble as indicated.

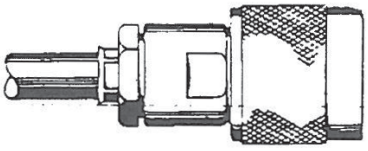




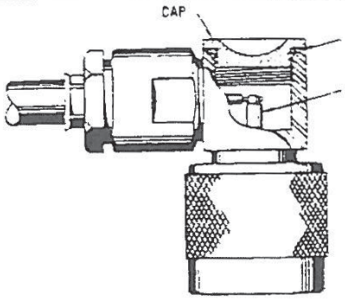
6. Solder or crimp contact to center conductor. For access type angle connectors, omit this step and proceed to step 7.

For captive contacts: (a) assemble bushing and insulator. Attach contact or (b) assemble washer and larger (cable end) insulator. Attach contact. Assemble smaller (mating end) insulator.





7. Thread assembly into connector and lock securely. Vee gasket must be split by braid clamp.



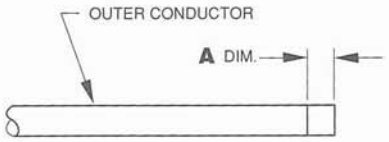
8. For access type angle connectors, solder center conductor in contact groove. Close access opening.

TRIM CODE CHART

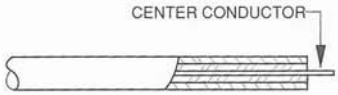
CODE	A	B	C	D
239A	29/32	7/32	.294	9/32

CP-3800

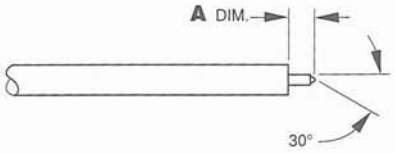
1. Trim cable using indicated trim tool.



A. Cut cable end square and score outer conductor all around to dimension indicated.



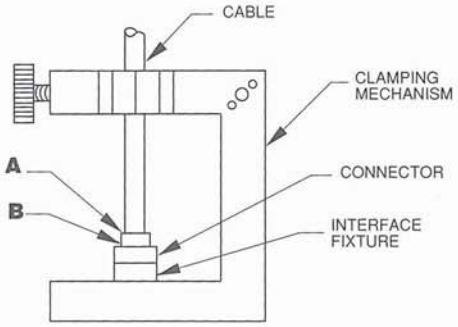
B. Remove jacket to scored mark with pliers. Then remove dielectric to front face of outer conductor making sure surface is square and free of burrs. Do not nick center conductor.



C. File end of center conductor as shown, to approximately 30°.

2. Insert trimmed end of cable into back end of connector, until cable bottoms.

3. Put an interface fixture on the mating end to prevent movement of the interface while soldering.



4. Place cable, connector and interface fixture in a non-destructive clamping mechanism.

5. Set fixture in vertical position shown.

6. Apply a small amount of liquid rosin flux to cable/connector joint (point **A**).

7. Apply heat at point **B** using resistance type heat tweezers or other similar device that will not leave burn marks or solder residue on the connector body.

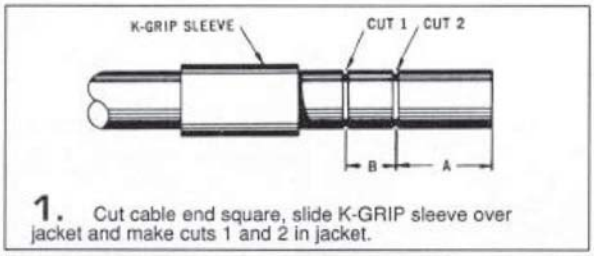
8. Apply solder at point **A**, forming a smooth continuous joint free of voids.

9. Allow to cool.

10. CLean off excess flux using alcohol or a freon based flux cleaner.

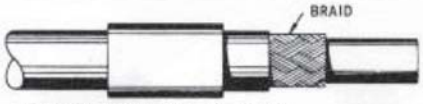
TRIM CODE CHART

CODE	A DIM.	TRIM TOOL
3800-1	.090/.080	KTO-2A
3800-2	.075/.065	KTO-3A

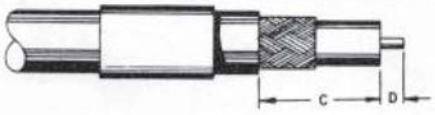


1. Cut cable end square, slide K-GRIP sleeve over jacket and make cuts 1 and 2 in jacket.

2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.



3. Remove jacket to dimension "B."

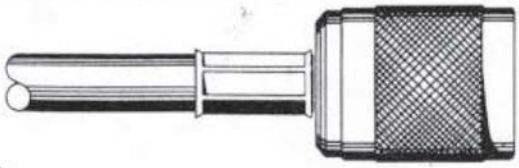


4. Trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor.

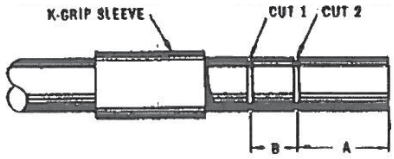
5A. For 10 & 20 KV connectors, when Cable Seal Gasket is supplied, place over center conductor and against cable dielectric. Solder contact to center conductor with gasket under compression.

6. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. When the "B" dimension in the trim code is 0, the K-GRIP Jr. is pushed under both braid and jacket. Teflon jackets may be slit axially 1/4" in two places to facilitate entry of the K-GRIP. When center contact is undercut captive type, insert cable assembly until insulator detent locks into contact.

