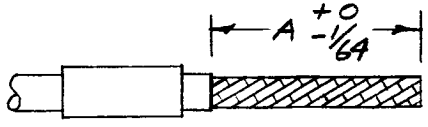
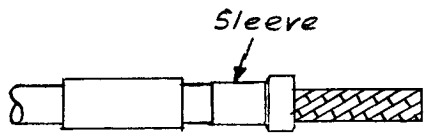


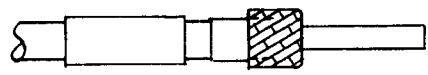
1. Dilate boot and slip over cable.



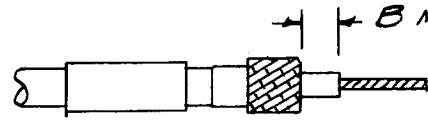
2. Trim jacket to dimension A (See Chart, Pg. 2). Be careful not to nick braid.



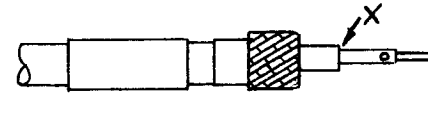
3. Slip sleeve over braid and against cable jacket.



4. Fold braid back over sleeve and comb out braid (as shown) to avoid bunching.

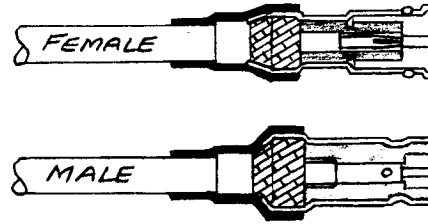


5. Trim dielectric to dimension B (see table, page 2). Tin center conductor and remove excess solder.

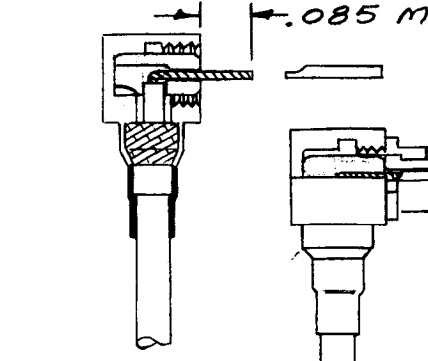


(For Straight Plugs & Jacks)

6. Solder contact to inner conductor. Avoid excessive solder and overheating. Contact must butt insulator at point X to prevent it from protruding beyond insulator edge.



7. Slip cable assembly into body and trim off all excess braid protruding beyond body end. Crimp securely and slip boot back over body as shown. Note: Before crimping make certain contact does not protrude beyond insulator surface. (See chart, Pg. 2 for crimping tool)



8. Angle Plugs. Thread cable through connector as shown and crimp with proper tool. Thread female insulator onto center conductor and insert into connector. With insulator held down make certain cable is pulled as far forward as possible to remove all slack. Trim center conductor to dimension shown. Tin center conductor and remove excess solder. Solder contact to center conductor making certain contact butts insulator.

CONNECTOR ASSEMBLY INSTRUCTIONS

SERIES 27

Pg. 1

Pg. 2



1. Dilate boot and slip over 50 or 75 ohm cable.

2. Trim jacket to dimension A (See ~~chart~~ *chart Pg. 1*). Be careful not to nick braid.

3. Slip sleeve over braid and against cable jacket. Fold braid back over sleeve and comb out braid (as shown) to avoid bunching.

5. Trim dielectric to dimension B (see table at right). Tin center conductor and remove excess solder.

6. ~~Strip dielectric and conductors.~~ *Strip dielectric and conductors. Avoid excessive solder to prevent overheating of conductors.* Solder contact to inner conductor. Contact must butt insulator at point X to prevent contact from protruding beyond insulator *edge*.

7. Slip cable assembly into body and trim off all excess braid protruding beyond body end. Crimp securely and slip boot back over body as shown. Note: Before crimping make certain contact does not protrude beyond insulator surface.

8. Angle Plugs. Thread cable through connector as shown and crimp with proper tool, ~~as shown in illustration.~~ *as shown in illustration.* Insert female insulator onto center conductor and certain cable is pulled as far forward as possible to remove all slack. Trim center conductor to dimension shown. Tin center conductor and remove excess solder. Solder contact to center conductor making certain contact butts insulator.

Place male insulator on contact and insert into body. Screw body into connector as shown and tighten with end wrench.

Part No.	A	B	Plier	Cables
27-1	3/4	1/4	27-900	21-596 21-598*
27-2	3/8	1/4	27-900	21-596 21-598*
27-4	3/8	.082	27-900	21-596 21-598*
27-6	3/4	3/4	27-900	21-596 21-598*
27-7	3/4	1/4	27-900	21-596 21-598*
27-8	3/8	.082	27-900	21-596 21-598*
27-10	3/8	.082	27-900	21-596 21-598*
27-13	3/8	.082	27-901	21-597
**27-14	3/8	.082	27-901	21-597
27-16	3/8	.082	27-901	21-597
27-18	3/4	3/4	27-901	21-597
27-19	3/8	.082	27-901	21-597
27-20	3/8	.082	27-901	21-597
27-22	3/8	.082	27-901	21-597
27-25	3/4	3/4	27-901	21-597
27-26	3/4	3/4	27-900	21-596 21-598*

**This connector uses plier No. 27-901 & plug No. 27-902 to crimp cable (See illustration). *RG-174/U

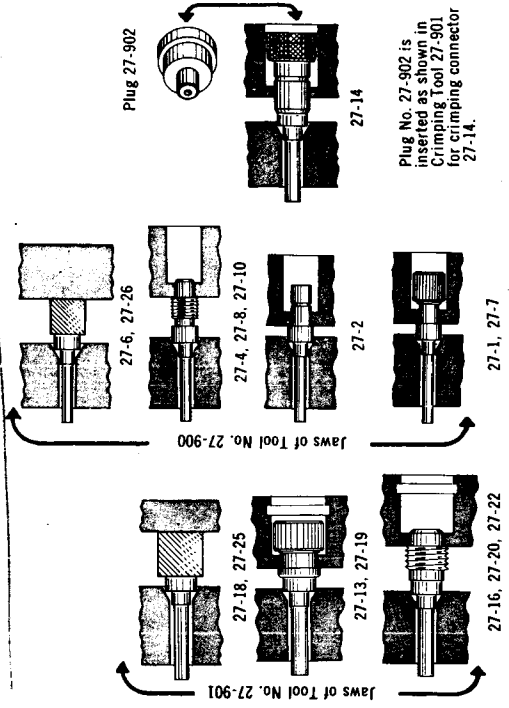
CRIMPING TOOLS



Subminax connectors should be placed in the jaws of their respective Crimping Tools as illustrated below for completing cable assembly.

NOTE: Each Crimping Tool, 27-900 and 27-901 has only one set of jaws; the four illustrations of 27-900, for example, are of the same jaws but with different connector placement.

NOTE: Because of the high pressures that can be applied in crimping, pre-set crimping jaw travel-limit-screw to limit that will produce secure crimp for each connector group without connector deformation.



Plug No. 27-902 is inserted as shown in Crimping Tool 27-901 for crimping connector 27-14.

