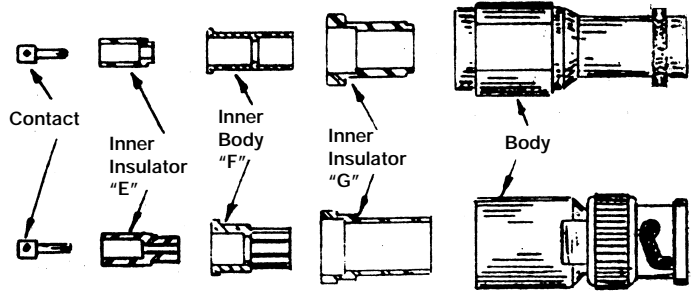
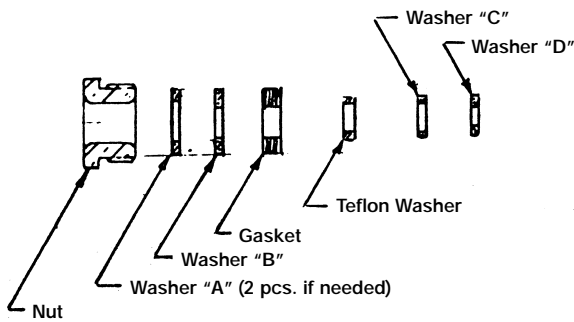


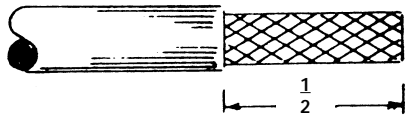
Assembly Instructions-C12

Triax BNC, 180° Polarity

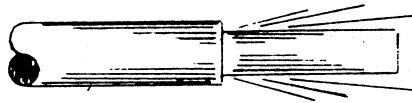


31-4774-3

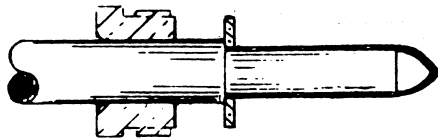
31-2743-11



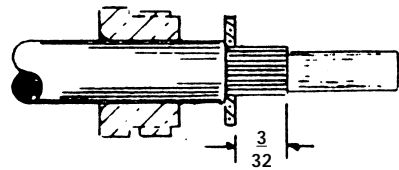
Step 1 Cut off end of cable square and remove jacket as shown. Do not nick braid.



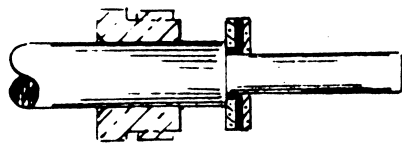
Step 2 Comb out braid.



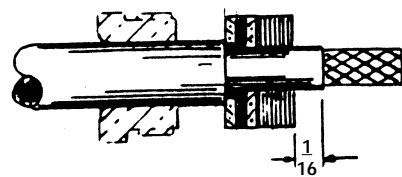
Step 3 Taper braid, slide nut over jacket. Slide washer 'A' over braid.



Step 4 Cut braid to dim. Shown. Do not nick inner jacket.

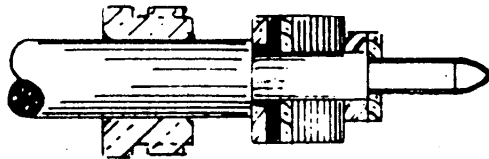


Step 5 Flare braid. Trim if necessary. Slide washer 'B' over inner jacket. Push firmly against braid and washer 'A'.

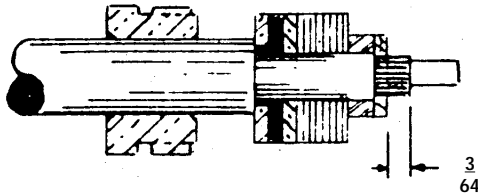


Step 6 Slide gasket over inner jacket. Push firmly into place. Trim inner jacket to dim. Shown. Do not nick braid.

