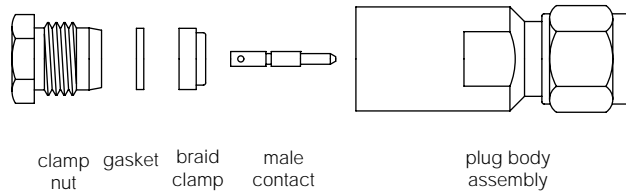
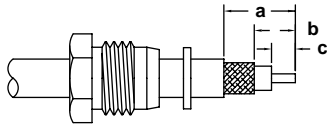


CLAMP TYPE FOR FLEXIBLE CABLES



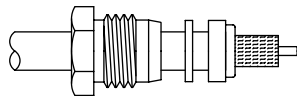
Amphenol Number	Connector Type	Cable RG-/U	Stripping Dimensions, inches (mm)		
			a	b	c
901-103	SMA Plug	55, 58, 141, 142, 223	.265(7)	.140(3.5)	.094(2.5)

Step 1



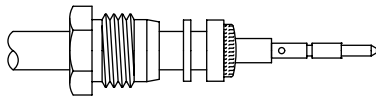
Step 1 Place nut and gasket over cable. Strip cable to dimensions shown in cable. Comb out braid.

Step 2



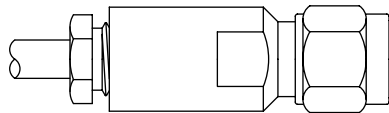
Step 2 Place braid clamp over braid and push back against cable jacket. Fold back wires, trim as necessary so that wires do not touch shoulder of clamp. Cuts must be square. Do not nick center conductor.

Step 3



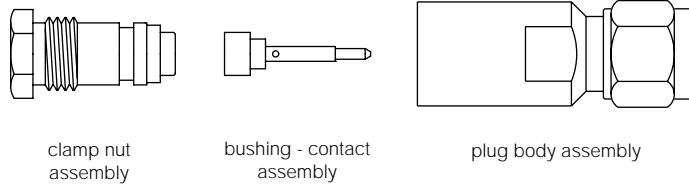
Step 3 Solder center contact to cable (SN60-40 rosin core solder recommended). Center contact must seat square against dielectric. Avoid excessive heat which may distort dielectric.

Step 4



Step 4 Thread connector assembly onto prepared cable assembly. Tighten to 20-25 in/lbs torque.

MODIFIED CLAMP TYPE FOR FLEXIBLE CABLES

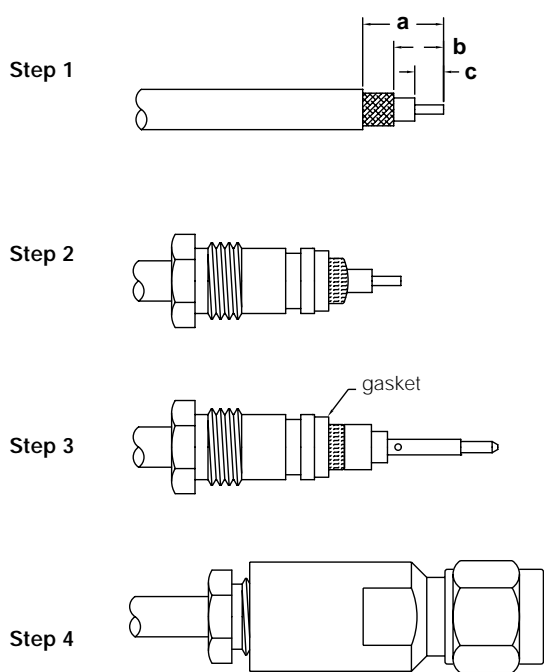


clamp nut assembly

bushing - contact assembly

plug body assembly

Amphenol Number	Connector Type	Cable RG-/U	Stripping Dimensions, inches (mm)		
			a	b	c
901-128-11	SMA Plug	174, 316	.328(14)	—	.125(3.2)



Step 1

Step 2

Step 3

Step 4

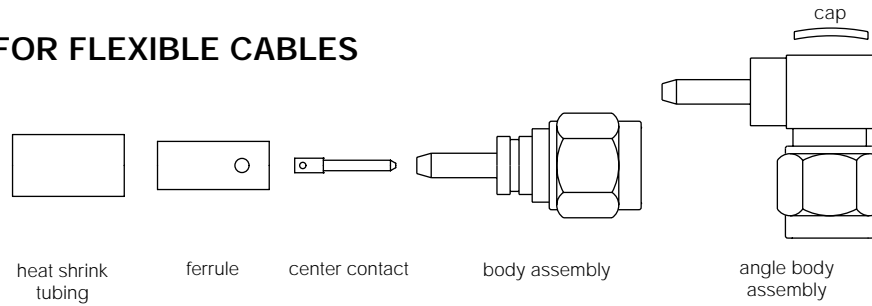
Step 1 Strip cable to dimensions shown in table. Cut must be square. Do not nick center conductor. Comb out braid.

Step 2 Place clamp assembly over braid and push back against cable jacket. Fold back braid wires, trim as necessary so that wires do not touch shoulder of gasket.

Step 3 (For angle connectors, skip to next step.) Assemble bushing assembly and solder center contact to cable (SN60-40 rosin core solder recommended.)

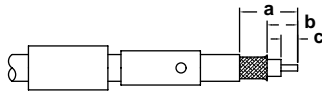
Step 4 Thread connector assembly onto prepared cable assembly. Tighten to 20-25 in/lbs torque. For angle connectors, solder center conductor and cap in place.

