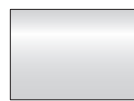


Crimp instructions for Amphenol N plugs

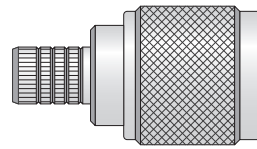
Amphenol Number	Connector Type	Cable RG-U	Strip Dimensions, inches (mm)			Hex Crimp Data	
			a	b	c	Cavity for Contact	Cavity for Outer Ferrule
82-332	N Plug	9, 214	.531(13.5)	.234(6.0)	.140(3.5)	.100(2.5)	.429(10.9)
82-340	N Plug	8, 213	.531(13.5)	.234(6.0)	.141(3.6)	.100(2.5)	.429(10.9)
82-340-1052	N Plug	B9913, 9914	.539(13.7)	.250(6.4)	.158(4.0)	.116(2.9)	.429(10.9)
82-340-1054	N Plug	LMR 400	.539(13.7)	.250(6.4)	.157(4.0)	.116(2.9)	.429(10.9)
82-4425	N Plug	9, 214, 225, 393	.687(17.4)	.281(7.1)	.187(4.7)	.100(2.5)	.429(10.9)
82-4425-1003	N Plug	9, 214, 225, 393	.687(17.4)	.281(7.1)	.187(4.7)	.100(2.5)	.429(10.9)
82-4426	N Plug	8, 213	.687(17.4)	.281(7.1)	.187(4.7)	.100(2.5)	.429(10.9)
82-4426-11RFX	N Plug	8, 213, 214 Eth.Cables	.630(16.0)	.303(7.7)	.157(4.0)	.100(2.5)	.429(10.9)
82-5375	N Plug	58, 141	.531(13.5)	.233(5.9)	.140(3.5)	.100(2.5)	.213(5.4)
82-5993	N Plug	LMR 600	.844(21.4)	.344(8.7)	.250(6.4)	.176(4.5)	.612(15.5)



Outer ferrule

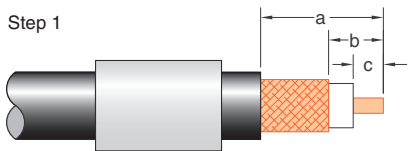


Contact



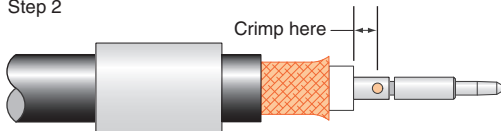
Body assembly

Step 1



Step 1 Strip cable jacket, braid, and dielectric to dimensions shown. 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.

Step 2

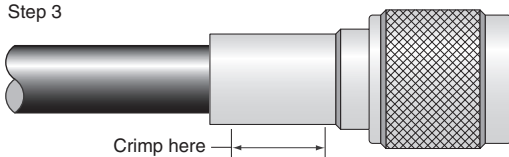


Step 2 Slide outer ferrule onto cable as shown. Flare slightly end of cable braid as shown to facilitate insertion of inner ferrule. Important: Do not comb out braid. Place contact on cable center conductor so it butts against cable dielectric. Center conductor should be visible through inspection hole in contact. Crimp or solder contact in place as follows:

Crimp Method: Use Die Set Cavity for contact indicated in table above.

Solder Method: Soft solder contact to cable center conductor. Do not get any solder on outside surface of contact. Avoid excessive heat to prevent swelling of dielectric.

Step 3



Step 3 Install cable assembly into body assembly so 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 specified in table above.

HBK0605