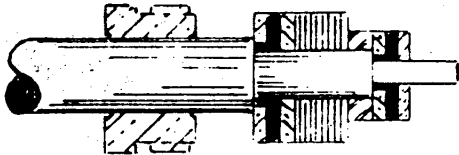
(Continued on next page)



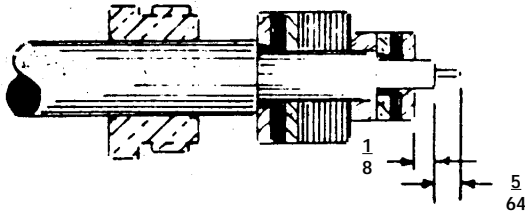
Step 7 Taper braid, slide Teflon washer over inner jacket. Slide washer 'C' over braid. Push firmly into place.



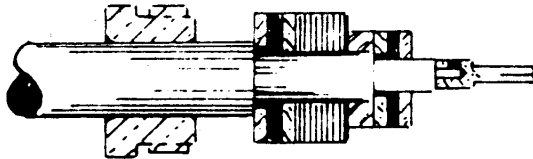
Step 8 Cut inner braid to dim. Shown. Do not cut into dielectric.



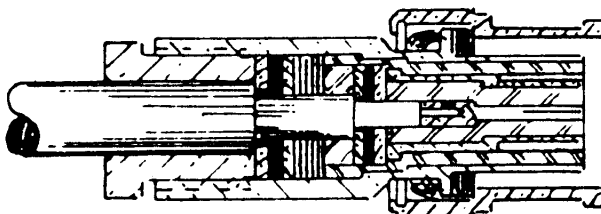
Step 9 Flare braid. Trim if necessary. Slide washer 'D' over dielectric. Push firmly into place.



Step 10 Cut dielectric and center contact to dimensions shown. Do not nick center conductor.



Step 11 Solder contact to center conductor. Remove excess solder. Do not overheat.

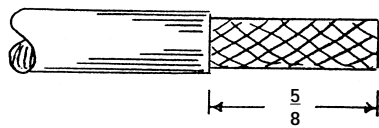
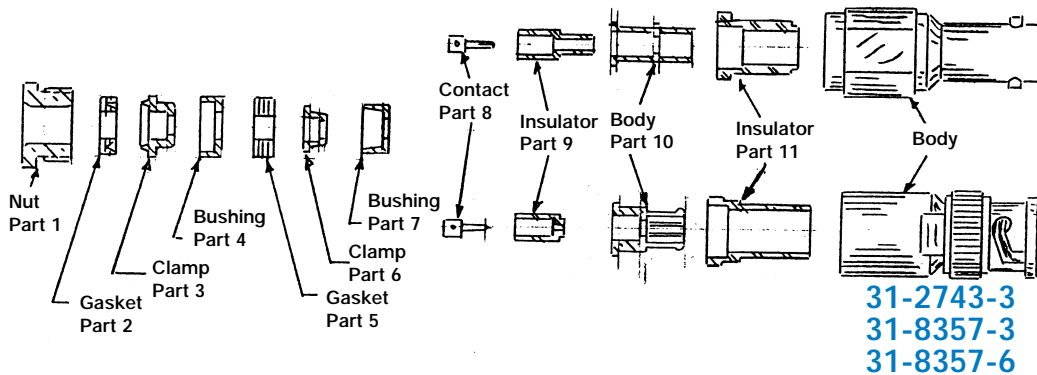


Step 12 Insert completed cable hardware into inner insulator 'E', inner body 'F', and outer insulator 'G'. Now insert completed assy. into either jack or plug body. Tighten with wrench. Do not rotate body or cable.

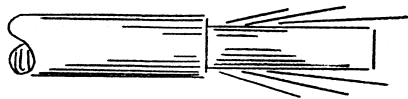
NOTE: Tighten with wrench to 20-24 in. lbs.