SOLDER TYPE FOR FLEXIBLE CABLES



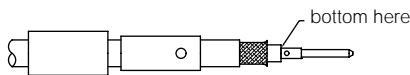
Amphenol Number	Connector Type	Cable RG-/U	Stripping Dimensions, inches (mm)		
			a	b	c
901-9501-3	SMA Plug	174, 179, 187, 188, 316	.440(11.2)	.130(3.3)	.090(2.3)
901-9521-3	SMA Angle Plug	174, 179, 187, 188, 316	.437(11.1)	.197(5.0)	.090(2.3)

Step 1

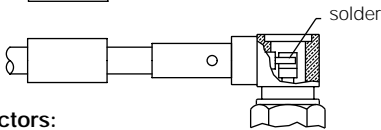


Straight connectors:

Step 2

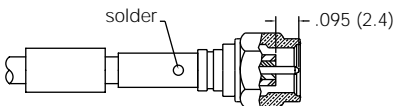


Step 3

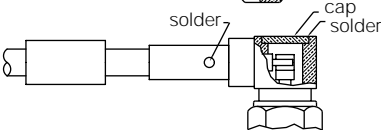


Angle connectors:

Step 2



Step 3



Step 1 Slide shrink tubing and ferrule up on cable as shown. Strip cable to dimensions shown in table. Flare cable braid.

Straight connectors:

Step 2 Solder center contact to cable center conductor as shown. Remove excess solder.

Note: Contact must bottom against cable dielectric.

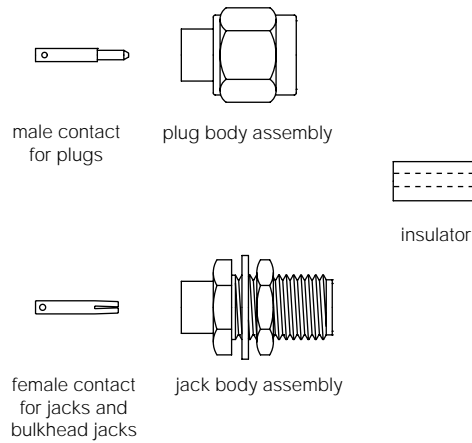
Step 3 Install coupling nut and body assembly as shown. Press ferrule against body and solder. Place heat shrink tubing over body and apply heat.

Angle connectors:

Step 2 Place cable dielectric into body and press ferrule against body as shown. Solder center conductor to contact as shown.

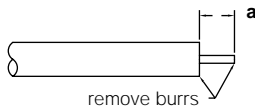
Step 3 Bottom ferrule against body and solder as shown. Place cap into position and also solder as shown. Place heat shrink tubing over body and apply heat.

SOLDER TO BODY/PRESSFIT INSULATOR FOR SEMI-RIGID CABLE



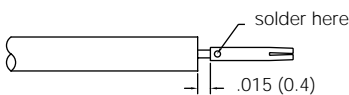
Amphenol Number	Connector Type	Cable S/R	Dim a
901-9201-2A	SMA Plug	.085(2.2)	.125(3.2)
901-9201-2ASF	SMA Plug	.085(2.2)	.125(3.2)
901-9202-1A	SMA Jack	.141(3.6)	.125(3.2)
901-9202-2A	SMA Jack	.085(2.2)	.125(3.2)
901-9210-1	SMA Bulkhead Jack	.141(3.6)	.125(3.2)
901-9210-2	SMA Bulkhead Jack	.085(2.2)	.125(3.2)
901-9867-RFX	SMA Plug	.085(2.2)	.098(2.5)
901-9868-RFX	SMA Plug	.141(3.6)	.098(2.5)

Step 1



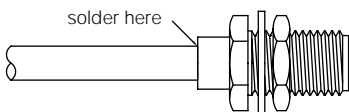
Step 1 Clean cable end for .625"(16mm) min. length. Trim cable jacket and dielectric to dimension shown. Do not nick center conductor. Remove burrs from jacket and center conductor.

Step 2



Step 2 Solder contact to center conductor. Use .015"(.4mm) shim to accurately maintain space between jacket, dielectric and contact. Remove all excess solder.

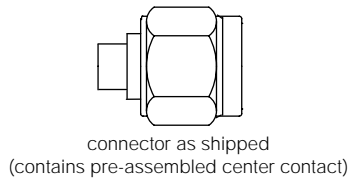
Step 3a,b



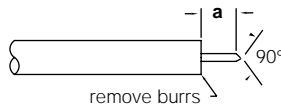
Step 3a Assemble cable and contact into connector body. Cable jacket and dielectric to be flush with shoulder of body as shown. Solder cable to connector body. Avoid excessive heat which may distort dielectric.

Step 3b Press fit insulator into connector body. Bottom insulator in connector body as shown.

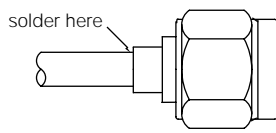
SOLDER TO BODY/PRE-ASSEMBLED CENTER CONTACT FOR SEMI-RIGID CABLE



Step 1



Step 2



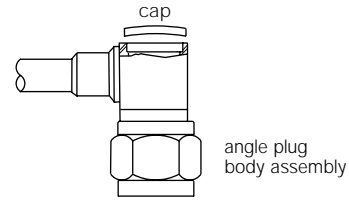
Amphenol Number	Connector Type	Cable S/R	Dim a
901-9723	SMA Plug	.085(2.2)	.125(3.2)
901-9723-10	SMA Plug	.085(2.2)	.125(3.2)
901-9805-HP	SMA Plug	.085(2.2)	.125(3.2)
901-9808	SMA Plug	.141(3.6)	.125(3.2)
901-9808-1	SMA Plug	.141(3.6)	.090(2.3)
901-9808-2	SMA Plug	.141(3.6)	.125(3.2)

Step 1 Clean cable end for .625"(16mm) min. length. Trim cable jacket and dielectric to dimension shown. Do not nick center conductor. Remove burrs from cable jacket. File blunt end of center conductor to a 90° cone.

