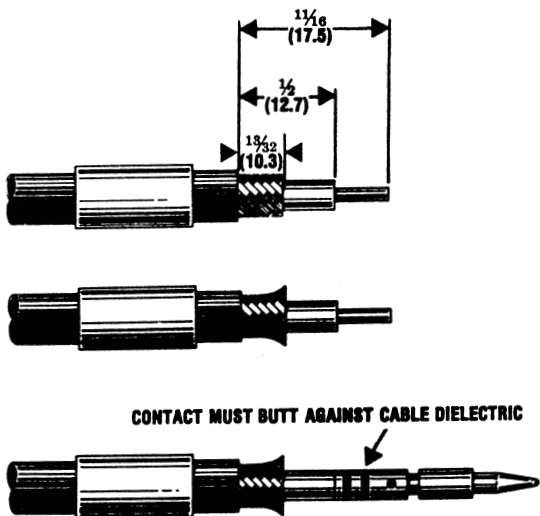


Amphenol Number	Connector Type	Cable RG-/U	Hex Crimp Data			CTL Series Tool Number	Stripping Dimensions, inches (mm)		
			Cavity for Contact	Cavity for Outer Ferrule	Die Set for Tool 227-944		a	b	c
82-4450	Plug	9, 214, 225, 393	.100 (2.5)	.429 (10.9)	227-1221-25	CTL-3	.687 (17.5)	.500 (12.7)	.406 (10.3)
82-4451	Plug	142B, 400	.100 (2.5)	.213 (5.4)	227-1221-57	CTL-3, -5	.687 (17.5)	.500 (12.7)	.406 (10.3)
82-4474	R/A Plug	9, 214, 225, 393	.100 (2.5)	.429 (10.9)	227-1221-25	CTL-3	.687 (17.5)	.500 (12.7)	.406 (10.3)
82-4475	R/A Plug	142B, 400	.100 (2.5)	.213 (5.4)	227-1221-57	CTL-3, -5	.687 (17.5)	.500 (12.7)	.406 (10.3)
82-4460	Panel Jack	9, 214, 225, 393	.100 (2.5)	.429 (10.9)	227-1221-25	CTL-3	.687 (17.5)	.500 (12.7)	.406 (10.3)
82-4454	Bulkhead Jack	214, 225, 393	.100 (2.5)	.213 (5.4)	227-1221-57	CTL-3, -5	.687 (17.5)	.500 (12.7)	.406 (10.3)



Strip cable jacket, braid, and dielectric to dimensions shown. $\pm .010$ (.25). All cuts are to be sharp and square. Important: Do not nick braid, dielectric, and center conductor. Tinning of center conductor is not necessary if contact is to be crimped. For solder method, tin center conductor avoiding excessive heat. Slide outer ferrule onto cable as shown.

Flare slightly end of cable braid as shown to facilitate insertion onto inner ferrule. Important: Do not comb out braid.

Place contact on cable center conductor so that it butts against cable dielectric. Center conductor should be visible through inspection hole in contact. Crimp contact in place using tool handle and die cavity shown in table above or soft solder per QQ-5-571 COMP SN60.

Do not get any solder on outside surfaces of contact. Avoid excessive heat to prevent swelling of dielectric.

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 tool handle and die set cavity shown in table above.