Assembly Instructions-C13 Triax BNC, TNC Threaded, 7/16-28

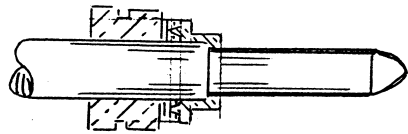
Note: For alternate Assembly instructions see sheet page 288



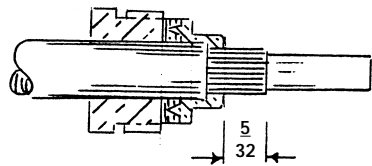
Step 1 Cut off end of cable square and remove jacket to dim. Shown. Do not nick braid.



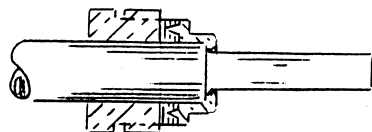
Step 2 Comb out braid.



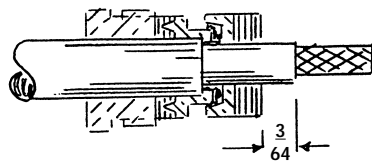
Step 3 Taper braid, slide nut, gasket, and clamp over tapered braid making sure inner shoulder of clamp is positioned tightly against end of jacket.



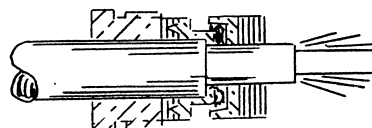
Step 4 Trim braid to dim. Shown.



Step 5 Flare back braid over clamp.

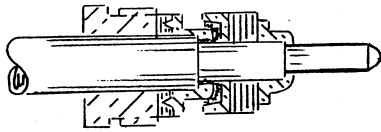


Step 6 Place part (4) and part (5) in position shown. Remove inner jacket to dim. Shown.

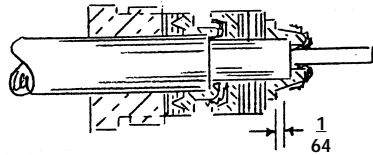


Step 7 Comb out inner braid.

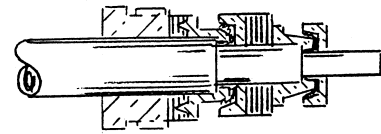
(Continued on next page)



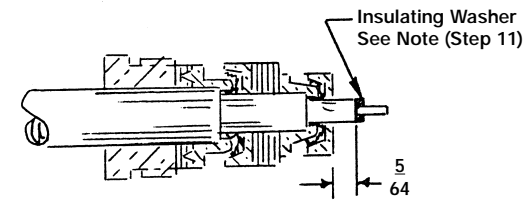
Step 8 Taper braid, slide clamp part (6) over tapered inner braid making sure inner shoulder of clamp is positioned tightly against end of inner jacket.



Step 9 Fold back inner braid over clamp and trim inner braid to dim. Shown.

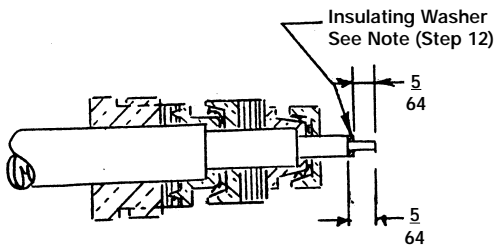


Step 10 Place small bushing part (7) in position shown. Push firmly against braid.



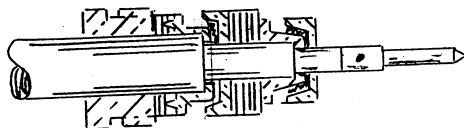
Step 11 Trim dielectric to dim. Shown. Do not nick inner conductor.

Note: For assemblies 00-8354-4, 00-8354-5, 00-8470-2 and 00-8470-3 only, trim to 1/16 in lieu of 5/64, then assemble insulating washer.

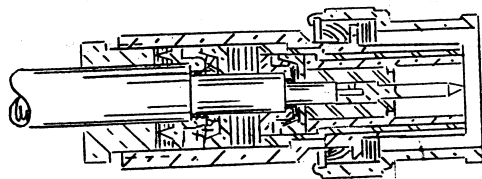


Step 12 Trim inner conductor to dim. Shown.