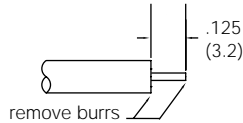
Step 2 Assemble cable into connector body. Make sure center conductor is straight. Use care in pushing center conductor into spring contact. Make sure jacket bottoms in connector. Maintain end pressure while soldering. Avoid excessive heat which may distort dielectric.

SOLDER TO BODY SMA ANGLE PLUGS

901-9221-1A, -1ASF for .141" S/R; 901-9221-2A, -2ASF for .085" S/R

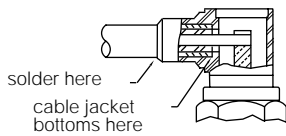


Step 1



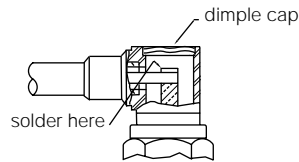
Step 1 Clean cable end for .625"(16mm) min. length. Trim cable jacket and dielectric to dimension shown. Do not nick center conductor. Remove burrs from cable jacket and center conductor.

Step 2



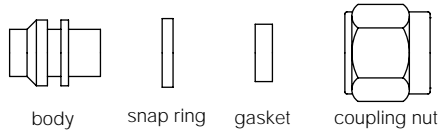
Step 2 Assemble cable into connector body. Bottom cable in connector body as shown. Solder cable to connector body as shown.

Step 3



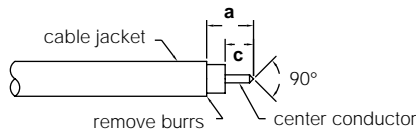
Step 3 Solder center conductor to contact as shown. Remove excess solder. Assemble cap and solder or lightly punch center of cap for retention in body.

C50-SOLDER TO BODY TYPES FOR SEMI-RIGID CABLE WITHOUT CONTACT & INSULATOR



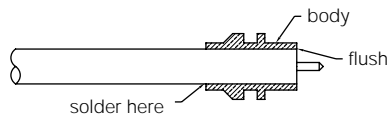
Amphenol Number	Connector Type	Cable RG-/U	Stripping Dims., inches (mm)	
			a	c
901-9201-1A	SMA Plug	.141 RG-402	.091(2.3)	—
901-9201-1ASF	SMA Plug	.141 RG-402	.091(2.3)	—

Step 1



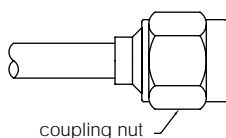
Step 1 Clean cable end for .625"(16mm) min. length. Trim cable jacket and dielectric to dimensions shown in table. Do not nick center conductor. Remove burrs from cable jacket. File blunt end of center conductor to a 90° cone.

Step 2



Step 2 Assemble cable into connector body. Cable jacket and dielectric to be flush with end of body as shown. Solder cable to connector body. Avoid excessive heat which may distort dielectric.

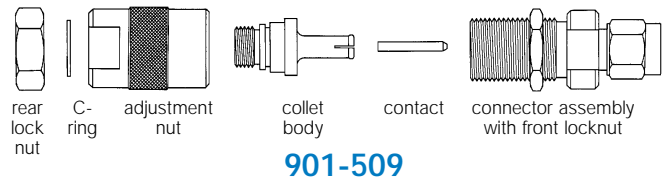
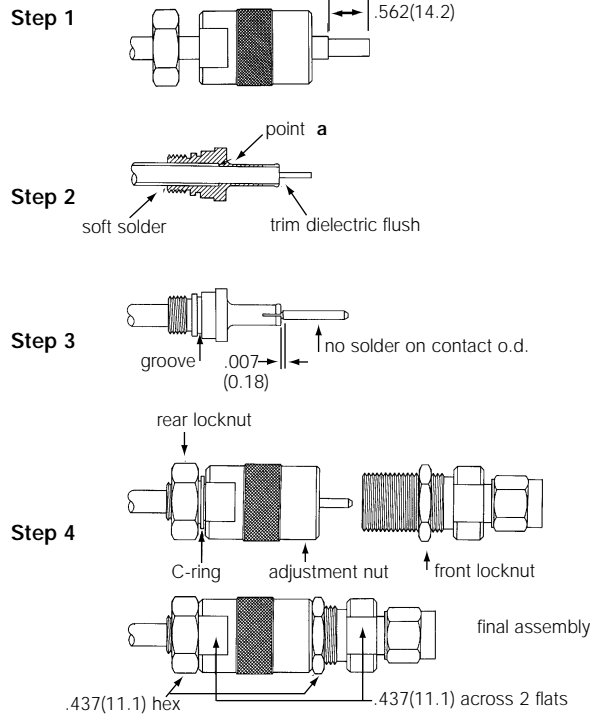
Step 3



Step 3 Assemble snap ring in groove on connector body. Assemble gasket in position as shown. Compress snap ring and assemble coupling nut as shown.

SOLDER TO COLLET METHOD FOR SEMI-RIGID CABLE

SMA Plug 901-509 for .141S/R



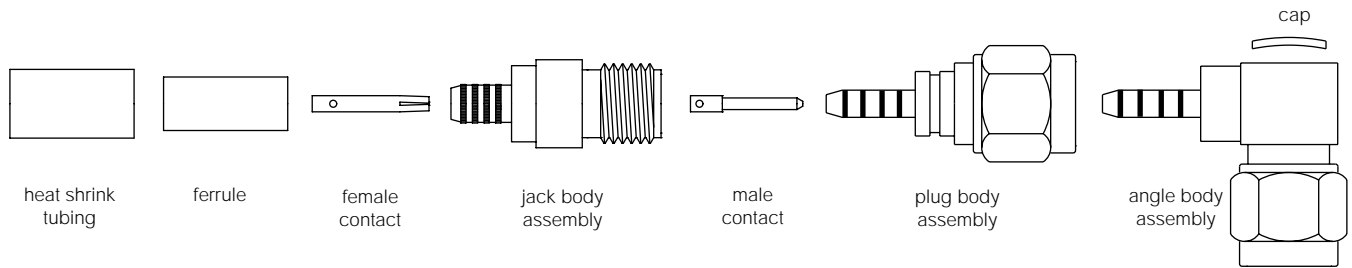
Step 1 Strip cable jacket to dimensions shown. To avoid cutting into dielectric, score cable jacket and flex slightly to break entirely through jacket. Slide rear locknut and adjustment nut onto cable.

