

BNC assembly instructions - C9

CRIMP TYPES



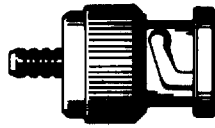
outer ferrule



bushing



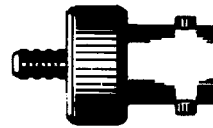
male contact



plug body assembly



female contact

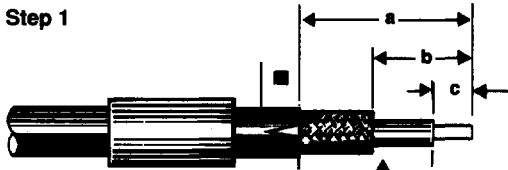


jack body assembly

♦ This part is used only with RG-62 cable

Amphenol Number	Connector Type	Cable RG-U	Hex Crimp Data				Stripping Dimensions, inches (mm)						
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944	CTL Series Tool Number	a	b	c				
31-242	BNC Plug	179, 187	.068(1.7)	.178(4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)				
31-245	BNC Bulk. Jack												
31-315	BNC Plug	174, 188, 316											
31-315-1005	BNC Plug	DbI. Br. 316											
31-318	BNC Bulk. Jack	174, 188, 316											
31-320	BNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)				
31-320-1006	BNC Plug	B9907, B89907											
31-321	BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)				
31-321-1000	BNC Plug	B8281	.068(1.7)	.324(8.2)	227-1221-32								
31-325	BNC Plug	122, B8218	.068(1.7)	.178(4.5)	227-1221-09								
31-335	BNC Angle Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)				
31-336	BNC Angle Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13								
31-342	BNC Bulk. Jack	58, 141	.068(1.7)	.213(5.4)	227-1221-11								
31-343	BNC Bulk. Jack	59, 62	.068(1.7)	.255(6.5)	227-1221-13								
31-343-1002	BNC Bulk. Jack	PL-59 20AWG CC	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)				
31-4320	BNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11								
31-4321	BNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-3	.656(16.7)	.250(6.4)	.156(4.0)				
31-4411	BNC Plug	B8213	.100(2.5)	.429(10.9)	227-1221-25								
36650-1003	BNC Plug	Plenum 58	.068(1.7)	.178(4.5)	227-1221-09	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)				
36775	BNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11								
36800	BNC Jack												
68150	BNC Jack	59,62	.068(1.7)	.255(6.5)	227-1221-13								
68150-1002	BNC Jack	59 (20 AWG CC)											
68175	BNC Plug	59											
68175-1003	BNC Plug	B9259											
68175-1004	BNC Plug	62											
68175-1005	BNC Plug	59 (20 AWG CC)	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.609(15.5)	.359(9.1)	.172(4.4)				
68175-1011	BNC Plug	Plenum 59, 62											
95600	BNC Angle Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.609(15.5)	.359(9.1)	.172(4.4)				
95625	BNC Angle Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13								

Step 1



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

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

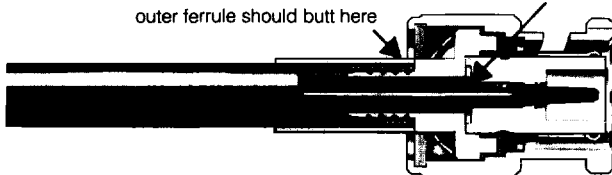
contact must butt against cable dielectric



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.

Step 3

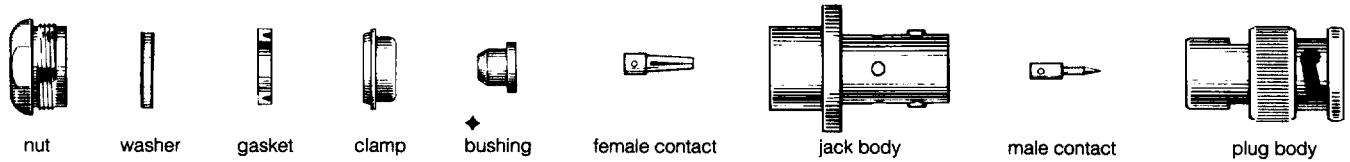
cable dielectric must butt insulator
outer ferrule should butt here



