



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>GENERAL CONDITIONS FOR THE ASSEMBLY OF COAX CONNECTORS</u>	2
A. Applicable Conditions for the Preparation of Coax Cable	2
B. Applicable Conditions for the Assembly of Coax Contacts	2
C. Applicable Conditions for the Assembly of Coax Connectors	3
2. <u>COAX CABLE REPAIR</u>	3
A. Coax Connectors for a Coax Cable Splice	3
3. <u>INSTALLATION OF COAX CONNECTORS</u>	17

20-51-00



707, 727-787 STANDARD WIRING PRACTICES MANUAL

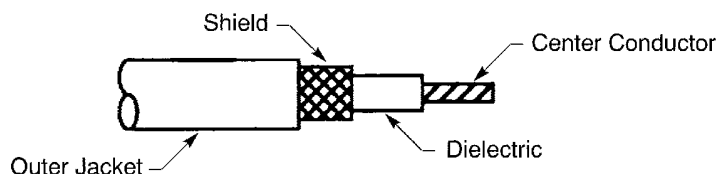
ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

This Subject gives:

- The general conditions for the preparation and assembly of connectors and contacts with coax cable
- The coax jack and plug connectors for the splice of coax cable.

1. GENERAL CONDITIONS FOR THE ASSEMBLY OF COAX CONNECTORS

A. Applicable Conditions for the Preparation of Coax Cable



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USUAL CONFIGURATION OF A COAX CABLE

Figure 1

NOTE: Cable preparation dimensions are very important and the specified tolerances must be obeyed.

These conditions are applicable:

- The ends of the outer jacket and the dielectric must be perpendicular to the longitudinal axis of the cable
- The ends of the outer jacket and the dielectric must be smooth and symmetrical to have the correct fit in the contact or the connector
- The outer jacket and the dielectric must not have damage after the specified length of the outer jacket is removed
- The shield must not have damage after the specified length of the outer jacket is removed
- The conductor must not have damage after the specified length of the dielectric is removed.

In order to prepare a cable that agrees with the applicable conditions, it is necessary to use the correct tools that do not cause deformation of the cable.

B. Applicable Conditions for the Assembly of Coax Contacts

These conditions are applicable for the assembly of all coax contacts:

- The end of the contact must be against the end of dielectric of the cable
- Before the contact is soldered or crimped, the conductor must be in the correct position in the crimp barrel or the solder barrel of the contact
- The conductor is in the correct position in the crimp barrel or the solder barrel of the contact when the conductor can be seen in the inspection hole of the contact.

These conditions are applicable for the assembly of solder type coax contacts:

- Solder must be applied with only the necessary amount of heat for the solder to flow
- Flux and unwanted solder must be removed from the outer surface of the contact.

20-51-00



707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

CAUTION: MORE THAN THE NECESSARY AMOUNT OF HEAT CAN CAUSE DAMAGE TO THE DIELECTRIC OF THE CABLE OR THE COAX CONTACT.

C. Applicable Conditions for the Assembly of Coax Connectors

These general conditions are applicable:

- The different components of the connector must be correctly aligned and in the correct position
- If a connector that has a vee gasket is disassembled, a new vee gasket must be installed when the connector is assembled again.

Connector assemblies must be tested for:

- Continuity
- Short circuits
- Unwanted grounds
- Insulation resistance.

NOTE: The minimum, acceptable insulation resistance is 100 megohms.

A connector that is not connected must have one of these seals for protection:

- A metallic cap that engages the connector coupling mechanism
- A plastic cap that has a tight fit
- A polyethylene bag that is held in position with a wire harness tie.

2. COAX CABLE REPAIR

For the applicable damage conditions and repair conditions of coax cables, refer to Subject 20-10-13.

A. Coax Connectors for a Coax Cable Splice

Table 1
APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
09-026	BNC	In-Line Jack	KC-39-31	Subject 20-51-11
		Straight Plug	KC-59-96	Subject 20-51-11