Step 2 Insert cable into collet body and apply axial pressure to cable to assure good metal contact at Point **a**. Solder cable jacket to collet body with 60/40 solder. Trim cable jacket with tines of collet body. Do not nick cable center conductor.

Step 3 Solder contact to cable center conductor with 60/40 solder and maintain the .007 dimension shown between contact and tines. Do not permit solder on contact o.d.

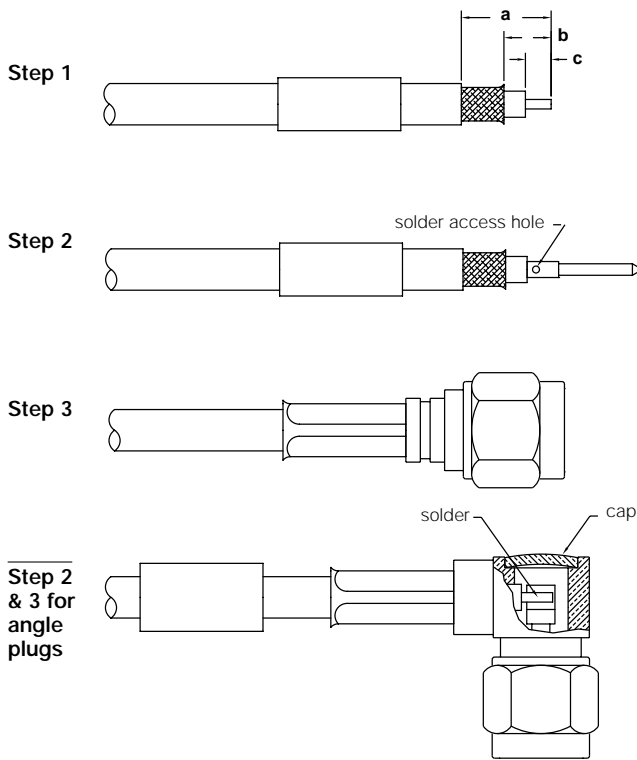
Step 4 Slide adjustment nut over collet body. Install C-ring into groove on collet body. Thread rear locknut loosely into place. Thread this assembly onto connector assembly. Make phase angle adjustment by turning adjustment nut: one revolution of nut = $[0.636 \times f(\text{GHz})]^\circ$. When desired phase angle is achieved, hold adjustment nut in place and turn the front locknut down against it. Then tighten rear locknut and assembly is complete.