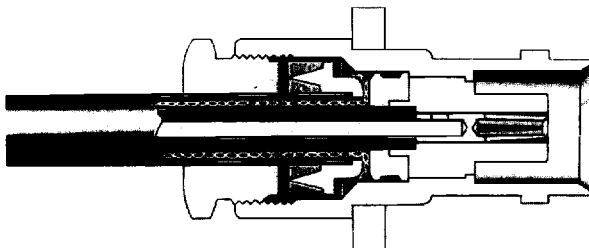
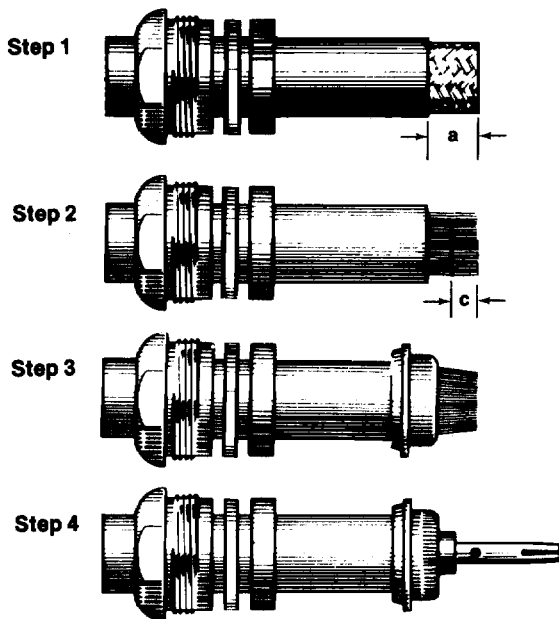
Step 3 Install cable assembly into body assembly so that inner ferrule portion slides under braid. Push cable assembly forward until contact snaps into place in insulator. Slide outer ferrule over braid and up against connector body. Crimp outer ferrule using Die Set Cavity specified in table above.

BNC assembly instructions - C10

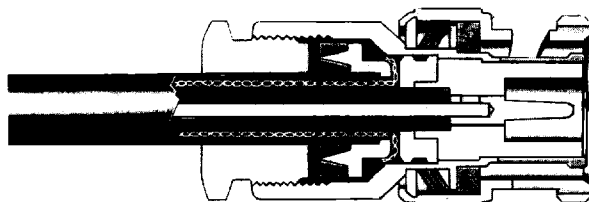
CLAMP TYPES



◆ This part is used only with RG-62 cable



Step 5



Amphenol Number	Connector Type	Cable RG-/U	Stripping Dims, Inches (Millimeters)	
			a	c
31-2	BNC Plug	58	.312(7.9)	.094(2.4)
31-202			.250(6.4)	.094(2.4)
31-204	BNC Angle Plug	55, 58, 141, 142, 223, 400	.281(7.1)	.109(2.8)
31-205	BNC Jack	55, 58, 141, 142, 223, 400	.297(7.5)	.109(2.8)
31-206	BNC Bulkhead Jack			
31-207	BNC Bulkhead Jack	59, 62, 140, 210	.250(6.4)	.094(2.4)
31-212	BNC Plug	59, 62		
31-215	BNC Jack	59, 62, 140, 210	.297(7.5)	.109(2.8)
31-71003	75Ω BNC Plug	59, 62, 140, 210	.250(6.4)	.156(4.0)
6775-75	75Ω BNC Plug	11	.490(12.4)	.200(5.1)
8575	BNC Angle Plug	59, 62, 140, 210	.297(7.5)	.094(2.4)
84975	BNC Plug	122, B8218	.281(7.1)	.172(4.4)
86225	BNC Angle Plug	59, 62, 140, 210	.281(7.1)	.141(3.6)

Step 1 Place nut, washer and gasket over cable and strip jacket to dimension **a** shown in table above.

Step 2 Comb out braid and fold out. Trim insulation off center conductor to dimension **c** shown in table above. [For RG-62,71 and 210/U cable, trim an additional .032" (0.8mm) of insulation off center conductor and add bushing.] Tin center conductor.

