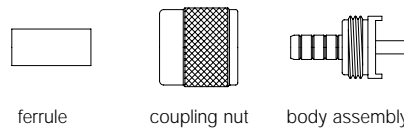


C4 — BRAID CRIMP - SOLDER CENTER CONTACT



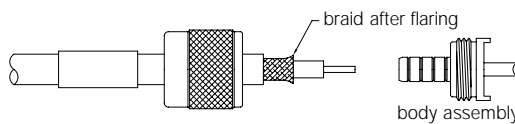
Amphenol Number	Connector Type	Cable RG-/U	Cable Attachment		Hex Crimp Data			Stripping Dims, inches (mm)		
			Outer	Inner	Cavity for Outer Ferrule	Die Set Tool 227-994	CTL Series Tool No.	a	b	c
83-58SP	UHF Plug	58, 141	Crimp	Solder	.213(5.4)	227-1221-11	CTL-1	1.14(29.0)	.780(19.9)	.250(6.4)
83-58SP-1002	UHF Plug	400	Crimp	Solder	.213(5.4)	227-1221-11	CTL-1	1.14(29.0)	.780(19.9)	.250(6.4)
83-59DCP-RFX	UHF Plug	59	Crimp	Solder	.255(6.5)	227-1221-13	CTL-1	1.22(30.9)	.574(22.6)	.543(13.8)
83-58SCP-RFX	UHF Plug	58	Crimp	Solder	.213(5.4)	227-1221-11	CTL-1	1.22(30.9)	.574(22.6)	.543(13.8)
83-59SP	UHF Plug	59	Crimp	Solder	.255(6.5)	227-1221-13	CTL-1	1.22(30.9)	.574(22.6)	.543(13.8)
83-8SP-RFX	UHF Plug	8	Crimp	Solder	.429(10.9)	227-1221-25	CTL-3	1.22(30.9)	.574(22.6)	.543(13.8)

Step 1



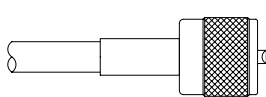
Step 1 Cut end of cable even. Strip cable to dimensions shown in table. All cuts are to be sharp and square. Do not nick braid, dielectric or center conductor. Tin center conductor avoiding excessive heat.

Step 2



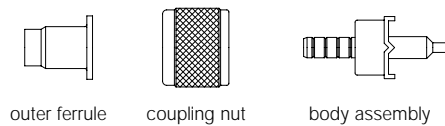
Step 2 Slide coupling nut and ferrule over cable jacket. Flair braid slightly as shown. Install cable into body assembly, so inner ferrule portion slides under braid, until braid butts shoulder. Slide outer ferrule over braid until it butts shoulder. Crimp ferrule with tool and die set indicated in table.

Step 3



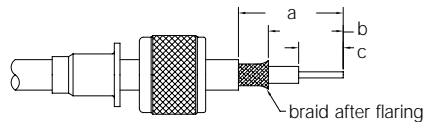
Step 3 Soft solder center conductor to contact. Avoid heating contact excessively to prevent damaging insulator. Slide/screw coupling nut over body.

C5 — UHF CRIMP-CRIMP TYPE-C5



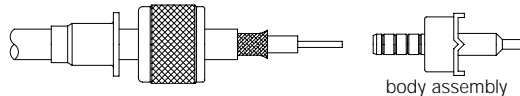
Amphenol Number	Connector Type	Cable RG-/U	Cable Attachment		Hex Crimp Data			a	b	c	CTL Series Tool #	Die Set for Tool 227-944
			Outer	Inner	Cavity for Outer ferrule	Cavity for End of Ferrule	Cavity for Center Contact					
83-58DCP-2	UHF Plug	58	Crimp	Crimp	.260(6.60)	.210(5.33)	.052(1.32) sq.	1.23(31.3)	.791(20.2)	.25(6.35)	—	227-1350
83-58DCP-2RFX	UHF Plug	58	Crimp	Crimp	.255(6.5)	.213(5.4)	.068(1.7)	1.12(28.4)	.685(17.4)	.236(5.99)	CTL-1	227-1221-11,-13

Step 1



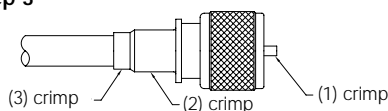
Step 1 Strip cable to dimensions shown. Slide ferrule and coupling nut over cable jacket and flair braid slightly as shown.

Step 2



Step 2 Slide body assembly into place so inner ferrule portion slides under braid. Braid must butt back of body. Slide coupling nut forward. Slide ferrule over braid until it butts against body.

Step 3



Step 3 Using tools indicated in table above:
 (1) crimp center contact
 (2) crimp outer ferrule to braid
 (3) crimp outer ferrule to cable jacket

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