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
09-058	BNC	In-Line Jack	KC-39-108	Subject 20-51-15
			KC-39-20	Subject 20-51-11
		Straight Plug	KC-59-411	Subject 20-51-15
			KC-59-61	Subject 20-51-11
	C	In-Line Jack	KD-19-45	Subject 20-51-11
		Straight Plug	KD-59-130	Subject 20-51-16
			KD-59-161	Subject 20-51-15
			KD-59-44	Subject 20-51-11
			KD-59-55	Subject 20-51-11
	N	In-Line Jack	KN-39-21	Subject 20-51-11
		Straight Plug	KN-59-247	Subject 20-51-15
	TNC	In-Line Jack	KA-39-12	Subject 20-51-11
			KA-39-82	Subject 20-51-15
		Straight Plug	KA-59-277	Subject 20-51-15
			KA-59-29	Subject 20-51-11
10-008	C	In-Line Jack	KD-39-08	Subject 20-51-11
			KD-39-42	Subject 20-51-15
		Straight Plug	KD-59-163	Subject 20-51-15
			KD-59-33	Subject 20-51-11
			KD-59-38	Subject 20-51-11
	HN	In-Line Jack	KH-39-11	Subject 20-51-11
			KH-39-21	Subject 20-51-15
		Straight Plug	KH-59-19	Subject 20-51-11
			KH-59-63	Subject 20-51-15
	N	In-Line Jack	KN-39-19	Subject 20-51-11
		Straight Plug	KN-59-18	Subject 20-51-11
			KN-59-261	Subject 20-51-15
			KN-59-46	Subject 20-51-11
5012H3012	N	In-Line Jack	KN-39-114-M06	Subject 20-51-15
		Straight Plug	KN-59-330-M06	Subject 20-51-15
5026A1018	KM	In-Line Jack	KM-19-08	Subject 20-51-15
		Straight Plug	KM-59-18	Subject 20-51-15
			KM-59-31	Subject 20-51-15
			KM-59-41	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
5026A1314	KM	In-Line Jack	KM-19-08	Subject 20-51-15
		Straight Plug	KM-59-18	Subject 20-51-15
			KM-59-31	Subject 20-51-15
			KM-59-41	Subject 20-51-15
5026A1318	KM	In-Line Jack	KM-19-08	Subject 20-51-15
		Straight Plug	KM-59-18	Subject 20-51-15
			KM-59-31	Subject 20-51-15
			KM-59-41	Subject 20-51-15
AA-1500	BNC	In-Line Jack	KC-39-110	Subject 20-51-15
			KC-39-48	Subject 20-51-11
		Straight Plug	KC-59-177	Subject 20-51-11
			KC-59-267	Subject 20-51-15
	C	In-Line Jack	KD-39-21	Subject 20-51-11
			KD-39-28	Subject 20-51-15
		Straight Plug	KD-59-125	Subject 20-51-15
			KD-59-94	Subject 20-51-11
	N	In-Line Jack	KN-39-48	Subject 20-51-11
		Straight Plug	KN-39-72	Subject 20-51-15
			KN-59-128	Subject 20-51-11
			KN-59-185	Subject 20-51-15
	TNC	In-Line Jack	KA-39-32	Subject 20-51-11
			KA-39-83	Subject 20-51-15
		Straight Plug	KA-59-188	Subject 20-51-15
			KA-59-98	Subject 20-51-11
AA-2831	N	In-Line Jack	1203-13-9	Subject 20-51-15
		Straight Plug	1205-31-9	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
BA13077A	BNC	In-Line Jack	KC-39-110	Subject 20-51-15
			KC-39-48	Subject 20-51-11
		Straight Plug	KC-59-177	Subject 20-51-11
			KC-59-267	Subject 20-51-15
	C	In-Line Jack	KD-39-21	Subject 20-51-11
			KD-39-28	Subject 20-51-15
		Straight Plug	KD-59-125	Subject 20-51-15
			KD-59-94	Subject 20-51-11
	N	In-Line Jack	KN-39-48	Subject 20-51-11
		Straight Plug	KN-39-72	Subject 20-51-15
			KN-59-128	Subject 20-51-11
			KN-59-185	Subject 20-51-15
	TNC	In-Line Jack	KA-39-32	Subject 20-51-11
			KA-39-83	Subject 20-51-15
		Straight Plug	KA-59-188	Subject 20-51-15
			KA-59-98	Subject 20-51-11
BA14349	BNC	In-Line Jack	KC-39-110	Subject 20-51-15
			KC-39-48	Subject 20-51-11
		Straight Plug	KC-59-177	Subject 20-51-11
			KC-59-267	Subject 20-51-15
	C	In-Line Jack	KD-39-21	Subject 20-51-11
			KD-39-28	Subject 20-51-15
		Straight Plug	KD-59-125	Subject 20-51-15
			KD-59-94	Subject 20-51-11
	N	In-Line Jack	KN-39-48	Subject 20-51-11
		Straight Plug	KN-39-72	Subject 20-51-15
			KN-59-128	Subject 20-51-11
			KN-59-185	Subject 20-51-15
	TNC	In-Line Jack	KA-39-32	Subject 20-51-11
			KA-39-83	Subject 20-51-15
		Straight Plug	KA-59-188	Subject 20-51-15
			KA-59-98	Subject 20-51-11