CRIMP/SOLDER CENTER CONTACT TYPE FOR FLEXIBLE CABLE



Amphenol Number	Connector Type	Cable RG-U	Stripping Dimensions, inches (mm)			Hex Crimp Data		
			a	b	c	Cavity for Outer Ferrule	Die Set for Tool 227-944	CTL Series Tool
901-9511-1	SMA Plug	55, 142, 223, 400	.300(7.6)	.130(3.3)	.090(2.3)	.213(5.4)	227-1221-11	CTL-1
901-9511-1SF	SMA Plug	55, 142, 223, 400	.300(7.6)	.130(3.3)	.090(2.3)	.213(5.4)	227-1221-11	CTL-1
901-9511-2	SMA Plug	58, 141 B/YR20621	.300(7.6)	.090	.090(2.3)	.213(5.4)	227-1221-11	CTL-1
901-9511-2SF	SMA Plug	58, 141 B/YR20621	.300(7.6)	.090	.090(2.3)	.213(5.4)	227-1221-11	CTL-1
901-9531-1	SMA Angle Plug	55, 142, 223, 400	.475(12.1)	.235(6.0)	.120(3.0)	.213(5.4)	227-1221-11	CTL-1
901-9531-1SF	SMA Angle Plug	SF 142B	.475(12.1)	.235(6.0)	.120(3.0)	.213(5.4)	227-1221-11	CTL-1
901-9531-2	SMA Angle Plug	58, 141, B/YR20621	.475(12.1)	.235(6.0)	.120(3.0)	.213(5.4)	227-1221-11	CTL-1
901-9531-2SF	SMA Angle Plug	58, 141, B/YR20621	.475(12.1)	.235(6.0)	.120(3.0)	.213(5.4)	227-1221-11	CTL-1
901-9870	SMA Plug	58	.532(13.5)	.205(5.2)	.138(3.5)	.213(5.4)	227-1221-11	CTL-1
901-9871	SMA Plug	223	.532(13.5)	.205(5.2)	.138(3.5)	.213(5.4)	227-1221-11	CTL-1
901-9873	SMA Angle Plug	58	.543(13.8)	.216(5.5)	.102(2.6)	.230(5.9)	227-1221-45	CTL-1
901-9874	SMA Angle Plug	58	.543(13.8)	.216(5.5)	.102(2.6)	.213(5.4)	227-1221-11	CTL-1
901-9875	SMA Bulkhead Jack	174, 179, 187, 188, 316	.394(10.0)	.189(4.8)	.098(2.5)	.128(3.3)	227-1221-03	CTL-13.9
901-9876-RFX	SMA Plug	58	.532(13.5)	.205(5.2)	.138(3.5)	.213(5.4)	227-1221-11	CTL-1
901-9879-RFX	SMA Bulkhead Jack	174, 179, 187, 188, 316	.394(10.0)	.189(4.8)	.098(2.5)	.128(3.3)	227-1221-03	CTL-13.9
901-9880-RFX	SMA Angle Plug	58	.543(13.8)	.216(5.5)	.102(2.6)	.213(5.4)	227-1221-11	CTL-1
901-9902	SMA Angle Plug	223	.475(12.1)	.235(6.0)	.120(3.0)	.213(5.4)	227-1221-11	CTL-1
901-10009-RFX	SMA Plug	LMR 240	.406(10.3)	—	.079(2.0)	.255(6.5)	227-1221-59	CTL-1
901-10010-RFX	SMA Plug	LMR 240	.472(12)	.146(3.7)	.079(2.0)	.213(5.4)	227-1221-11	CTL-1
901-10011	SMA Plug	LMR 240	.618(15.7)	.218(5.54)	.093(2.4)	.255(6.5)	227-1221-59	CTL-1
901-10012	SMA Plug	LMR 200	.293(7.4)	—	.093(2.4)	.213(5.4)	227-1221-11	CTL-1
901-10021-1SF	Jack	55, 142, 223, 400	.415(10.5)	.155(3.9)	.115(2.9)	.213(5.4)	227-1221-11	CTL-1
901-10021-3SF	Jack	174, 188, 316	.415(10.5)	.155(3.9)	.115(2.9)	.128(3.3)	227-1221-03	CTL-13.9
901-10021-12SF	Jack	RD 316	.415(10.5)	.155(3.9)	.115(2.9)	.151(3.8)	227-1221-37	CTL-13.9
901-10024-RFX	Plug	RD 316	.430(10.9)	.170(4.2)	.100(2.5)	.151(3.8)	227-1221-37	CTL-13.9
901-10025-RFX	Plug	RD 316	.430(10.9)	.170(4.2)	.100(2.5)	.151(3.8)	227-1221-37	CTL-13.9
901-10028-RFX	SMA Angle Plug	RD 316	.417(10.6)	.212(5.4)	.106(2.7)	.151(3.8)	227-1221-37	CTL-13.9
901-10029-RFX	SMA Angle Plug	RD 316	.417(10.6)	.212(5.4)	.106(2.7)	.151(3.8)	227-1221-37	CTL-13.9
901-10013-RFX	SMA Angle Plug	174, 188, 316	.382(9.7)	.177(4.5)	.098(2.5)	.128(3.3)	227-1221-03	CTL-13.9
901-9531-3,-3SF	SMA Angle Plug	174, 179, 187, 188, 316	.475(12.1)	.235(6.0)	.090(2.3)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9872	SMA Angle Plug	174, 179, 187, 188, 316	.472(12.0)	.216(5.5)	.102(2.6)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9877-RFX	SMA Plug	174, 179, 187, 188, 316	.421(10.7)	.165(4.2)	.098(2.5)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9916	SMA Plug	174, 179, 187, 188, 316	.421(10.7)	.165(4.2)	.098(2.5)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9531-12,-12SF	SMA Angle Plug	Double Braid 316	.475(12.1)	.235(6.0)	.090(2.3)	.151(3.8)	227-1221-37 Cavity B	—
901-9881-RFX	SMA Angle Plug	174, 179, 187, 188, 316	.472(12.0)	.216(5.5)	.102(2.6)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-10014	SMA Angle Plug	LMR 240	.615(15.6)	.215(5.5)	.075(1.9)	.255(6.5)	227-1221-59 Cavity A	CTL-1

Assembly



Step 1

Step 2

Step 3

Step 2 & 3 for angle plugs

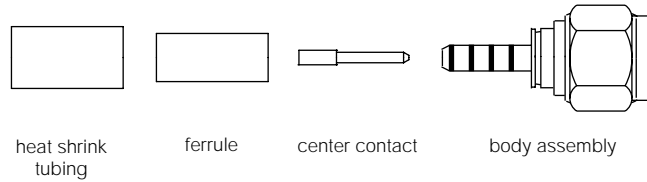
Step 1 Slide outer ferrule onto cable as shown. Strip cable jacket, braid and dielectric to dimensions shown in table. All cuts should be sharp and square. Do not nick braid, dielectric or center conductor when cutting.

Step 2 Flare end of cable braid slightly as shown to facilitate insertion onto inner ferrule. Do not comb out braid. Solder center contact to cable (SN60-40 rosin core solder recommended.) Note: Center conductor should be visible through soft solder access hole in contact, prior to soldering.

Step 3 Install body onto cable so that female portion slides under braid and insulator butts flush against cable dielectric. Slide outer ferrule over braid and up against body. Make sure no slack exists in braid. Crimp over ferrule with tool specified in table, keeping cable dielectric bottomed against insulator.

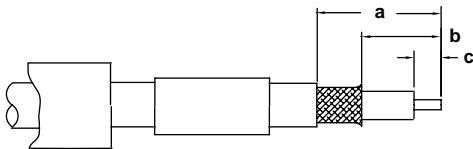
Step 2 & 3 Angle Plugs: Place cable dielectric into body and press ferrule against body as shown. Crimp with die set shown in table above. Solder cable center conductor into contact as shown. Insert cap and solder as shown or dimple and lightly punch center of cap for retention in body, for brass versions. Place heat shrink tubing over crimp ferrule, against body, and apply heat.