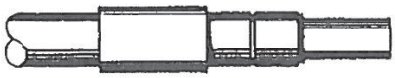


7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

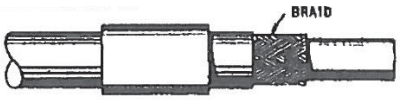
TRIM CODE CHART				
CODE	A	B	C	D
401	23/64	7/32	.468	7/64
402	11/32	7/32	.375	3/16
403	7/16	7/32	.493	5/32
405	49/64	7/32	.871	7/64
406	9/32	0	.093	3/16
407	11/16	0	.496	3/16
408	45/64	7/32	.809	7/64
409	19/64	3/16	.406	7/64
410	31/32	7/32	.562	5/8
413	21/32	7/32	.717	5/32
414	29/64	7/32	.556	7/64
415	15/32	3/16	.530	5/32
417	41/64	7/32	.743	7/64
418	45/64	7/32	.809	7/64
419	7/8	7/32	.984	7/64
421	15/64	0	.150	5/64
424	11/32	7/32	.450	7/64
426	17/64	7/32	.406	5/64
430	1/2	0	.211	1/4
431	9/16	0	.366	3/16
432	17/64	7/32	.390	3/32
433	5/16	7/32	.375	5/32
435	25/64	7/32	.524	5/64
436	35/64	7/32	.512	1/4
439	7/32	7/32	.345	3/32
440	11/32	7/32	.480	5/64
441	23/32	7/32	.772	5/32
447	1-1/64	7/32	.953	9/32
451	1-5/64	7/32	1.018	9/32
452	1-3/32	7/32	.690	5/8
457	45/64	7/32	.764	5/32
458	5/8	7/32	.671	11/64
459	39/64	7/32	.638	3/16
462	5/16	7/32	.437	3/32
464	15/32	7/32	.493	3/16
465	1/4	11/32	.432	5/32
468	25/64	7/32	.501	3/32
469	1/2	7/32	.580	9/64
470	13/32	7/32	.462	5/32
474	15/16	3/16	.890	15/64
475	1-3/4	3/16	1.627	5/16
477	19/64	9/32	.468	7/64
480	.281	.406	.500	.187
484	1-13/64	7/32	.948	15/64
487	27/64	7/32	.550	3/32
488	45/64	7/32	.316	39/64
489	11/32	11/32	.500	3/16
493	1/4	9/32	.390	.140
498	23/64	7/32	.316	17/64
5401	5/16	9/32	.432	5/32
5402	3/8	5/16	.500	3/16
5403	5/8	5/16	.750	3/16
5406	13/32	9/32	.500	3/16
5407	5/16	1/4	.437	1/8
5416	3/4	0	.560	3/16
5417	19/32	1/4	.703	9/64
5425	5/16	0	.187	1/8
5457	5/16	5/16	15/32	5/32



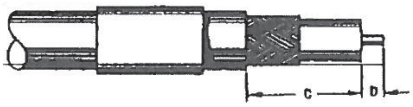
1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket



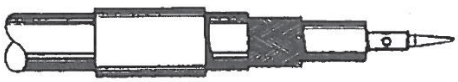
2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.



3. Remove jacket to dimension "B."

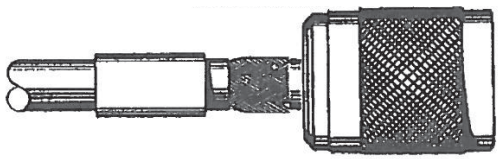


4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

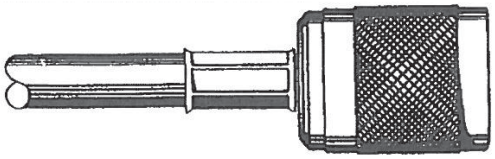


5. Solder or crimp contact to center conductor.

5A. For 10 & 20 KV connectors, when Cable Seal Gasket is supplied, place over center conductor and against cable dielectric. Solder contact to center conductor with gasket under compression.

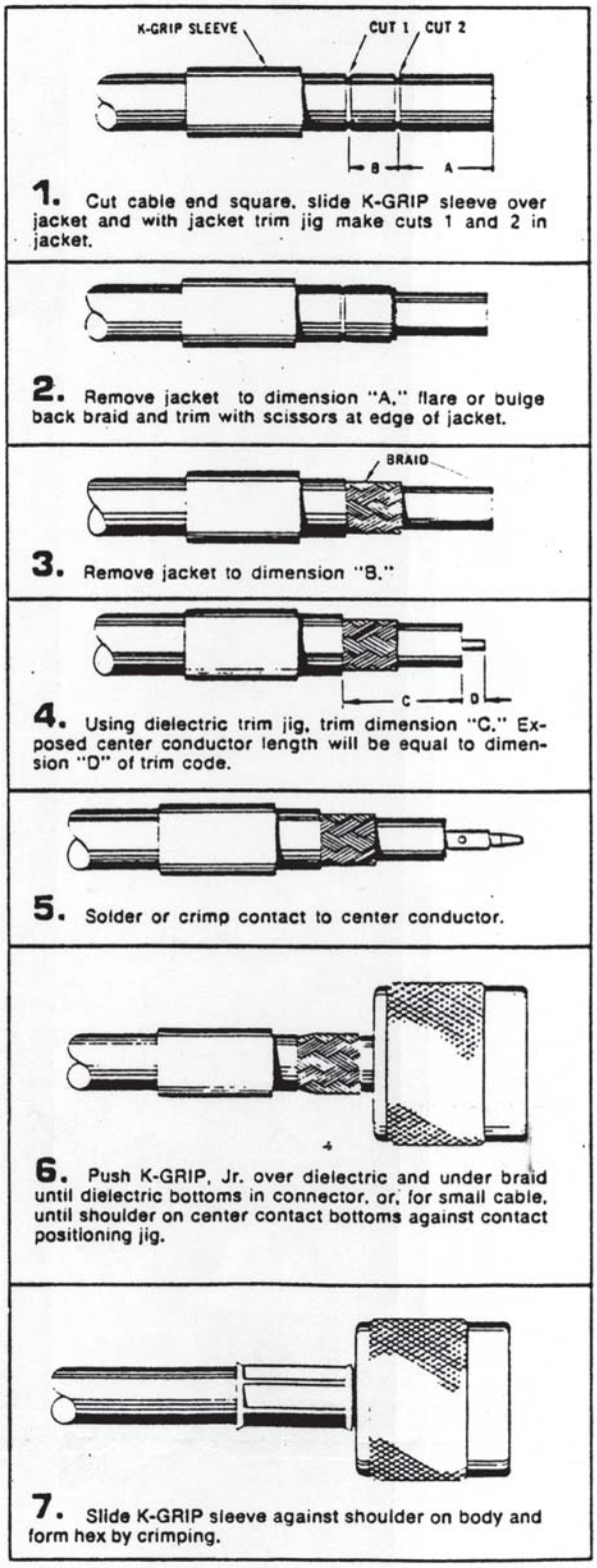


6. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. When the "B" dimension in the trim code is 0, the K-GRIP Jr. is pushed under both braid and jacket. Teflon jackets may be slit axially 1/4" in two places to facilitate entry of the K-GRIP. When center contact is undercut captive type, insert cable assembly until insulator detent locks into contact.