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
BA5903	BNC	In-Line Jack	KC-39-108	Subject 20-51-15
			KC-39-20	Subject 20-51-11
		Straight Plug	KC-59-383	Subject 20-51-15
			KC-59-411	Subject 20-51-15
			KC-59-61	Subject 20-51-11
	C	In-Line Jack	KD-19-45	Subject 20-51-11
		Straight Plug	KD-59-130	Subject 20-51-16
			KD-59-161	Subject 20-51-15
			KD-59-44	Subject 20-51-11
			KD-59-55	Subject 20-51-11
	N	In-Line Jack	KN-39-21	Subject 20-51-11
		Straight Plug	KN-59-247	Subject 20-51-15
			KN-59-369-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	KA-39-12	Subject 20-51-11
			KA-39-15	Subject 20-51-11
			KA-39-82	Subject 20-51-15
		Straight Plug	KA-59-128	Subject 20-51-11
			KA-59-277	Subject 20-51-15
			KA-59-29	Subject 20-51-11
			KA-59-438-M06	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
BA6903	C	In-Line Jack	KD-39-09	Subject 20-51-11
			KD-39-37	Subject 20-51-15
		Straight Plug	KD-59-164	Subject 20-51-15
			KD-59-165	Subject 20-51-15
			KD-59-201	Subject 20-51-15
			KD-59-201-M06	Subject 20-51-15
			KD-59-41	Subject 20-51-11
			KD-59-42	Subject 20-51-11
			KD-59-64	Subject 20-51-15
	HN	In-Line Jack	KH-19-12	Subject 20-51-11
			KH-39-12	Subject 20-51-11
			KH-39-22	Subject 20-51-15
		Straight Plug	KH-59-21	Subject 20-51-11
			KH-59-65	Subject 20-51-15
	N	In-Line Jack	KN-39-20	Subject 20-51-11
			KN-39-93	Subject 20-51-15
		Straight Plug	KN-59-220	Subject 20-51-15
			KN-59-220-M07	Subject 20-51-15
			KN-59-48	Subject 20-51-11
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	KA-39-15	Subject 20-51-11
		Straight Plug	KA-59-185	Subject 20-51-15
			KA-59-185-MC7	Subject 20-51-15
			KA-59-31	Subject 20-51-11
			KA-59-316	Subject 20-51-15
			KA-59-438-M06	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
BMS13-65 Type 0F	N	In-Line Jack	1203-14-9	Subject 20-51-15
			KN-39-71	Subject 20-51-15
		Straight Plug	1205-47-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
			KN-59-369-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	123-22-5	Subject 20-51-15
		Straight Hex Plug	125-94-9	Subject 20-51-15
		Straight Plug	125-88-9	Subject 20-51-15
			KA-59-128	Subject 20-51-11
			KA-59-251	Subject 20-51-15
			KA-59-438-M06	Subject 20-51-15
BMS13-65 Type 0G	N	In-Line Jack	1203-19-9	Subject 20-51-15
		Straight Plug	1205-62-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
BMS13-65 Type 0H	N	In-Line Jack	1203-20-9	Subject 20-51-15
		Straight Plug	1205-48-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	123-23-9	Subject 20-51-15
		Straight Hex Plug	125-101-9	Subject 20-51-15
		Straight Plug	125-91-9	Subject 20-51-15
BMS13-65 Type 0J	N	In-Line Jack	1203-16-9	Subject 20-51-15
		Straight Plug	1205-49-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
	SC	In-Line Jack	823-2-9	Subject 20-51-15
		Straight Plug	825-12-9	Subject 20-51-15
BMS13-65 Type 0K	N	In-Line Jack	1203-21-9	Subject 20-51-15
		Straight Plug	1205-61-9	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
FEP226	N	In-Line Jack	1203-13-9	Subject 20-51-15
		Straight Plug	1205-31-9	Subject 20-51-15
MC5400	BNC	In-Line Jack	KC-39-48	Subject 20-51-11
		Straight Plug	KC-59-177	Subject 20-51-11
	C	In-Line Jack	KD-39-21	Subject 20-51-11
		Straight Plug	KD-59-94	Subject 20-51-11
	N	In-Line Jack	KN-39-48	Subject 20-51-11
		Straight Plug	KN-59-128	Subject 20-51-11
	TNC	In-Line Jack	KA-39-32	Subject 20-51-11
		Straight Plug	KA-59-98	Subject 20-51-11
MI-5224	HN	In-Line Jack	KH-39-11	Subject 20-51-11
		Straight Plug	KH-59-47	Subject 20-51-11
MI-5406	BNC	In-Line Jack	KC-39-110	Subject 20-51-15
			KC-39-48	Subject 20-51-11
		Straight Plug	KC-59-177	Subject 20-51-11
			KC-59-267	Subject 20-51-15
	C	In-Line Jack	KD-39-21	Subject 20-51-11
			KD-39-28	Subject 20-51-15
		Straight Plug	KD-59-125	Subject 20-51-15
			KD-59-94	Subject 20-51-11
	N	In-Line Jack	KN-39-48	Subject 20-51-11
			KN-39-72	Subject 20-51-15
		Straight Plug	KN-59-128	Subject 20-51-11
			KN-59-185	Subject 20-51-15
	TNC	In-Line Jack	KA-39-32	Subject 20-51-11
			KA-39-83	Subject 20-51-15
		Straight Plug	KA-59-188	Subject 20-51-15
			KA-59-98	Subject 20-51-11

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
RG-11	C	In-Line Jack	KD-39-08	Subject 20-51-11
			KD-39-42	Subject 20-51-15
		Straight Plug	KD-59-163	Subject 20-51-15
			KD-59-33	Subject 20-51-11
			KD-59-38	Subject 20-51-11
	HN	In-Line Jack	KH-39-11	Subject 20-51-11
			KH-39-21	Subject 20-51-15
		Straight Plug	KH-59-19	Subject 20-51-11
			KH-59-63	Subject 20-51-15
	N	In-Line Jack	KN-39-19	Subject 20-51-11
		Straight Plug	KN-59-18	Subject 20-51-11
			KN-59-261	Subject 20-51-15
			KN-59-46	Subject 20-51-11
RG-115	N	In-Line Jack	KN-39-23	Subject 20-51-11
			KN-39-55	Subject 20-51-11
		Straight Plug	KN-59-135	Subject 20-51-11
			KN-59-28	Subject 20-51-11
			KN-59-57	Subject 20-51-11
RG-122	BNC	In-Line Jack	KC-39-142-M06	Subject 20-51-15
			KC-39-36	Subject 20-51-15
			KC-39-44	Subject 20-51-11
		Straight Plug	KC-59-111	Subject 20-51-11
			KC-59-446	Subject 20-51-15
	TNC	In-Line Jack	KA-39-31	Subject 20-51-11
		Straight Plug	125-69-9	Subject 20-51-15
RG-142	TNC	In-Line Jack	KA-39-15	Subject 20-51-11
			KA-39-85	Subject 20-51-15
		Straight Plug	KA-59-128	Subject 20-51-11
			KA-59-230	Subject 20-51-15
			KA-59-251	Subject 20-51-15
			KA-59-438-M06	Subject 20-51-15
			KA-59-57	Subject 20-51-11