Note: For assemblies 00-8354-4, 00-8354-5, 00-8470-2 and 00-8470-3 only, trim inner conductor to 5/64 with insulating washer assembled.



Step 13 Solder contact on inner conductor. Remove excess solder. Do not overheat dielectric as it will distort and will not enter insulator properly.

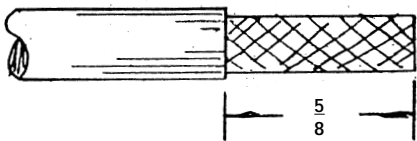
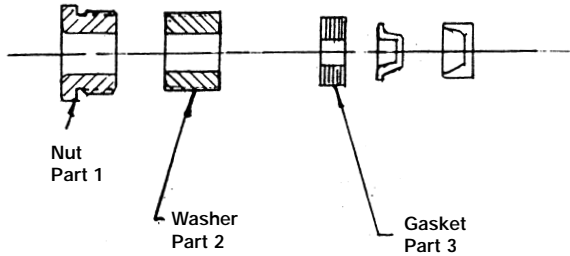


Step 14 Insert completed cable hardware assy. into either Jack or Plug body. Make sure part (2) is properly seated on sharp edge of part (3). After nut is started, tighten with torque wrench to 13 to 15 in. lbs.

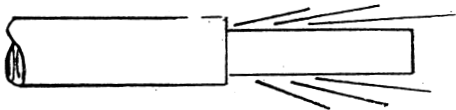
Note: Sharp edge of clamp part (3) must split gasket part (2).

ALTERNATE ASSEMBLY INSTRUCTIONS

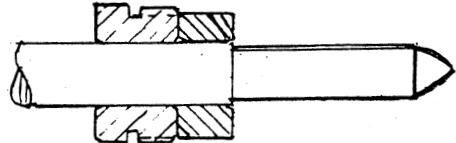
Gasket (Part #2), Clamp (Part #3) & Bushing (Part #4) is replaced by washer (Part #12).



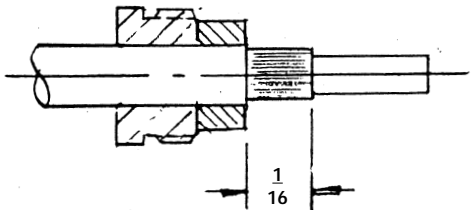
Step 1A Cut off end of cable square and remove jacket to dim's shown. Do not nick braid.



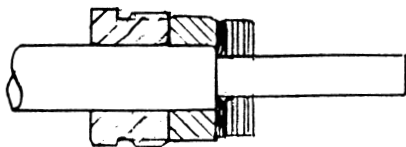
Step 2A Comb out braid.



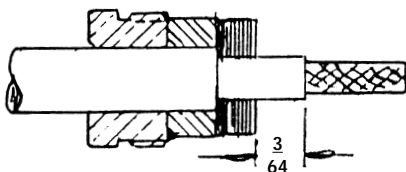
Step 3A Taper braid, slide washer over braid and jacket.



Step 4A Trim braid to dim shown.



Step 5A Flare back braid to face of washer, and place gasket in position shown.