7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

TRIM CODE CHART				
CODE	A	B	C	D
412	5/8	7/32	.680	5/32



1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

2. Remove jacket to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.

3. Remove jacket to dimension "B."

4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

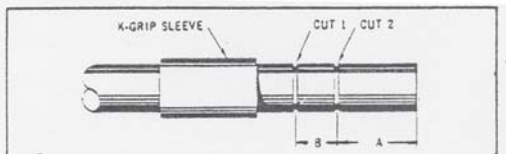
5. Solder or crimp contact to center conductor.

6. Push K-GRIP, Jr. over dielectric and under braid until dielectric bottoms in connector, or, for small cable, until shoulder on center contact bottoms against contact positioning jig.

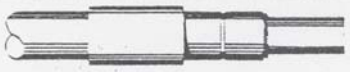
7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

TRIM CODE CHART

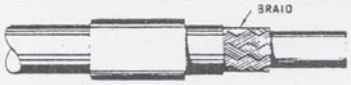
CODE	A	B	C	D
416	25/64	7/32	.453	5/32



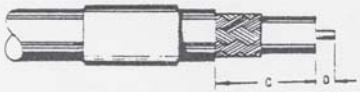
1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.



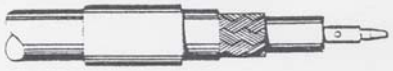
2. Remove jacket to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.



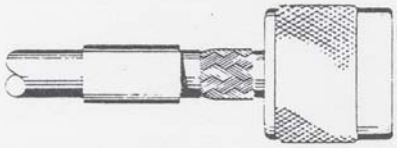
3. Remove jacket to dimension "B."



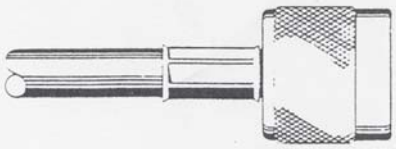
4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.



5. Solder ~~crimp~~ contact to center conductor.



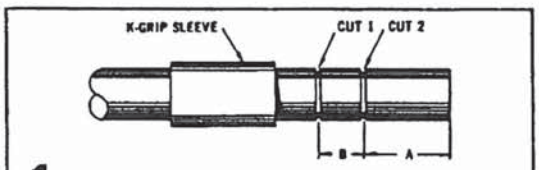
6. Push K-GRIP, Jr. over dielectric and under braid until dielectric bottoms in connector, or, for small cable, until shoulder on center contact bottoms against contact positioning jig.



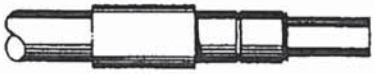
7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

TRIM CODE CHART

CODE	A	B	C	D
420	5/8	7/32	.600	1/4



1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

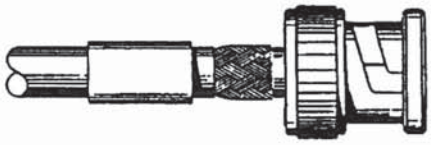


2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.

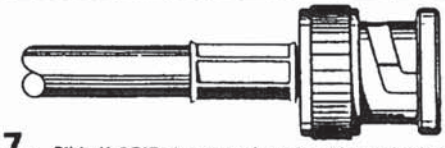
3. Remove jacket to dimension "B."

4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor.



6. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. When the "B" dimension in the trim code is 0, the K-GRIP Jr. is pushed under both braid and jacket. Teflon jackets may be slit axially ¼" in two places to facilitate entry of the K-GRIP.

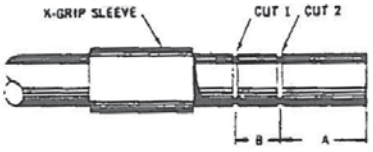


7. Slide K-GRIP sleeve against shoulder on body and form hex.

For captive contact connectors, solder contact to center conductor and thread assembly into connector.

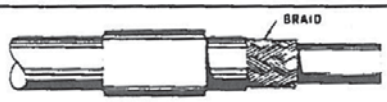
TRIM CODE CHART

CODE	A	B	C	D
425	19/32	0	.316	9/32



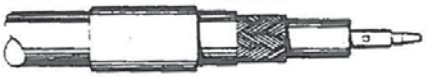
1. Cut cable end square. slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

2. Remove jacket to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.

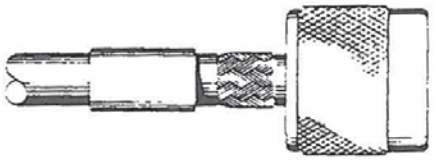


3. Remove jacket to dimension "B."

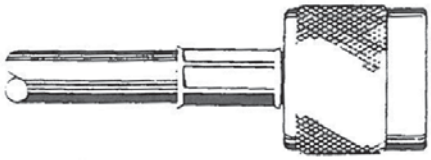
4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.



5. Solder or crimp contact to center conductor.



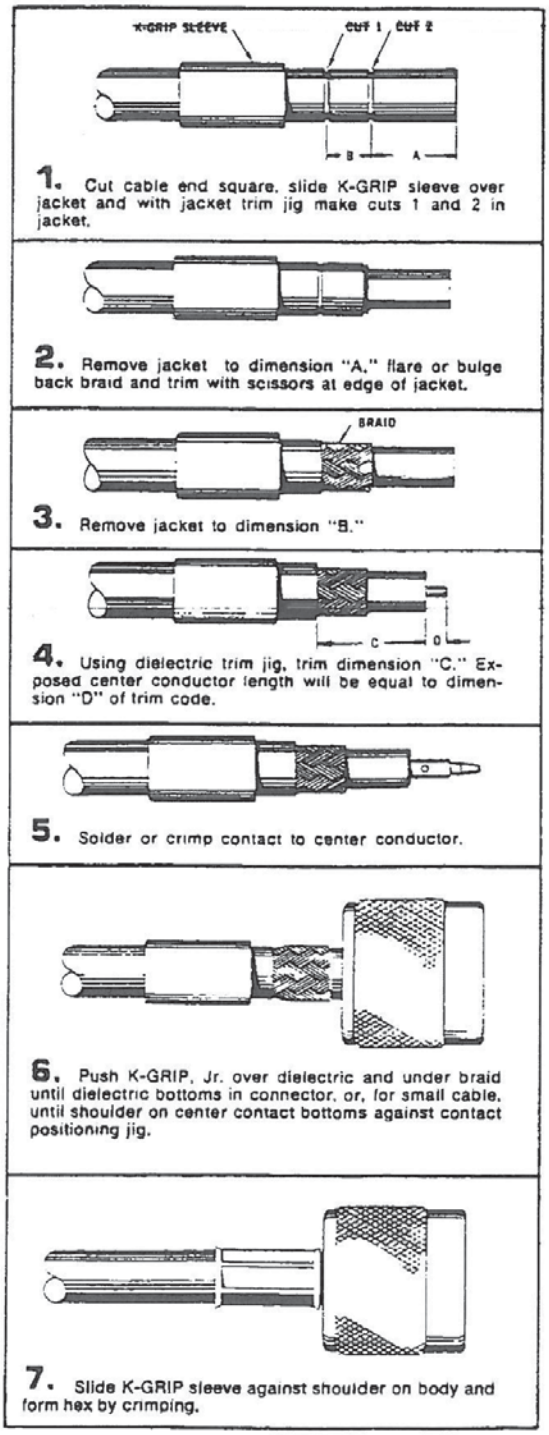
6. Push K-GRIP, Jr. over dielectric and under braid until dielectric bottoms in connector, or, for small cable, until shoulder on center contact bottoms against contact positioning jig.