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
RG-180	BNC	In-Line Jack	KC-39-142-M06	Subject 20-51-15
			KC-39-36	Subject 20-51-15
			KC-39-44	Subject 20-51-11
		Straight Plug	KC-59-111	Subject 20-51-11
			KC-59-446	Subject 20-51-15
	TNC	In-Line Jack	KA-39-31	Subject 20-51-11
		Straight Plug	125-69-9	Subject 20-51-15
RG-195	BNC	In-Line Jack	KC-39-142-M06	Subject 20-51-15
			KC-39-36	Subject 20-51-15
			KC-39-44	Subject 20-51-11
		Straight Plug	KC-59-111	Subject 20-51-11
			KC-59-446	Subject 20-51-15
	TNC	In-Line Jack	KA-39-31	Subject 20-51-11
		Straight Plug	125-69-9	Subject 20-51-15
RG-210	BNC	In-Line Jack	KC-39-109	Subject 20-51-15
			KC-39-22	Subject 20-51-11
			KC-39-45	Subject 20-51-11
		Straight Plug	KC-59-263	Subject 20-51-15
			KC-59-64	Subject 20-51-11
	N	In-Line Jack	KN-39-51	Subject 20-51-11
		Straight Plug	KN-59-133	Subject 20-51-11

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
RG-213	C	In-Line Jack	KD-39-08	Subject 20-51-11
			KD-39-42	Subject 20-51-15
		Straight Plug	KD-59-163	Subject 20-51-15
			KD-59-33	Subject 20-51-11
			KD-59-38	Subject 20-51-11
	HN	In-Line Jack	KH-39-11	Subject 20-51-11
			KH-39-21	Subject 20-51-15
		Straight Plug	KH-59-19	Subject 20-51-11
			KH-59-63	Subject 20-51-15
	N	In-Line Jack	KN-39-19	Subject 20-51-11
		Straight Plug	KN-59-18	Subject 20-51-11
			KN-59-201	Subject 20-51-15
			KN-59-261	Subject 20-51-15
			KN-59-369-M06	Subject 20-51-15
			KN-59-46	Subject 20-51-11
			KN-59-67	Subject 20-51-15
RG-214	C	In-Line Jack	KD-39-09	Subject 20-51-11
			KD-39-37	Subject 20-51-15
		Straight Plug	KD-59-164	Subject 20-51-15
			KD-59-165	Subject 20-51-15
			KD-59-41	Subject 20-51-11
			KD-59-42	Subject 20-51-11
	HN	In-Line Jack	KD-59-52	Subject 20-51-15
			KH-19-12	Subject 20-51-11
			KH-39-12	Subject 20-51-11
			KH-39-22	Subject 20-51-15
		Straight Plug	KH-59-21	Subject 20-51-11
			KH-59-65	Subject 20-51-15
	N	In-Line Jack	KN-39-20	Subject 20-51-11
			KN-39-93	Subject 20-51-15
			KN-59-34	Subject 20-51-11
		Straight Plug	KN-59-220	Subject 20-51-15
			KN-59-220-M07	Subject 20-51-15
			KN-59-48	Subject 20-51-11