Step 3 Pull braid wires forward and taper toward center conductor. Place clamp over braid and push back against cable jacket.

Step 4 Fold back braid wires as shown, trim to proper length [.125" (3.2mm) long]▲ and form over clamp as shown. Solder contact to center conductor.

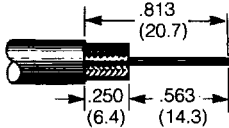
Step 5 Insert cable and parts into connector body. Make sure sharp edge of clamp seats properly in gasket. Tighten nut.

▲ for 6775-75, trim braid to be .290(7.4) long; for 31-71003, trim braid to be .219(5.5) long.

BNC SURETWIST® assembly instructions - C11

The following instructions are identical for all configurations of BNC SURETWIST® connectors

Step 1



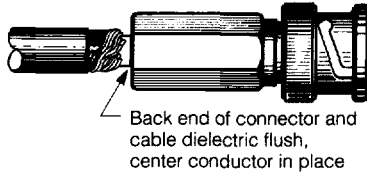
Strip cable as shown. Take care not to nick center conductor or outer braid.

Step 2



Twist outer braid in a clockwise direction so that at least 1/32" of cable dielectric is bared, and braid is left flat. (Stray or loose braid can cause shorts.)

Step 3

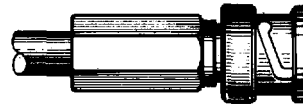


Gently insert center conductor into back end of connector, "feeling" it into the guide hole. (If center conductor is NOT properly in place, about 1/8" of center conductor will show at the back end. Reinsert until cable dielectric reaches position shown in illustration.)

Cable ☆ RG-/U	Connector Type	Amphenol Number
58	BNC Plug	31-5137
	BNC Angle Plug	31-5153
	BNC Jack	31-5139
59	BNC Plug	31-5136
	BNC Angle Plug	31-5154
	BNC Jack	31-5138
Belden 8281, 88281 Times AA-5236 Amphenol 21-1060-7	BNC Plug	31-5151
	BNC Angle Plug	31-5155
	BNC Jack	31-5152
Plenum 59, 62 Belden 89269, 86262 Times AA-6074, AA-6075	BNC Plug	31-5369
	BNC Jack	31-5370

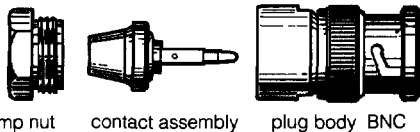
☆ for solid center conductor cables only.

Step 4



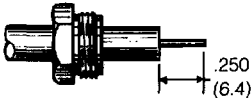
Push the cable firmly home (as far as possible). Then screw the connector onto the cable in a clockwise direction until it stops. Assembly is complete.

BNC QUICKTRIM® assembly instructions - C12

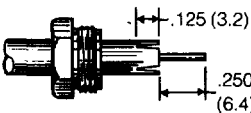


dimensions, inches (millimeters)

Step 1A



Step 1B



Step 2



Step 3



Step 4



Amphenol Number	Cable RG-/U	Center Contact Affixment		
		Hex Size	Die Set for Tool 227-944	CTL Series Tool Number
31-4541	59, 59A, 62, 62A	.068(1.7)	227-1221-13 Cavity B	CTL-1
31-4542	Belden 9268 Montrose CBL-5098			
31-5060	Plenum 62 IBM 4885584	Solder Center Conductor		

Step 1A For all cables listed, except Plenum 62.

Slide clamp nut over cable. Strip cable to dimension shown. Cut braid and dielectric square. Do not nick center conductor.

Step 1B For Plenum 62 (IBM 4885584). Same as step 1A, and then slit jacket back .125"(3.2 mm) in four places 90° apart as shown in illustration.

Step 2 Slide contact assembly under braid and jacket until braid butts as shown. Use caution that braid slides over contact assembly and not inside of it. Be sure center conductor is visible through side hole of contact. Crimp contact to conductor using Amphenol CTL-1 crimp tool; or by using die set 227-1221-13 cavity B in tool frame 227-944 or in pneumatic crimp tool 227-60., or solder contact to conductor.

Step 3 Insert into connector body.

Step 4 Tighten clamp nut to a torque of 35 lbf-in.