7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

TRIM CODE CHART

CODE	A	B	C	D
444	7/16	9/32	.500	7/32



1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

2. Remove jacket to dimension "A." flare or bulge back braid and trim with scissors at edge of jacket.

3. Remove jacket to dimension "B."

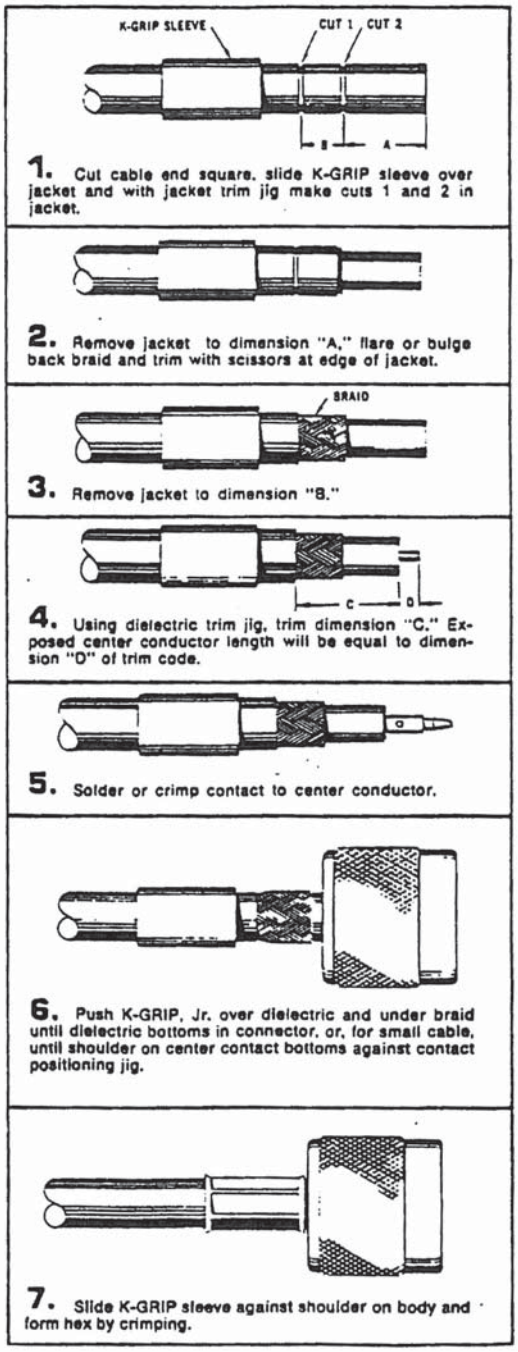
4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor.

6. Push K-GRIP, Jr. over dielectric and under braid until dielectric bottoms in connector, or, for small cable, until shoulder on center contact bottoms against contact positioning jig.

7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

TRIM CODE CHART				
CODE	A	B	C	D
460	17/32	7/32	.541	13/64



1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

2. Remove jacket to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.

3. Remove jacket to dimension "B."

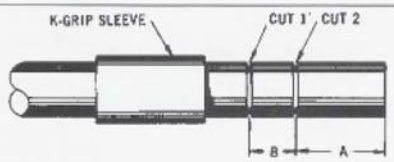
4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor.

6. Push K-GRIP, Jr. over dielectric and under braid until dielectric bottoms in connector, or, for small cable, until shoulder on center contact bottoms against contact positioning jig.

7. Slide K-GRIP sleeve against shoulder on body and form hex by crimping.

TRIM CODE CHART				
CODE	A	B	C	D
472	USE	CP-5401		



1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket

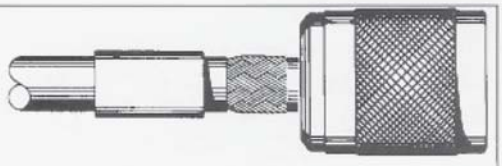
2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.

3. Remove jacket to dimension "B."

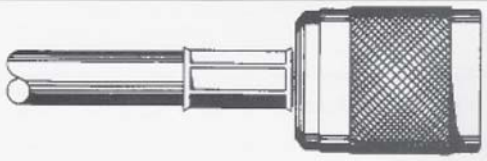
4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor.

5A. For 10 & 20 KV connectors, when Cable Seal Gasket is supplied, place over center conductor and against cable dielectric. Solder contact to center conductor with gasket under compression.



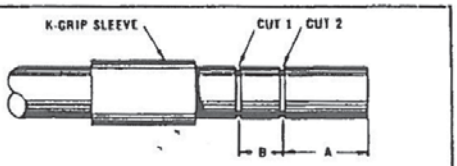
6. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. When the "B" dimension in the trim code is 0, the K-GRIP Jr. is pushed under both braid and jacket. Teflon jackets may be slit axially 1/4" in two places to facilitate entry of the K-GRIP. When center contact is undercut captive type, insert cable assembly until insulator detent locks into contact.



7. Slide K-GRIP sleeve against shoulder on body and form hex. For captive contact connectors, solder contact to center conductor and thread assembly into connector.