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
RG-223	BNC	In-Line Jack	KC-39-25	Subject 20-51-11
			KC-39-75	Subject 20-51-16
		Straight Plug	KC-59-218	Subject 20-51-15
			KC-59-259	Subject 20-51-15
			KC-59-33	Subject 20-51-11
	N	In-Line Jack	KN-39-42	Subject 20-51-11
			KN-39-71	Subject 20-51-15
		Straight Plug	KN-59-113	Subject 20-51-11
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
			KN-59-242-M06	Subject 20-51-15
			KN-59-369-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	KA-39-85	Subject 20-51-15
RG-225	HN	In-Line Jack	KH-39-11	Subject 20-51-11
		Straight Plug	KH-59-50	Subject 20-51-11
			KH-59-60	Subject 20-51-11
	N	In-Line Jack	KN-39-93	Subject 20-51-15
		Straight Plug	KN-59-131	Subject 20-51-11
			KN-59-220	Subject 20-51-15
RG-303	TNC	In-Line Jack	KA-39-85	Subject 20-51-15
		Straight Plug	KA-59-251	Subject 20-51-15
RG-393	N	In-Line Jack	1203-4-9	Subject 20-51-15
		Straight Plug	KN-59-237	Subject 20-51-11
			KN-59-239	Subject 20-51-15
			KN-59-329-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	KA-39-100-M06	Subject 20-51-15
		Straight Plug	KA-59-251	Subject 20-51-15
			KA-59-267	Subject 20-51-11
			KA-59-319	Subject 20-51-11
			KA-59-353-M06	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
RG-58	BNC	In-Line Jack	KC-39-108	Subject 20-51-15
			KC-39-20	Subject 20-51-11
			KC-39-75	Subject 20-51-16
		Straight Plug	KC-59-411	Subject 20-51-15
			KC-59-61	Subject 20-51-11
	C	In-Line Jack	KD-19-45	Subject 20-51-11
		Straight Plug	KD-59-130	Subject 20-51-16
			KD-59-161	Subject 20-51-15
			KD-59-44	Subject 20-51-11
			KD-59-55	Subject 20-51-11
	N	In-Line Jack	KN-39-21	Subject 20-51-11
		Straight Plug	KN-59-247	Subject 20-51-15
	TNC	In-Line Jack	KA-39-12	Subject 20-51-11
			KA-39-82	Subject 20-51-15
		Straight Plug	KA-59-277	Subject 20-51-15
			KA-59-29	Subject 20-51-11
RG-59	BNC	In-Line Jack	KC-39-109	Subject 20-51-15
			KC-39-22	Subject 20-51-11
			KC-39-45	Subject 20-51-11
			KC-39-75	Subject 20-51-16
		Straight Plug	KC-59-128	Subject 20-51-15
			KC-59-263	Subject 20-51-15
			KC-59-64	Subject 20-51-11
	N	In-Line Jack	KN-39-51	Subject 20-51-11
		Straight Plug	KN-59-133	Subject 20-51-11
RG-62	BNC	In-Line Jack	KC-39-109	Subject 20-51-15
			KC-39-22	Subject 20-51-11
		Straight Plug	KC-59-263	Subject 20-51-15
			KC-59-64	Subject 20-51-11
	N	In-Line Jack	KN-39-51	Subject 20-51-11
		Straight Plug	KN-59-133	Subject 20-51-11

20-51-00



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

**Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)**

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
RG-71	BNC	In-Line Jack	KC-39-21	Subject 20-51-11
		Straight Plug	KC-59-262	Subject 20-51-15
			KC-59-41	Subject 20-51-11
			KC-59-425-M06	Subject 20-51-15
			KC-59-51	Subject 20-51-15
			KC-59-63	Subject 20-51-11
	N	In-Line Jack	KN-39-19	Subject 20-51-11
	TNC	Straight Plug	KA-59-313	Subject 20-51-15
			KA-59-39	Subject 20-51-11
S280W503-2	N	In-Line Jack	1203-14-9	Subject 20-51-15
			KN-39-71	Subject 20-51-15
		Straight Plug	1205-47-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
			KN-59-369-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	123-22-5	Subject 20-51-15
		Straight Hex Plug	125-94-9	Subject 20-51-15
		Straight Plug	125-88-9	Subject 20-51-15
			KA-59-128	Subject 20-51-11
			KA-59-251	Subject 20-51-15
			KA-59-438-M06	Subject 20-51-15
S280W503-3	N	In-Line Jack	1203-19-9	Subject 20-51-15
		Straight Plug	1205-62-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
S280W503-4	N	In-Line Jack	1203-20-9	Subject 20-51-15
		Straight Plug	1205-48-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
			KN-59-49	Subject 20-51-11
	TNC	In-Line Jack	123-23-9	Subject 20-51-15
		Straight Hex Plug	125-101-9	Subject 20-51-15
		Straight Plug	125-91-9	Subject 20-51-15

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY AND INSTALLATION OF COAX CONNECTORS

Table 1 APPLICABLE COAX JACK AND PLUG CONNECTORS FOR SPECIFIED COAX CABLES
(Continued)

Coax Cable	Connector			
	Series	Type	Part Number	Assembly Procedure
S280W503-5	N	In-Line Jack	1203-16-9	Subject 20-51-15
		Straight Plug	1205-49-9	Subject 20-51-15
			KN-59-183	Subject 20-51-15
			KN-59-183-M06	Subject 20-51-15
	SC	In-Line Jack	823-2-9	Subject 20-51-15
		Straight Plug	825-12-9	Subject 20-51-15
S280W503-6	N	In-Line Jack	1203-21-9	Subject 20-51-15
		Straight Plug	1205-61-9	Subject 20-51-15

3. INSTALLATION OF COAX CONNECTORS

For the installation of coax connectors, refer to Subject 20-60-06.

20-51-00



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF STANDARD CONNECTORS WITH COAX CABLE

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Coax Cable Part Numbers	2
2. <u>CONNECTOR ASSEMBLY WITH ITT SURPRENANT BA14349 AND RAYCHEM 5020G3442 COAX CABLE</u>	2
A. Necessary Parts and Materials	2
B. Cable Preparation	2
C. Shield Termination	3
D. Connector Assembly	3

20-51-05



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF STANDARD CONNECTORS WITH COAX CABLE

This Subject gives the procedure to prepare a coax cable for the assembly of a connector that is not a coax connector.