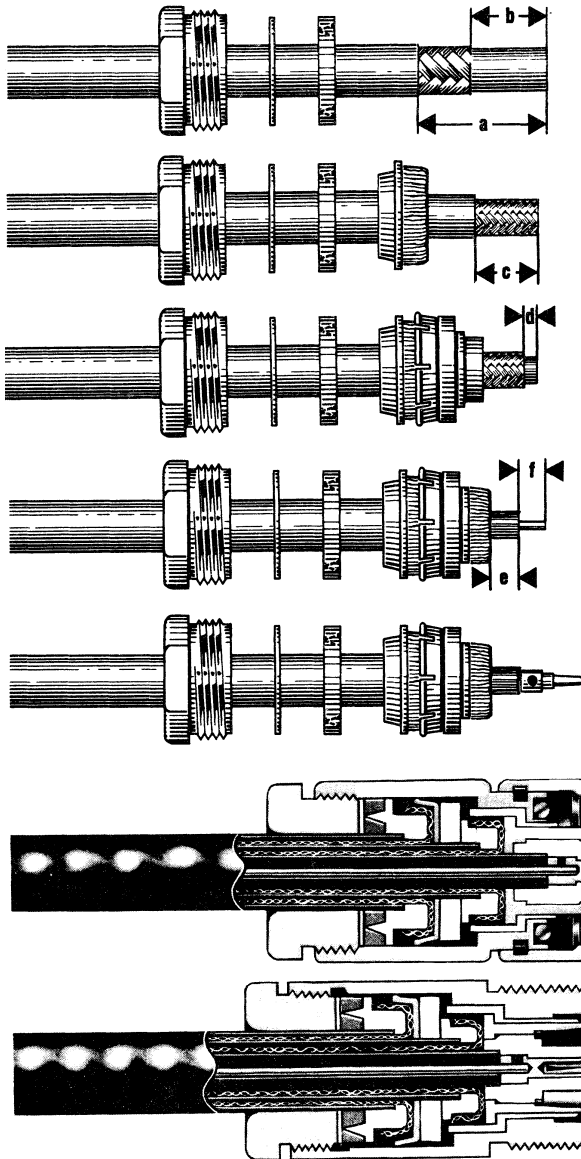
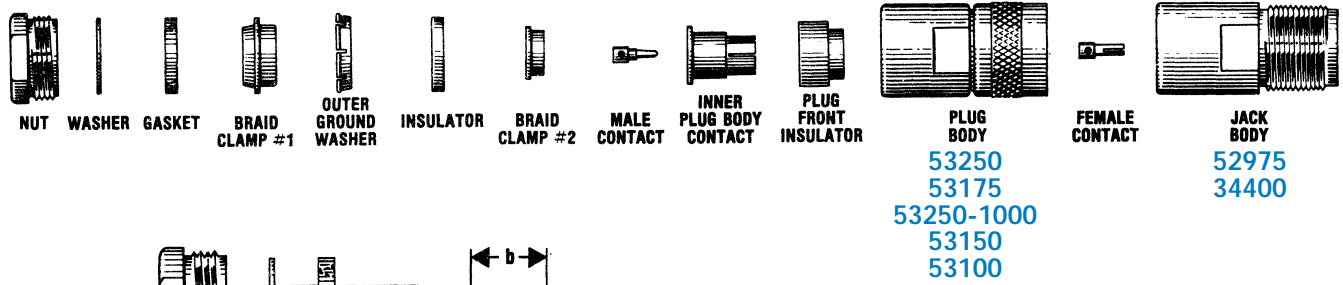


Step 6A Remove inner jacket to dim shown.

Continue as per inst. #7 of sheet page 72

Assembly Instructions-C15

Triax Threaded, 7/8-20 and 11/16-24



■ for 34400 and 34375 Jacks this dimension is .130 (3.3)

D for 53100 and 53150 Plugs this dimension is .187 (4.5)

Step 1 Slide nut, washer and gasket over cable. Cut off outside jacket (using razor blade or wire strippers) to dimension a. Make a clean cut, being very careful not to nick braid. Cut first braid to dimension b.

Step 2 Slide first braid clamp over braid up to jacket of cable. Fold first braid back over clamp, making sure braid is evenly distributed over the surface of the clamp. Trim second jacket to dimension c, again being very careful not to nick braid.

Step 3 Trim second braid to dimension d. Slide on outer ground washer insulator and second braid clamp. Fold second braid back over braid clamp, again making sure that braid is evenly distributed over surface of clamp.

Step 4 Trim cable dielectric to dimension e.