All Dimensions in Inches

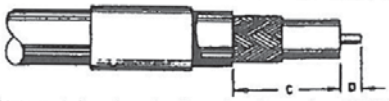
TRIM CODE CHART				
CODE	A	B	C	D
465	1/4	11/32	.432	5/32
489	11/32	11/32	.500	3/16
5401	5/16	9/32	.432	5/32
5402	3/8	5/16	.500	3/16
5406	13/32	9/32	.500	3/16
5450	.400	.313	.525	.188



1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

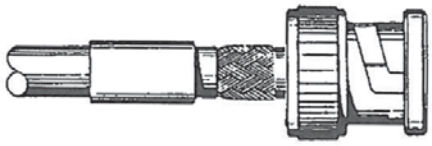
2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.

3. Remove jacket to dimension "B."

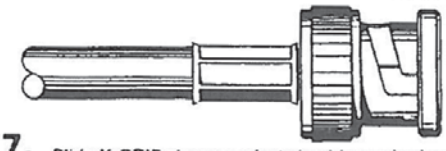


4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor. For captive contact connectors omit this step and proceed to step 6.



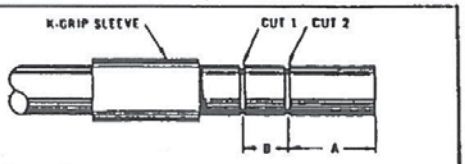
6. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. When the "B" dimension in the trim code is 0, the K-GRIP Jr. is pushed under both braid and jacket. Teflon jackets may be slit axially ¼" in two places to facilitate entry of the K-GRIP.



7. Slide K-GRIP sleeve against shoulder on body and form hex
For captive contact connectors, solder contact to center conductor and thread assembly into connector.

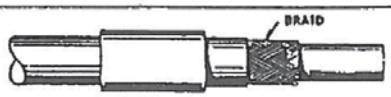
TRIM CODE CHART

CODE	A	B	C	D
5455	.30	.28	.40	.18

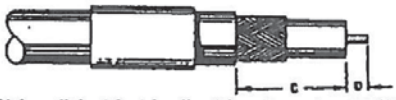


1. Cut cable end square, slide K-GRIP sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.

2. Remove jackets to dimension "A," flare or bulge back braid and trim with scissors at edge of jacket.



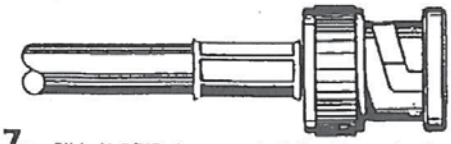
3. Remove jacket to dimension "B."



4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.

5. Solder or crimp contact to center conductor. For captive contact connectors omit this step and proceed to step 6.

6. Push K-GRIP Jr. over dielectric and under braid until dielectric bottoms in connector. When the "B" dimension in the trim code is 0, the K-GRIP Jr. is pushed under both braid and jacket. Teflon jackets may be slit axially ¼" in two places to facilitate entry of the K-GRIP.



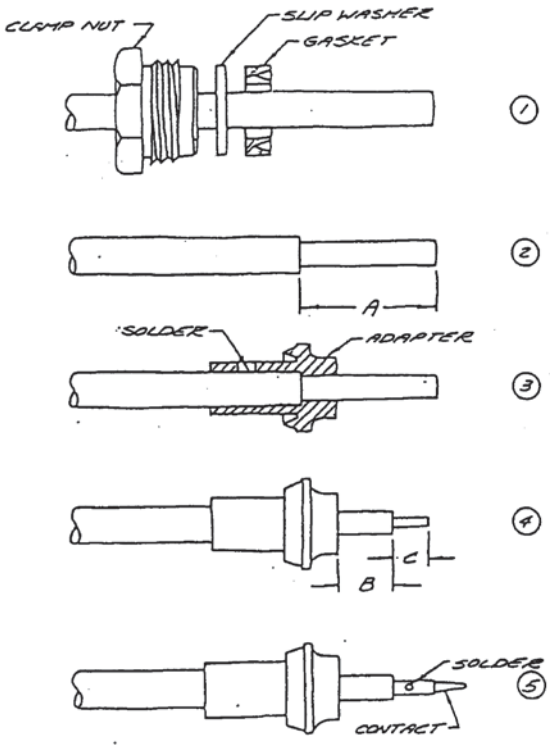
7. Slide K-GRIP sleeve against shoulder on body and form hex.
For captive contact connectors, solder contact to center conductor and thread assembly into connector.