1. PART NUMBERS AND DESCRIPTION

A. Coax Cable Part Numbers

Table 1
COAX CABLE PART NUMBERS

Coax Cable	Supplier
BA14349	ITT Surprenant
5020G3442	Raychem

2. CONNECTOR ASSEMBLY WITH ITT SURPRENANT BA14349 AND RAYCHEM 5020G3442 COAX CABLE

A. Necessary Parts and Materials

Table 2
FERRULE PART NUMBERS

Part	Boeing Standard
Ferrule, Inner	BACS13S124B
Ferrule, Outer	BACS13S199C

NOTE: Refer to Subject 20-00-11 for approved suppliers and alternative part numbers for BACS13S ferrules.

B. Cable Preparation

Refer to Subject 20-51-00 for the general conditions that are applicable for the preparation of coax cable.

- (1) Remove 2.5 inches ± 0.06 inch of the outer jacket from the end of the cable.
- (2) Remove 2.5 inches ± 0.06 inch of the outer shield from the end of the cable.
- (3) Make a selection of an outer ferrule from Table 2.
- (4) Put the outer ferrule on the cable.
- (5) Put a 2 inch length of 1/4 inch diameter heat shrinkable sleeve on the cable.
- (6) Remove 1.13 inches ± 0.03 inch of the inner shield from the end of the cable.
- (7) Remove 1.13 inches ± 0.03 inch of the dielectric from the end of the cable.

CAUTION: DO NOT CUT OR CAUSE ANY DAMAGE TO THE CONDUCTOR. DAMAGE TO THE CONDUCTOR CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (8) Put a 1.06 inch $+0$ inch, -0.03 inch length of 1/16 inch diameter heat shrinkable sleeve on the conductor.

Make sure that the forward end of the sleeve is aligned with the end of the dielectric.

20-51-05



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF STANDARD CONNECTORS WITH COAX CABLE

- (9) Shrink the sleeve in position. Refer to Subject 20-10-14.

C. Shield Termination

- (1) Make a selection of the inner ferrule from Table 2.
(2) Put the inner ferrule on the cable.
(3) Assemble a shield ground wire with the mechanical ferrules.

Make sure that:

- The shield ground wire is 4 inches in length
- The heat shrinkable sleeve is 1/2 inch in length and has a 1/8 inch diameter
- The end of the sleeve is aligned with the end of the outer jacket.

Refer to Subject 20-10-15 for:

- The selection of the wire
 - The crimp tools for the specified ferrules.
- (4) Put the strands of the shield:
- Against the dielectric
 - Symmetrically around the circumference of the dielectric.
- (5) Assemble a shield dead end. Refer to Subject 20-10-15.
(6) Push the 2 inch length of 1/4 inch diameter heat shrinkable sleeve forward until the forward end of the sleeve makes an overlap with the rear end of the shield ground wire.
(7) Shrink the sleeve in position. Refer to Subject 20-10-14.

D. Connector Assembly

- (1) Assemble the connector.
Refer to the applicable Subject for the connector.

20-51-05



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers and Description	2
	B. Necessary Materials	12
2.	<u>COAX CONNECTOR ASSEMBLY TOOLS</u>	13
	A. Coax Cable Trim Jigs	13
	B. Coax Connector Crimp Tools	18
3.	<u>CONNECTOR ASSEMBLY</u>	32
	A. Cable Preparation Dimensions	32
	B. Cable Preparation	54
	C. K-Grip Assembly	55
	D. Center Contact Assembly - Crimp Type Contacts	57
	E. Center Contact Assembly - Solder Type Contacts	60
	F. Center Contact Assembly - Solder Type Contacts of Right Angle Plug Connectors	63
	G. Connector Shell Installation	65
4.	<u>COAX CABLE PREPARATION PROCEDURES</u>	73
	A. Cable Preparation - No Trim Jig	73
	B. Cable Preparation - Cable Jacket Trim Jig	74
	C. Dielectric Removal - No Trim Jig	75
	D. Dielectric Removal - Dielectric Trim Jig	77
5.	<u>APPROVED TOOL SUPPLIERS</u>	78
	A. Coax Cable Trim Jigs	78
	B. Coax Connector Crimp Tools	79

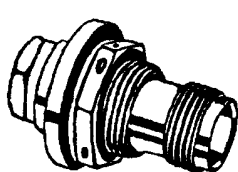
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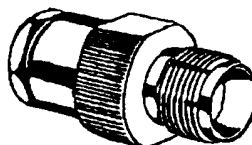
707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

1. PART NUMBERS AND DESCRIPTION

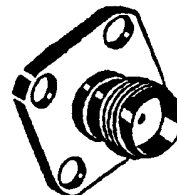
A. Connector Part Numbers and Description



Bulkhead Jack



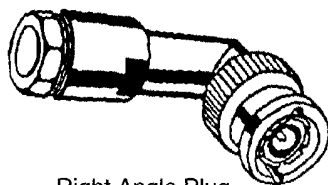
In-Line Jack



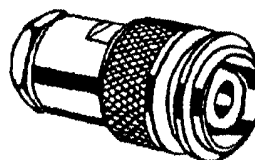
Panel Jack

2445956 S00061545994_V1

K-GRIP WEATHERPROOF COAX JACK CONNECTORS
Figure 1



Right Angle Plug



Straight Plug

2447682 S00061545995_V1

K-GRIP WEATHERPROOF COAX PLUG CONNECTORS
Figure 2

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Series	Configuration	Contact Type	Supplier
KA-19-21	TNC	Panel Jack	Solder	Kings Electronics
KA-19-23	TNC	Panel Jack	Solder	Kings Electronics
KA-19-24	TNC	Panel Jack	Solder	Kings Electronics
KA-19-25	TNC	Panel Jack	Solder	Kings Electronics
KA-19-48	TNC	Bulkhead Jack	Solder	Kings Electronics
KA-19-50	TNC	Panel Jack	Solder	Kings Electronics
KA-19-51	TNC	Panel Jack	Solder	Kings Electronics
KA-19-63	TNC	Panel Jack	Solder	Kings Electronics
KA-39-12	TNC	In-Line Jack	Solder	Kings Electronics
KA-39-15	TNC	In-Line Jack	Solder	Kings Electronics
KA-39-31	TNC	In-Line Jack	Solder	Kings Electronics

