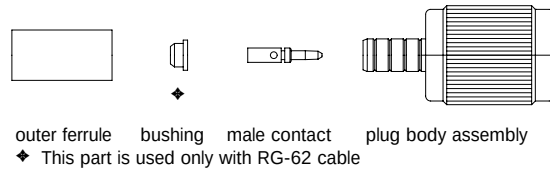


Assembly Instructions-C36 TNC

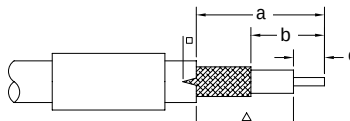
Amphenol®

CRIMP-CRIMP TYPES



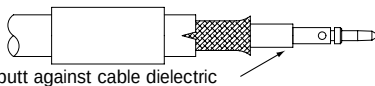
Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data				Stripping Dimensions, inches (mm)		
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944	CTL Series Tool No.	a	b	c
36825	TNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2318	TNC Bulk. Jack	174, 188, 316	.068(1.7)	.178(4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-2367	TNC Plug	58, 141	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2367-RFX	TNC Plug	58, 141, 142A	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.630(16.0)	.303(7.7)	.156(4.0)
31-2368	TNC Plug	59, 62	.068(1.7)	.255(6.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2373	TNC Plug	55, 142, 223	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2381	TNC Angle Plug	55, 142, 223, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-4452	TNC Plug	142, 400	.068(1.7)	.213(5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2242	TNC Plug	179,187	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
31-2242-RFX	TNC Plug	179,187	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
31-2264	TNC Blkh Jack	59,62,140,210	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2264-RFX	TNC Blkh Jack	59	.068 (1.7)	.255 (8.5)	227-1331-13	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-2264-RFX	TNC Blkh Jack	62	.068 (1.7)	.255 (8.5)	227-1331-13	CTL-1	.689(17.5)	.362(9.2)	.197(5.0)
▲ 31-2315	TNC Plug	174,188	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.593(15.1)	.250(6.4)	.156(4.0)
▲ 31-2315-RFX	TNC Plug	174,188,316	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
▲ 31-2317	TNC Jack	174.188	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
▲ 31-2318	TNC Blkh Jack	174,187,188	.068 (1.7)	.178 (4.5)	227-1221-09	CTL-2	.590(15.0)	.323(8.2)	.118(3.0)
31-2368-RFX	TNC Plug	59	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.157(4.0)
31-2368-RFX	TNC Plug	62	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.630(16.0)	.303(7.7)	.197(5.0)
31-2381	TNC Angle Plug	55,142	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-2382	TNC Angle Plug	58,141	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.578(14.7)	.328(8.3)	.125(3.2)
31-2383	TNC Angle Plug	62	.068 (1.7)	.255 (8.5)	227-1221-13	CTL-1	.689(17.5)	.362(9.2)	.156(4.0)
31-2389	TNC Blkh Jack	58,141	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.593(15.1)	.250(6.4)	.156(4.0)
31-2389-RFX	TNC Blkh Jack	141,142	.068 (1.7)	.213 (5.4)	227-1221-11	CTL-1	.689(17.5)	.362(9.2)	.157(4.0)
31-2367-RFX	TNC Plug	58,141	.068	.213	227-1221-11	CTL-1,5	.630 (16.0)	.303 (7.7)	.157 (4.0)
31-5849-RFX	TNC Angle Plug	58,58c	Solder	.213	227-1221-11	CTL-1,3,5	.709(18)	.382(9.7)	.161(4.1)
31-6000-RFX	TNC Plug	8x,LMR240	.068	.255	227-1221-13	CTL-1,5	.630 (16)	.303 (7.7)	.157 (4.0)
31-6001-RFX	TNC Plug	B8214, B9913	Solder	.429	227-1221-25	CTL-4	.630 (16)	.303 (7.7)	.157 (4.0)
31-6002-RFX	TNC Angle Plug	LMR 400, B9913,B9914	Solder	.429	227-1221-25	CTL-4	.728 (18.5)	.401 (0.2)	.244 (6.2)
31-6003-RFX	TNC Angle Plug	8x,LMR240	Solder	.255	227-1221-13	CTL-1,5	.728 (18.5)	.401 (10.2)	.244 (6.2)

Step 1

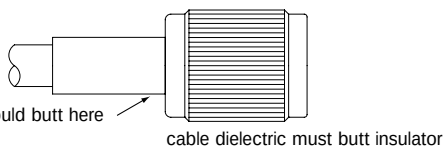


- ▲ For RG-174, 179, 187, 188, 316/U cables only, slit jacket back .100"(2.5mm) as shown. Before attaching center contact, slide metal spacer/TFE sleeve (not shown) over cable dielectric. The center contact should butt against the dielectric and TFE sleeve.

Step 2



Step 3



Step 1

Strip cable jacket, braid, and dielectric to dimensions in table above. 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

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

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 in table above.