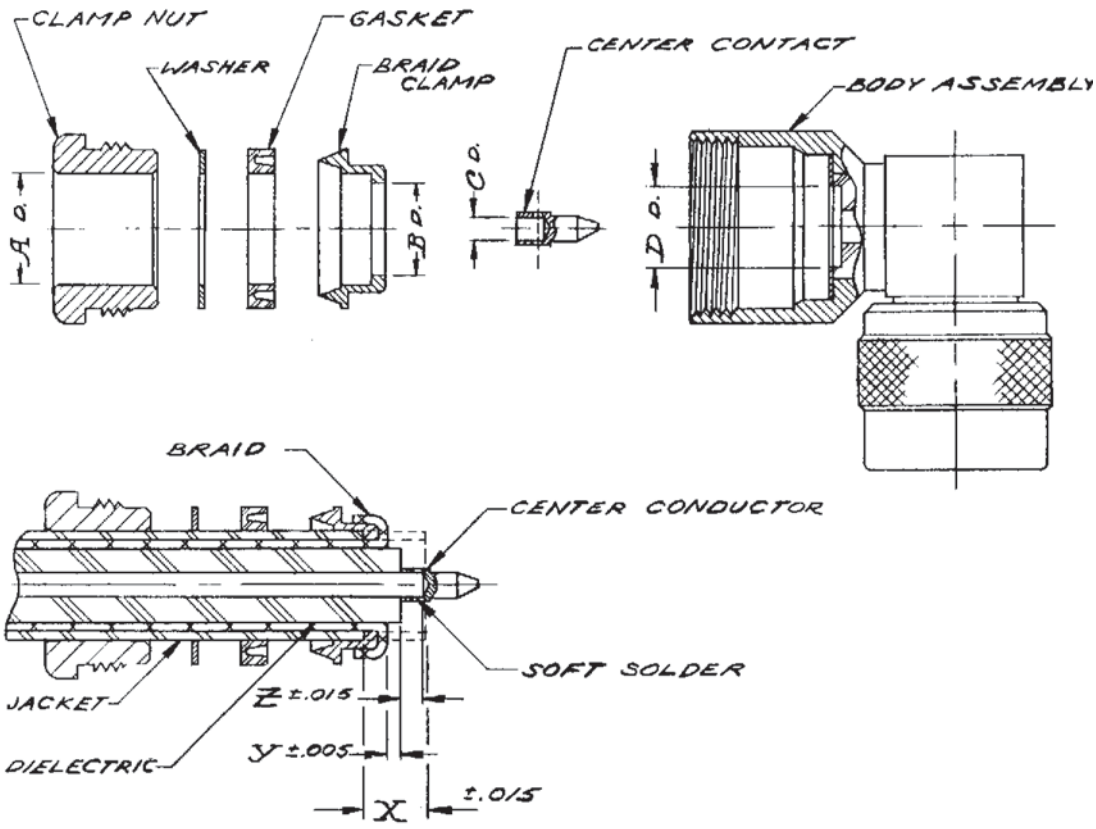
TRIM CODE CHART

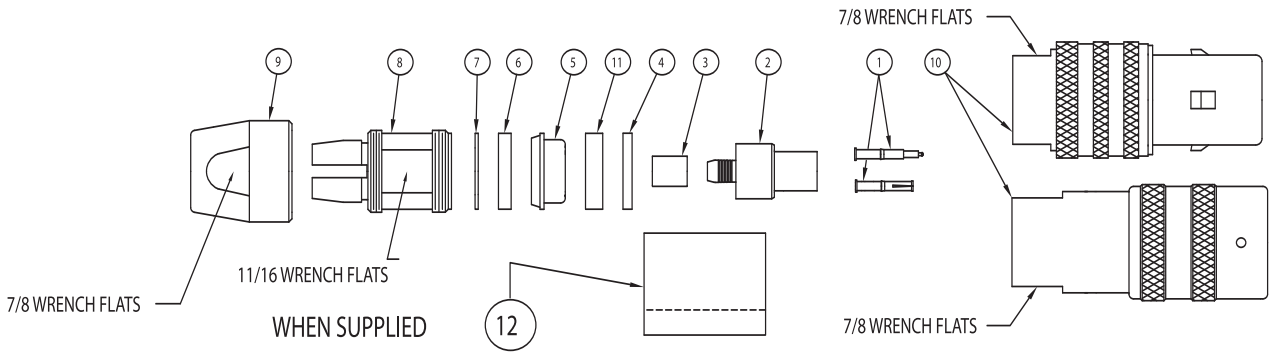
CODE	A	B	C	D
5458	.37	.31	.56	.12

1. CUT CABLE END SQUARE AND SLIDE CLAMP NUT, SLIP WASHER AND GASKET OVER OUTER CONDUCTOR.
2. TRIM OUTER CONDUCTOR TO "A" DIMENSION WITHOUT CUTTING DIELECTRIC.
3. SLIDE ADAPTER OVER CABLE UNTIL ADAPTER BOTTOMS ON OUTER CONDUCTOR. SOLDER ADAPTER TO OUTER CONDUCTOR USING MINIMUM HEAT.
4. TRIM DIELECTRIC TO DIMENSION "B" AND CENTER CONDUCTOR TO DIMENSION "C".
5. SOLDER CONTACT TO CENTER CONDUCTOR.

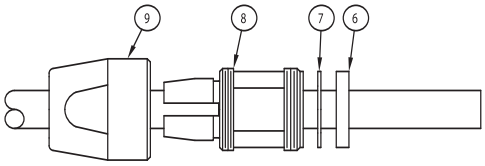
CODE	A	B	C
-708	.235	.045	.120



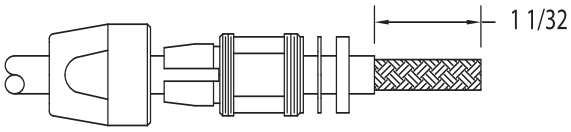

CLAMP NUT
WASHER
GASKET
BRAID CLAMP
CENTER CONTACT
BODY ASSEMBLY
A O.
B O.
C O.
D O.
BRAID
CENTER CONDUCTOR
SOFT SOLDER
JACKET
DIELECTRIC
Z ±.015
Y ±.005
X
±.015



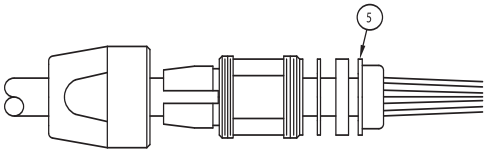
NOTE: CARE MUST BE TAKEN WHEN TRIMMING CABLE THAT THE BRAIDS, INSULATORS AND CONDUCTORS OF THE CABLE ARE NOT NICKED OR DAMAGED.



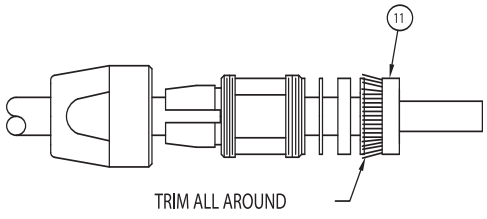
1. CUT CABLE END SQUARE. PLACE NUT (ITEM 9), COLLET (ITEM 8), THIN WASHER (ITEM 7), AND GASKET (ITEM 6) OVER THE JACKET.



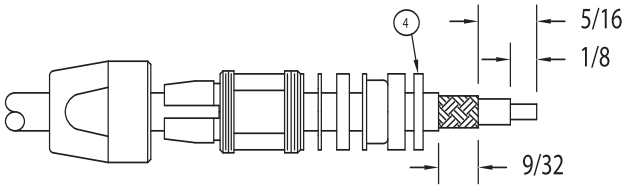
2. REMOVE OUTER JACKET TO 1-1/32" DIMENSION SHOWN.



3. PLACE BRAID CLAMP (ITEM 5) OVER THE OUTER BRAID AND SEAT AGAINST THE OUTER JACKET.



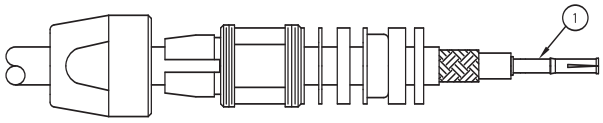
4. FOLD THE OUTER BRAID BACK OVER THE BRAID CLAMP, AND PRESS THE OUTER GROUND RING (ITEM 11) OVER THE BRAID AND BRAID CLAMP SO THAT THE OUTER GROUND RING IS FLUSH TO THE EDGE OF THE BRAID CLAMP. TRIM EXCESS BRAID THAT EXTENDS BEYOND THE OUTER DIAMETER OF THE BRAID CLAMP.