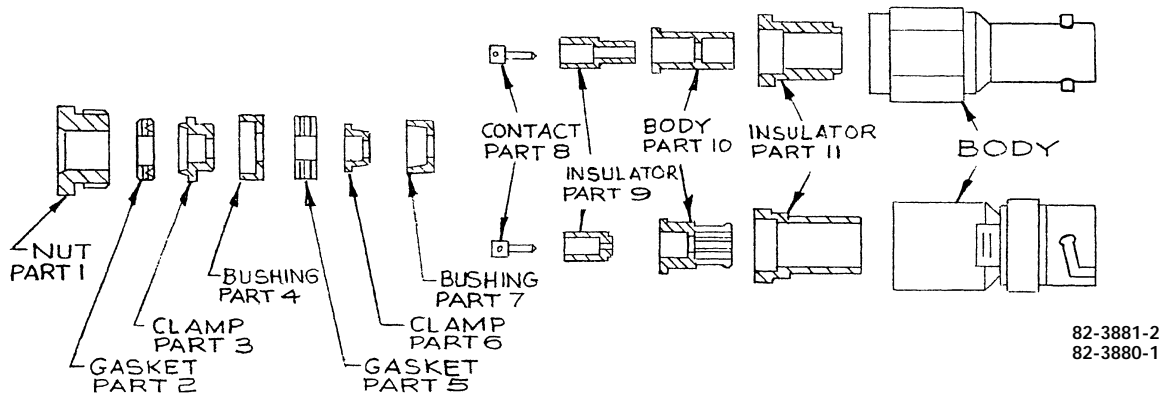
Step 5 Tin the inside hole of the contact. Tin wire and insert into contact and solder. Remove any excess solder. Be sure cable dielectric is not heated excessively and swollen so as to prevent dielectric from entering body of fitting.

Step 6 Plug only: Place front insulator and outer contact assembly into back of connector body and push into proper place. Insert cable-contact assembly into body. Screw nut into body with wrench until moderately tight.

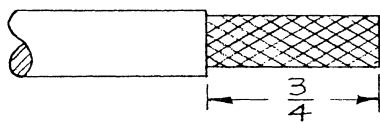
**Stripping dims. ±1/64 inches
(0.4 millimeters)**

Plugs	58A, 59 Type	8, 11 Type
a	7/8 (22.2)	15/16 (23.8)
b	19/32 (15.1)	19/32 (15.1)
c	9/16 (14.3)	15/32 (11.9)
d	11/32 (8.7)	5/16 (7.9)
e	11/32 (8.7)Δ	5/16 (7.9)
f	9/64 (3.6)	1/8 (3.2)
Jacks	58A, 59 Type	8 Type
a	19/32 (15.1)	29/32 (23.0)
b	21/64 (8.3)	19/32 (15.1)
c	19/64 (7.5)	9/16 (14.5)
d	1/4 (6.4)	5/16 (7.9)
e	1/4 (6.4) ■	5/16 (7.9)
f	3/32 (2.4)	1/8 (3.2)

Assembly Instructions-C23 Triax C Bayonet Lock

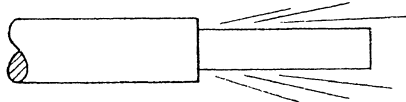


Step 1



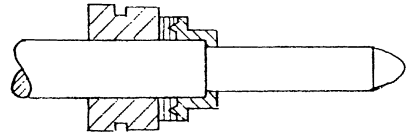
Step 1 Cut off end of cable and remove jacket to dim. shown. Do not nick braid.

Step 2



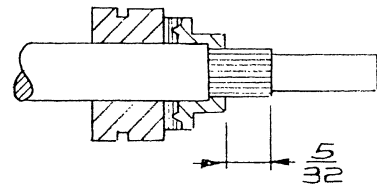
Step 2 Comb out braid.

Step 3



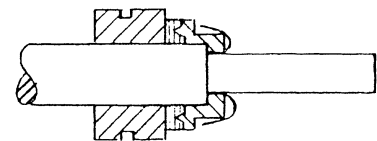
Step 3 Taper braid, slide nut, gasket and clamp over tapered braid making sure inner shoulder of clamp is positioned tightly against end of jacket.

