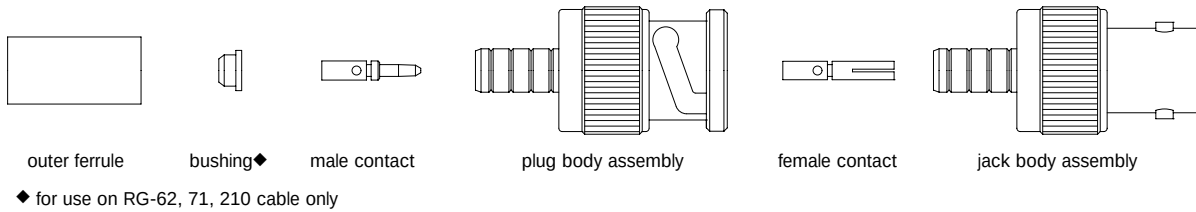
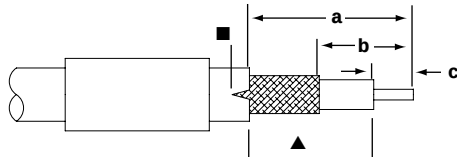


CRIMP TERMINATION FOR TYPE 2 – 75Ω CONNECTORS



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

Step 1

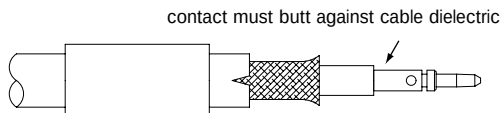


■ ▲ For RG-174, 179, 187, 188, 316/U cables only, slit jacket back .100" (2.5mm) as shown. Before attaching center contact TFE sleeve (not shown) over cable dielectric and under braid. For 31-71016, before attaching center contact. Slide metal spacer/TFE sleeve (not shown) over cable dielectric and under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

Step 1

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

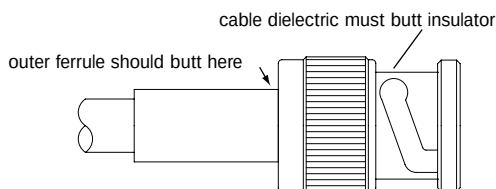
Step 2



Step 2

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

Step 3



Step 3

Install cable assembly into body assembly so that inner ferrule portion slides under braid. Push cable assembly forward until contact snaps into place in insulator. Slide outer ferrule over braid and up against connector body. Crimp outer ferrule using Die Set Cavity specified in table above.

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

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