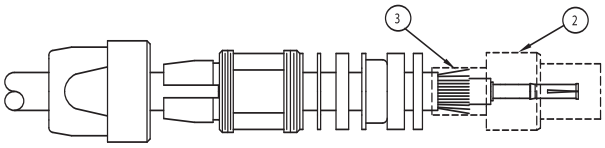
5A. REMOVE INNER JACKET AND INNER BRAID TO 5/16" DIMENSION. REMOVE INNER JACKET AN ADDITIONAL 9/32". DO NOT NICK BRAID.

B. REMOVE INNER DIELECTRIC TO 1/8" DIMENSION TO EXPOSE INNER CONDUCTOR. DO NOT NICK OR UNRAVEL CENTER CONDUCTOR.

C. PLACE THICK WASHER (ITEM 4) AGAINST RING.



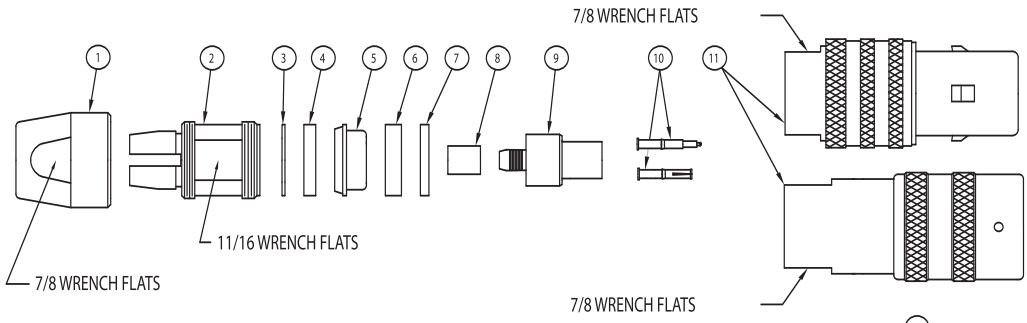
6. PLACE THE MALE OR FEMALE CONNECTOR CONTACT (ITEM 1) OVER THE CENTER CONDUCTOR OF THE CABLE AND BUTT IT AGAINST THE CORE. CRIMP OR SOLDER THE CONTACT TO THE CORE.



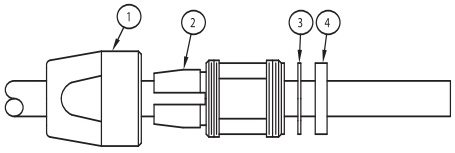
7. PLACE CRIMP SLEEVE (ITEM 3) OVER INNER BRAID OF THE CABLE. SLIDE BODY ASSEMBLY (ITEM 2) OVER THE CORE (INNER DIELECTRIC) AND UNDER THE INNER BRAID UNTIL THE CONTACT BOTTOMS IN THE CONNECTOR. (NOTE: CAUTION MUST BE EXERCISED TO NOT ALLOW ANY OF THE BRAID TO REMAIN INSIDE THE CONNECTOR ASSEMBLY. ALL BRAID MUST BE ON THE OUTSIDE OF THE BODY.) SLIDE THE CRIMP SLEEVE OVER BODY AND BRAID TO WITHIN 1/64" OF THE BODY SHOLDER. CRIMP THE SLEEVE.

SLIDE CONNECTOR INTO MAIN CONNECTOR BODY (ITEM 10). TIGHTEN COLLET TO BODY WITH A MINIMUM OF 80 INCH POUNDS OF TORQUE. IT IS RECOMMENDED NOT TO EXCEED 125 INCH POUNDS OF TORQUE. LOCK CLAMP NUT TO COLLET TO PREVENT ROTATION OF CABLE WITHIN THE CONNECTOR.

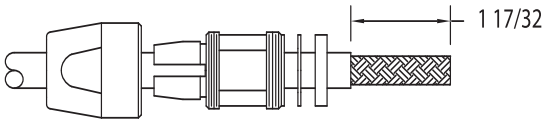
"U" SPACER, ITEM 12, IS SUPPLIED ONLY WITH SMALL CABLE CONNECTORS. IT IS PLACED OVER ITEM 3 AFTER CRIMPING AND BEFORE THREADING CABLE ASSEMBLY INTO BODY.



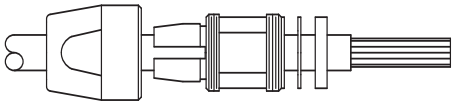
NOTE: CARE MUST BE TAKEN WHEN TRIMMING CABLE THAT THE BRAIDS, INSULATORS AND CONDUCTORS OF THE CABLE ARE NOT NICKED OR DAMAGED.



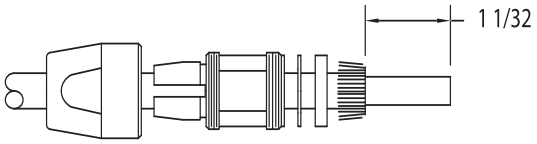
1. CUT CABLE END SQUARE. PLACE NUT (ITEM 1), COLLET (ITEM 2), THIN WASHER (ITEM 3), AND GASKET (ITEM 4) OVER THE JACKET.



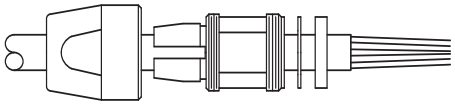
2. REMOVE OUTER JACKET TO 1-17/32" DIMENSION SHOWN.



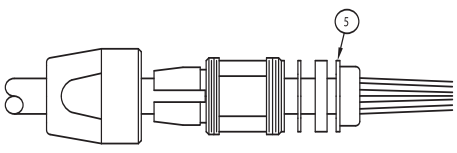
3. COMB OUT BRAID AS SHOWN.



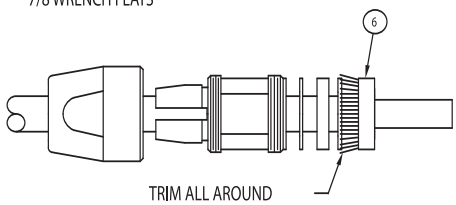
4. FOLD BRAID BACK AND TRIM CABLE BACK 1/2".