Step 4



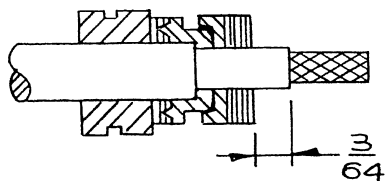
Step 4 Trim braid to dim. shown.

Step 5



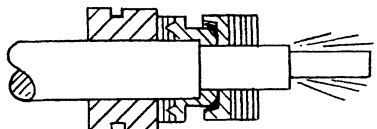
Step 5 Flare back braid over clamp.

Step 6



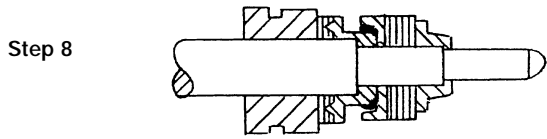
Step 6 Place part (4) and part (5) in position shown. Remove inner jacket to dim. shown.

Step 7

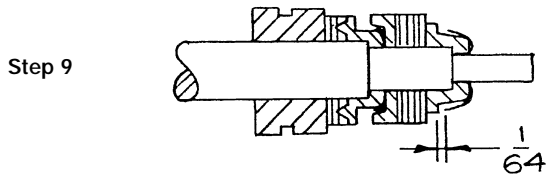


Step 7 Comb out inner braid.

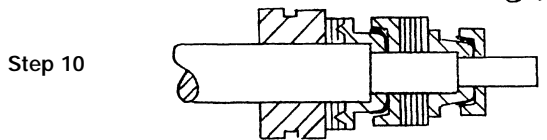
Assembly



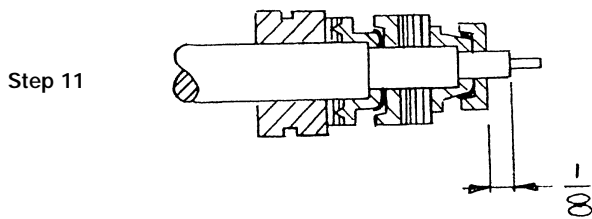
Step 8 Taper braid, slide clamp part (6) over tapered inner braid making sure inner shoulder of clamp is positioned tightly against end of inner jacket.



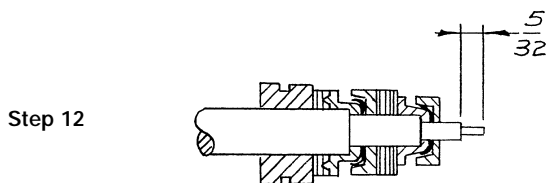
Step 9 Fold back inner braid over clamp and trim inner braid to dim. shown.



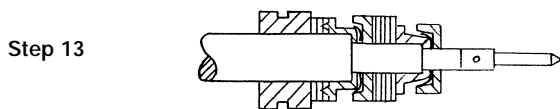
Step 10 Place small bushing part (7) in position shown. Push firmly against braid.



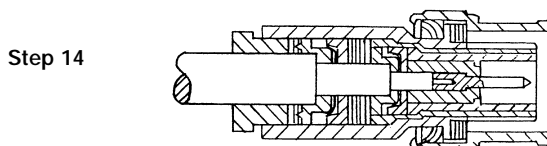
Step 11 Trim dielectric to dim. shown. Do not nick inner conductor.



Step 12 Trim inner conductor to dim. shown.



Step 13 Solder contact on inner conductor. Remove excess solder. Do not overheat dielectric as it will distort and will not enter insulator properly.



Step 14 Insert complete cable hardware assembly into either Jack or Plug body. Make sure part (2) is properly seated on sharp edge of part (3). After nut is started, tighten with torque wrench to 25 ± 5 in. lbs.

Note: Sharp edge of clamp part (3) must split gasket part (2)