CRIMP-CRIMP TYPES FOR FLEXIBLE CABLE



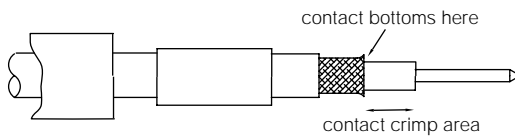
Amphenol Number	Connector Type	Cable RG-/U	Stripping Dimensions, inches (mm)			Contact Data Positioner for Tool 227-1454	Outer Ferrule Data			CTL Series Tool
			a	b	c		Positioner for M22520/1-01	Hex Cav. for Outer ferrule	Die Set for Tool 227-944	
901-101-15*	SMA Plug	142B, 400	.531(13.5)	.250(3.2)	.141(3.6)	—	/1-15	.213(5.4)	227-1221-11 Cav. A	CTL-1
901-9511-1SFC	SMA Plug	55, 58, 141, 142, 223, 400	.300(7.6)	—	.090(2.3)	227-1451-1	—	.213(5.4)	227-1221-11 Cav. A	CTL-1
901-9511-3*	SMA Plug	174, 179B,	.470(11.9)	.170(4.3)	.120(3.0)	227-1451-1	—	.128(3.3)	227-1221-03	CTL-139
901-9511-3SF*	SMA Plug	187A, 316	.470(11.9)	.170(4.3)	.120(3.0)	227-1451-1	—	.128(3.3)	227-1221-03	CTL-139
901-9511-3SFC	SMA Plug	174, 179, 187, 188, 316	.470(11.9)	.170(4.3)	.120(3.0)	227-1451-1	—	.128(3.3)	227-1221-03	CTL-139
901-9511-12SF*	SMA Plug	DbL. Br. 316	.470(11.9)	.170(4.3)	.120(3.0)	227-1451-1	—	.151(3.8)	227-1221-37 Cav. B	CTL-139
901-9511-12SFC	SMA Plug	DbL. Br. 316	.470(11.9)	.170(4.3)	.120(3.0)	227-1451-1	—	.151(3.8)	227-1221-37 Cav. B	CTL-139

Step 1



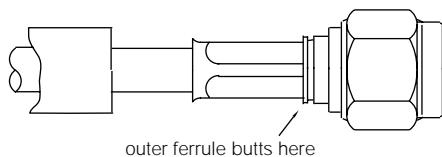
Step 1 Slide heat shrink tubing and outer ferrule onto cable. Strip cable jacket, braid and dielectric to dimensions shown in table above. All cuts are to be sharp and square. Do not nick braid, dielectric or center conductor when cutting. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule. Do not comb out braid.

Step 2



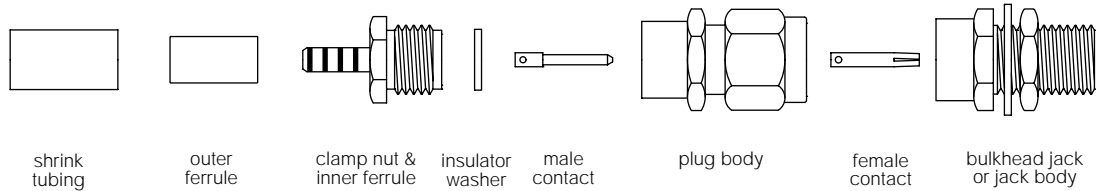
Step 2 For crimp contact type only:
Crimp center contact to cable conductor using 8-indent Tool and Positioner shown in Table above. Note: Contact must bottom against cable dielectric.
***For solder type connectors:**
Solder contact to center conductor.

Step 3



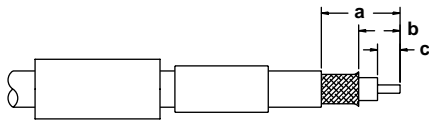
Step 3 Install inner ferrule of body assembly over cable dielectric and under braid. Place outer ferrule against body and crimp with tool 227-944 (M22520/5-01) and die set shown in table above. Place heat shrink tubing over crimp ferrule, against body, and apply heat.

BRAID CRIMP-SOLDER CENTER CONTACT TYPES FOR FLEXIBLE CABLE



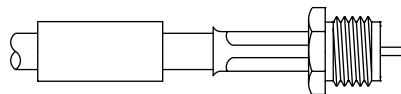
Amphenol Number	Connector Type	Cable RG-/U	Strip Dimensions, inches (mm)			Hex Cavity for Outer Ferrule	Die Set for Tool 227-944
			a	b	c		
901-9601-1SF	SMA Plug	55,58,141,142,223,400	.620(15.7)	.350(8.9)	.120(3.0)	.213(5.4)	227-1221-11 Cavity A
901-9601-3	SMA Plug	174,179,187,188,316	.620(15.7)	.350(8.9)	.120(3.0)	.128(3.3)	227-1221-03 Cavity A
901-9601-3SF	SMA Plug	174,179,187,188,316	.620(15.7)	.350(8.9)	.120(3.0)	.128(3.3)	227-1221-03 Cavity A
901-9602-1, -1SF	SMA Jack	55,58,141,142,223,400	.610(15.5)	.340(8.6)	.110(2.8)	.213(5.4)	227-1221-11 Cavity A
901-9602-3, -3SF	SMA Jack	174,179,187,188,316	.610(15.5)	.340(8.6)	.110(2.8)	.128(3.3)	227-1221-03 Cavity A
901-9602-12SF	SMA Jack	Double Braid 316	.610(15.5)	.340(8.6)	.110(2.8)	.128(3.3)	227-1221-03 Cavity A
901-9610-1SF	SMA Bulkhead Jack	55,58,141,142,223,400	.610(15.5)	.340(8.6)	.110(2.8)	.213(5.4)	227-1221-11 Cavity A
901-9610-3, -3SF	SMA Bulkhead Jack	174,179,187,188,316	.610(15.5)	.340(8.6)	.110(2.8)	.128(3.3)	227-1221-03 Cavity A
901-9610-12SF	SMA Bulkhead Jack	Double Braid 316	.610(15.5)	.340(8.6)	.110(2.8)	.151(3.8)	227-1221-37 Cavity B
901-10015	SMA Bulkhead Jack	LMR 240	4.93(12.5)	—	.043(2.4)	.255(6.5)	227-1221-59 Cavity A

Step 1



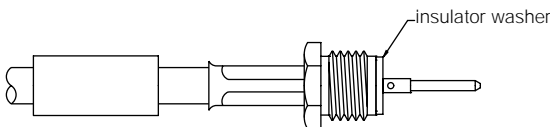
Step 1 Slide heat shrink tubing and outer ferrule onto cable. Strip cable jacket, braid and dielectric to dimensions shown in table above. All cuts are to be sharp and square. Do not nick braid, dielectric or center conductor when cutting. Tin center conductor. Avoid excessive heat to prevent swelling of cable dielectric. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule. Do not comb out braid.