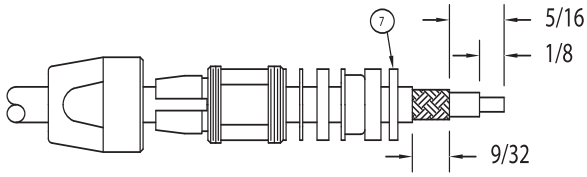
5. COMB OUT BRAID AGAIN AND FORM END AS SHOWN.



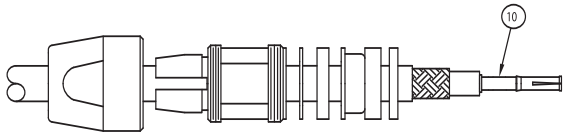
6. PLACE BRAID CLAMP (ITEM 5) OVER THE OUTER BRAID AND SEAT AGAINST THE OUTER JACKET.



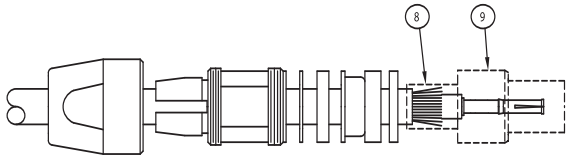
7. FOLD THE OUTER BRAID BACK OVER THE BRAID CLAMP, AND PRESS THE OUTER GROUND RING (ITEM 6) OVER THE BRAID AND BRAID CLAMP SO THAT THE OUTER GROUND RING IS FLUSH TO THE EDGE OF THE BRAID CLAMP. TRIM EXCESS BRAID THAT EXTENDS BEYOND THE OUTER DIAMETER OF THE BRAID CLAMP.



8. A. REMOVE INNER JACKET AND INNER BRAID TO 5/16" DIMENSION. REMOVE INNER JACKET AN ADDITIONAL 9/32". DO NOT NICK BRAID.
B. REMOVE INNER DIELECTRIC TO 1/8" DIMENSION TO EXPOSE INNER CONDUCTOR. DO NOT NICK OR UNRAVEL CENTER CONDUCTOR.
C. PLACE THICK WASHER (ITEM 7) AGAINST GROUND RING.

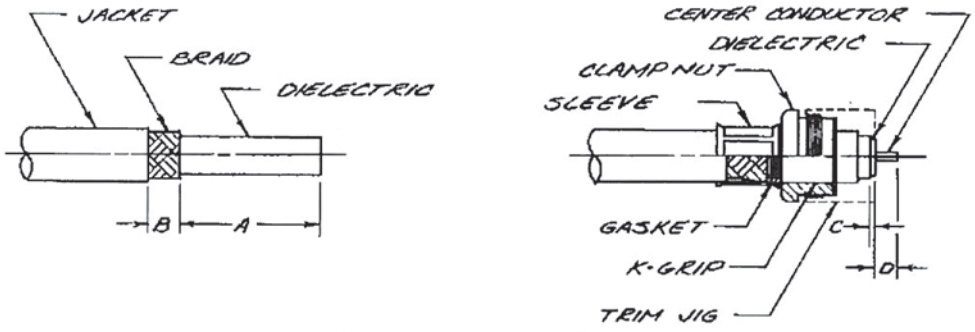


9. PLACE THE MALE OR FEMALE CONNECTOR CONTACT (ITEM 10) OVER THE CENTER CONDUCTOR OF THE CABLE AND BUTT IT AGAINST THE CORE. CRIMP OR SOLDER THE CONTACT TO THE CORE.



10. PLACE CRIMP SLEEVE (ITEM 8) OVER INNER BRAID OF THE CABLE. SLIDE BODY ASSEMBLY (ITEM 9) OVER THE CORE (INNER DIELECTRIC) AND UNDER THE INNER BRAID UNTIL THE CONTACT BOTTOMS IN THE CONNECTOR. (NOTE: CAUTION MUST BE EXERCISED NOT TO ALLOW ANY OF THE BRAID TO REMAIN INSIDE THE CONNECTOR ASSEMBLY. ALL BRAID MUST BE ON THE OUTSIDE OF THE BODY.) SLIDE THE CRIMP SLEEVE OVER BODY AND BRAID TO WITHIN 1/64" OF THE BODY SHOLDER. CRIMP THE SLEEVE.

SLIDE CONNECTOR INTO MAIN CONNECTOR BODY (ITEM 11). TIGHTEN COLLET TO BODY WITH A MINIMUM OF 80 INCH POUNDS OF TORQUE. IT IS RECOMMENDED NOT TO EXCEED 125 INCH POUNDS OF TORQUE. LOCK CLAMP NUT TO COLLET TO PREVENT ROTATION OF CABLE WITHIN THE CONNECTOR.



1. Cut cable and square and slide K-grip sleeve over jacket.

2. Cut through jacket and braid to dimension A, leaving cut jacket and braid in place until step 3 below. This may be conveniently done with a B-T stripper which will cut cleanly through both jacket and braid. When cutting through braid avoid tangling strand ends.

3. Remove jacket to dimension B, without nicking braid. Remove braid cut to dimension A in step 2, above.

4. Flare out braid slightly to permit slotted end of K-grip to enter between dielectric and braid. Flaring tool S-89-24-5 may be used for this operation.

5. Assemble K-grip gasket and clamp nut on K-grip.

6. Push K-grip over dielectric and under braid as far as it will go.

7. Slide K-grip sleeve forward over braid and K-grip gasket up to small shoulder on K-grip. Place assembly in K-grip forming tool centering sleeve between die halves and form hex.

8. Assemble dielectric trim jig to clamp nut, remove dielectric flush with jig and trim center conductor in usual manner.

9. Solder or crimp center contact to center conductor. Remove dielectric trim jig. Place connector gasket and braid clamp on K-grip. Then insert assembly into connector body and lock securely by clamp nut.

CABLE TRIM CODE

CODE	A	B	C	D
I	1 3/32	1/4	.093	3/16
II	1 25/32	1/4	.666	3/16
III	1 9/16	1/4	.297	7/32
IV	1 1/8	1/4	.093	5/32
V	1 13/32	1/4	.333	5/32
VI	1 3/32	1/4	.044	1/8
VII	1 53/64	1/4	.437	23/32