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KA-39-32	TNC	In-Line Jack	Solder	Kings Electronics
KA-59-128	TNC	Straight Plug	Solder	Kings Electronics
KA-59-134	TNC	Straight Plug	Solder	Kings Electronics
KA-59-138	TNC	Right Angle Plug	Solder	Kings Electronics
KA-59-166	TNC	Right Angle Plug	Solder	Kings Electronics
KA-59-267	TNC	Straight Plug	Solder	Kings Electronics
KA-59-29	TNC	Straight Plug	Solder	Kings Electronics
KA-59-31	TNC	Straight Plug	Solder	Kings Electronics
KA-59-318	TNC	Right Angle Plug	Solder	Kings Electronics
KA-59-319	TNC	Straight Plug	Solder	Kings Electronics
KA-59-32	TNC	Right Angle Plug	Solder	Kings Electronics
KA-59-36	TNC	Straight Plug	Solder	Kings Electronics
KA-59-39	TNC	Straight Plug	Solder	Kings Electronics
KA-59-40	TNC	Straight Plug	Solder	Kings Electronics
KA-59-41	TNC	Right Angle Plug	Solder	Kings Electronics
KA-59-59	TNC	Right Angle Plug	Solder	Kings Electronics
KA-59-98	TNC	Straight Plug	Solder	Kings Electronics
KA-59-99	TNC	Right Angle Plug	Solder	Kings Electronics
KC-19-100	BNC	Panel Jack	Solder	Kings Electronics
KC-19-101	BNC	Panel Jack	Solder	Kings Electronics
KC-19-113	BNC	Panel Jack	Solder	Kings Electronics
KC-19-116	BNC	Panel Jack	Solder	Kings Electronics
KC-19-121	BNC	Right Angle Bulkhead Jack	Crimp	Kings Electronics
KC-19-125	BNC	Panel Jack	Solder	Kings Electronics
KC-19-136	BNC	Panel Jack	Solder	Kings Electronics
KC-19-21	BNC	Panel Jack	Solder	Kings Electronics
KC-19-31	BNC	Panel Jack	Solder	Kings Electronics
KC-19-32	BNC	Panel Jack	Solder	Kings Electronics
KC-19-33	BNC	Bulkhead Jack	Solder	Kings Electronics
KC-19-34	BNC	Panel Jack	Solder	Kings Electronics
KC-19-57	BNC	Bulkhead Jack	Solder	Kings Electronics
KC-19-69	BNC	Panel Jack	Solder	Kings Electronics
KC-39-102	BNC	Right Angle Jack	Solder	Kings Electronics
KC-39-14	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-20	BNC	In-Line Jack	Solder	Kings Electronics

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KC-39-21	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-22	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-25	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-31	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-44	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-48	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-56	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-57	BNC	Right Angle Jack	Solder	Kings Electronics
KC-59-111	BNC	Straight Plug	Solder	Kings Electronics
KC-59-136	BNC	Straight Plug	Solder	Kings Electronics
KC-59-172	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-177	BNC	Straight Plug	Solder	Kings Electronics
KC-59-178	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-188	BNC	Straight Plug	Solder	Kings Electronics
KC-59-191	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-194	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-33	BNC	Straight Plug	Solder	Kings Electronics
KC-59-38	BNC	Straight Plug	Solder	Kings Electronics
KC-59-41	BNC	Straight Plug	Solder	Kings Electronics
KC-59-42	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-61	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-62	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-63	BNC	Straight Plug	Solder	Kings Electronics
KC-59-64	BNC	Straight Plug	Solder	Kings Electronics
KC-59-85	BNC	Straight Plug	Solder	Kings Electronics
KC-59-96	BNC	Straight Plug	Solder	Kings Electronics
KD-19-26	C	Panel Jack	Solder	Kings Electronics
KD-19-28	C	Panel Jack	Solder	Kings Electronics
KD-19-29	C	Bulkhead Jack	Solder	Kings Electronics
KD-19-33	C	Panel Jack	Solder	Kings Electronics
KD-19-44	C	Bulkhead Jack	Solder	Kings Electronics
KD-19-45	C	In-Line Jack	Solder	Kings Electronics
KD-19-49	C	Panel Jack	Solder	Kings Electronics
KD-19-52	C	Panel Jack	Solder	Kings Electronics
KD-19-56	C	Panel Jack	Solder	Kings Electronics