Step 2



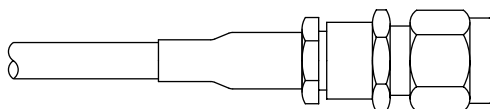
Step 2 Slide clamp nut over inner ferrule, and slide inner ferrule under braid until cable dielectric is flush with front of inner ferrule. Slide outer ferrule in place and crimp with die set shown in table above.

Step 3



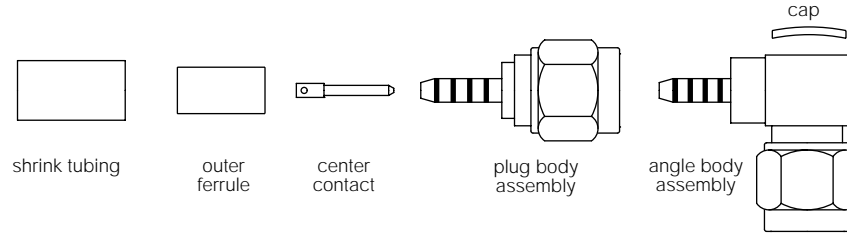
Step 3 Place insulator washer on cable center conductor and bottom against inner ferrule body as shown. Contact must butt firmly against insulator washer while soldering.

Step 4



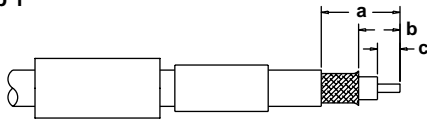
Step 4 Screw ferrule-contact assembly into body and tighten to 20-25 lbf.-in. torque. Slide heat shrink tubing over ferrule, up against clamp nut and shrink by applying heat.

BRAID CRIMP-SOLDER CENTER CONTACT TYPES FOR RG-174 & RG-179 CABLE GROUPS



Amphenol Number	Connector Type	Cable RG-/U	Stripping Dimensions, inches (mm)			Hex Cavity for Outer Ferrule	Die Set for Tool 227-944	CTL Series Tool
			a	b	c			
901-9531-3, -3SF	SMA Angle Plug	174, 179, 187, 188, 316	.475(12.1)	.235(6.0)	.090(2.3)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9872	SMA Angle Plug	174, 179, 187, 188, 316	.472(12.0)	.216(5.5)	.102(2.6)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9877	SMA Plug	174, 179, 187, 188, 316	.421(10.7)	.165(4.2)	.098(2.5)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9916	SMA Plug	174, 179, 187, 188, 316	.421(10.7)	.165(4.2)	.098(2.5)	.128(3.3)	227-1221-03 Cavity A	CTL-9
901-9531-12, -12SF	SMA Angle Plug	Double Braid 316	.475(12.1)	.235(6.0)	.090(2.3)	.151(3.8)	227-1221-37 Cavity B	—
901-9881	SMA Angle Plug	174, 179, 187, 188, 316	.472(12.0)	.216(5.5)	.102(2.6)	.128(3.3)	227-1221-03 Cavity A	CTL-9

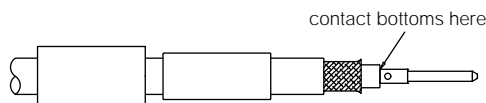
Step 1



Step 1

Slide heat shrink tubing and outer ferrule onto cable. Strip cable jacket, braid and dielectric to dimensions shown in table above. All cuts are to be sharp and square. Do not nick braid, dielectric or center conductor when cutting. Tin center conductor. Avoid excessive heat to prevent swelling of cable dielectric. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule. Do not comb out braid.

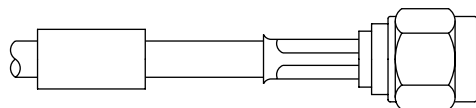
Step 2



Step 2

Solder center contact to cable center conductor as shown. Remove excess solder. **Note:** Contact must bottom against cable dielectric. (For angle plugs skip to Step 3B below.)

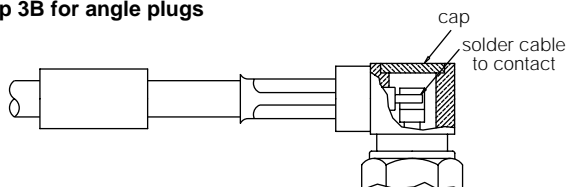
Step 3



Step 3

Install coupling nut and body assembly as shown. Place ferrule against body and crimp with die set shown in table above. Place heat shrink tubing over crimp ferrule, against body, and apply heat.

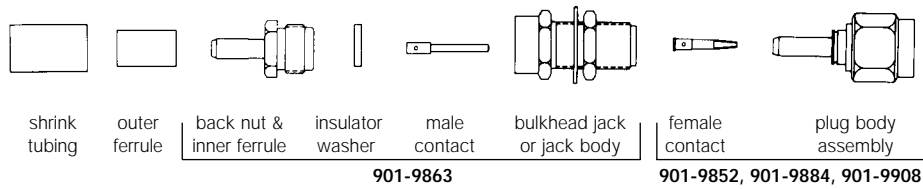
Step 3B for angle plugs



Step 3B

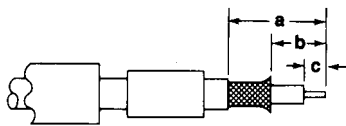
For angle plugs: Place cable dielectric into body and press ferrule against body as shown. Crimp with die set shown in table above. Solder cable center conductor into contact as shown. Insert cap and solder as shown or dimple and lightly punch center of cap for retention in body, for brass versions. Place heat shrink tubing over crimp ferrule, against body, and apply heat.

BRAID CRIMP-SOLDER CENTER CONTACT TYPES FOR FLEXIBLE CABLE



Amphenol Number	Connector Type	Cable RG-/U	Strip Dimensions, inches (mm)			Hex Cavity for Outer Ferrule	Die Set for Tool 227-944
			a	b	c		
901-9884	Plug	55, 142, 223, 400	.480 (12.2)	.250 (6.4)	.140 (3.6)	.213 (5.4)	227-1221-11 Cavity A
901-9852	Plug	174,179,187,188,316	.500 (12.7)	.260 (6.6)	.150 (3.8)	.128 (3.3)	227-1221-3 Cavity A
901-9863	Bulkhead Jack	174,179,187,188,316	.610 (15.5)	.340 (8.6)	.110 (2.8)	.128 (3.3)	227-1221-3 Cavity A
901-9908	Angle Plug	223	.475 (12.1)	.235 (6.0)	.120 (3.0)	.213 (5.4)	227-1221-11 Cavity A
901-9990	Bulkhead Jack	178, 196	.255 (6.5)	.105 (2.67)	.075 (1.8)	.105 (2.67)	227-1221-03 Cavity B

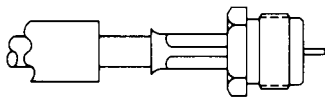
Step 1



Step 1 Slide heat shrink tubing and outer ferrule onto cable. Strip cable jacket, braid and dielectric to dimensions shown in table above. All cuts are to be sharp and square. Do not nick braid, dielectric or center conductor when cutting. Tin center conductor. Avoid excessive heat to prevent swelling of cable dielectric. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule. Do not comb out braid.

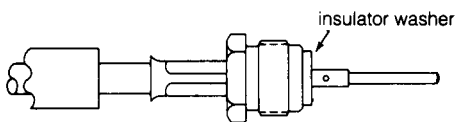
For 901-9863 RP-Bulkhead Jack

Step 2



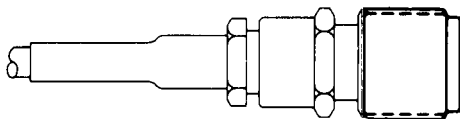
Step 2 Slide clamp nut over inner ferrule, and slide inner ferrule under braid until cable dielectric is flush with front of inner ferrule. Slide outer ferrule in place and crimp with die set shown in table above.

Step 3



Step 3 Place insulator washer on cable center conductor and bottom against inner ferrule body as shown. Contact must butt firmly against insulator washer while soldering.

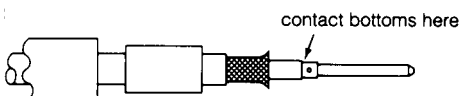
Step 4



Step 4 Screw ferrule-contact assembly into body and tighten to 20-25 lbf.-in. torque. Slide heat shrink tubing over ferrule, up against clamp nut and shrink by applying heat.

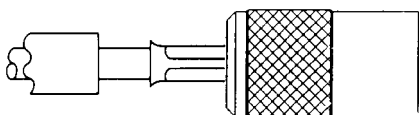
For 901-9884, 901-9852, 901-9908 RP Plugs

Step 2



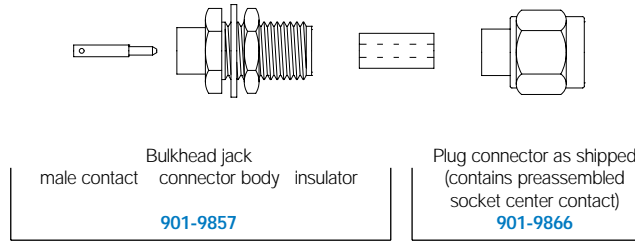
Step 2 Solder center contact to cable center conductor as shown. Remove excess solder. Note: Contact must bottom against cable dielectric.

Step 3

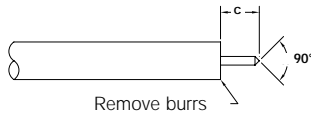


Step 3 Install coupling nut and body assembly as shown. Place ferrule against body and crimp with die set shown in table above. Place heat shrink tubing over crimp ferrule, against body, and apply heat.

SOLDER TYPES FOR .141" SEMI-RIGID CABLE



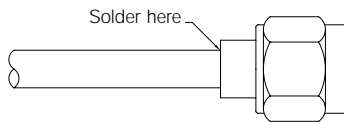
Step 1



Step 1

Clean cable end for .625"(16mm) min. length. Trim cable jacket and dielectric to $c = .090(2.3)$ for 901-9866 or $c = .125(3.2)$ for 901-9857. Do not nick center conductor. Remove burrs from cable jacket and center conductor. For 901-9866, file blunt end of center conductor to a 90° cone.

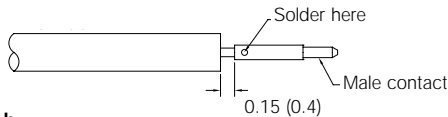
Step 2 for 901-9866 RP-Plug



Step 2

For 901-9866 assemble cable into connector body. Make sure center conductor is straight. Use care in pushing center conductor into spring contact. Make sure jacket bottoms in connector. Maintain end pressure while soldering. Avoid excessive heat which may distort dielectric.

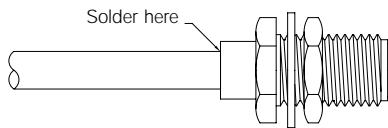
Step 2 for 901-9857 RP-Bu



Step 2

For 901-9857 solder contact to center conductor. Use .015"(.4mm) shim to accurately maintain space between jacket, dielectric and contact. Remove all excess solder.

Step 3a, b



Step 3a

Assemble cable and contact into connector body. Cable jacket and dielectric to be flush with shoulder of body as shown. Solder cable to connector body. Avoid excessive heat which may distort dielectric.

Step 3b

Press fit insulator into connector body. Bottom insulator in connector body as shown.