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KD-39-08	C	In-Line Jack	Solder	Kings Electronics
KD-39-09	C	In-Line Jack	Solder	Kings Electronics
KD-39-10	C	Tee Jack	Solder	Kings Electronics
KD-39-21	C	In-Line Jack	Solder	Kings Electronics
KD-59-100	C	Right Angle Plug	Solder	Kings Electronics
KD-59-101	C	Right Angle Plug	Solder	Kings Electronics
KD-59-155	C	Right Angle Plug	Solder	Kings Electronics
KD-59-156	C	Straight Plug	Solder	Kings Electronics
KD-59-33	C	Straight Plug	Solder	Kings Electronics
KD-59-35	C	Straight Plug	Solder	Kings Electronics
KD-59-38	C	Straight Plug	Solder	Kings Electronics
KD-59-40	C	Right Angle Plug	Solder	Kings Electronics
KD-59-41	C	Straight Plug	Solder	Kings Electronics
KD-59-42	C	Straight Plug	Solder	Kings Electronics
KD-59-43	C	Right Angle Plug	Solder	Kings Electronics
KD-59-44	C	Straight Plug	Solder	Kings Electronics
KD-59-50	C	Straight Plug	Solder	Kings Electronics
KD-59-55	C	Straight Plug	Solder	Kings Electronics
KD-59-57	C	Right Angle Plug	Solder	Kings Electronics
KD-59-90	C	Straight Plug	Solder	Kings Electronics
KD-59-94	C	Straight Plug	Solder	Kings Electronics
KD-59-95	C	Right Angle Plug	Solder	Kings Electronics
KG-59-16	SC	Right Angle Plug	Solder	Kings Electronics
KG-59-22	SC	Right Angle Plug	Solder	Kings Electronics
KG-59-23	SC	Straight Plug	Solder	Kings Electronics
KG-59-25	SC	Straight Plug	Crimp	Kings Electronics
KG-59-26	SC	Right Angle Plug	Solder	Kings Electronics
KH-19-12	HN	In-Line Jack	Solder	Kings Electronics
KH-19-13	HN	Panel Jack	Solder	Kings Electronics
KH-19-14	HN	Panel Jack	Solder	Kings Electronics
KH-19-22	HN	Panel Jack	Solder	Kings Electronics
KH-39-11	HN	In-Line Jack	Solder	Kings Electronics
KH-39-12	HN	In-Line Jack	Solder	Kings Electronics
KH-59-19	HN	Straight Plug	Solder	Kings Electronics
KH-59-20	HN	Right Angle Plug	Solder	Kings Electronics

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KH-59-21	HN	Straight Plug	Solder	Kings Electronics
KH-59-24	HN	Right Angle Plug	Solder	Kings Electronics
KH-59-28	HN	Straight Plug	Solder	Kings Electronics
KH-59-31	HN	Right Angle Plug	Solder	Kings Electronics
KH-59-47	HN	Straight Plug	Solder	Kings Electronics
KH-59-50	HN	Straight Plug	Solder	Kings Electronics
KH-59-53	HN	Straight Plug	Solder	Kings Electronics
KH-59-54	HN	Right Angle Plug	Solder	Kings Electronics
KH-59-56	HN	Right Angle Plug	Solder	Kings Electronics
KH-59-60	HN	Straight Plug	Solder	Kings Electronics
KH-59-78	HN	Straight Plug	Solder	Kings Electronics
KN-19-30	N	Panel Jack	Solder	Kings Electronics
KN-19-31	N	Panel Jack	Solder	Kings Electronics
KN-19-37	N	Bulkhead Jack	Solder	Kings Electronics
KN-19-44	N	Bulkhead Jack	Solder	Kings Electronics
KN-19-48	N	Panel Jack	Solder	Kings Electronics
KN-19-68	N	Panel Jack	Solder	Kings Electronics
KN-19-73	N	Panel Jack	Solder	Kings Electronics
KN-19-78	N	Panel Jack	Solder	Kings Electronics
KN-19-79	N	Panel Jack	Solder	Kings Electronics
KN-39-19	N	In-Line Jack	Solder	Kings Electronics
KN-39-20	N	In-Line Jack	Solder	Kings Electronics
KN-39-21	N	In-Line Jack	Solder	Kings Electronics
KN-39-23	N	In-Line Jack	Solder	Kings Electronics
KN-39-42	N	In-Line Jack	Solder	Kings Electronics
KN-39-48	N	In-Line Jack	Solder	Kings Electronics
KN-39-51	N	In-Line Jack	Solder	Kings Electronics
KN-39-55	N	In-Line Jack	Solder	Kings Electronics
KN-59-107	N	Right Angle Plug	Solder	Kings Electronics
KN-59-110	N	Right Angle Plug	Solder	Kings Electronics
KN-59-113	N	Straight Plug	Solder	Kings Electronics
KN-59-128	N	Straight Plug	Solder	Kings Electronics
KN-59-129	N	Right Angle Plug	Solder	Kings Electronics
KN-59-131	N	Straight Plug	Solder	Kings Electronics
KN-59-133	N	Straight Plug	Solder	Kings Electronics

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KN-59-135	N	Straight Plug	Solder	Kings Electronics
KN-59-136	N	Right Angle Plug	Solder	Kings Electronics
KN-59-138	N	Right Angle Plug	Solder	Kings Electronics
KN-59-18	N	Straight Plug	Solder	Kings Electronics
KN-59-237	N	Straight Plug	Solder	Kings Electronics
KN-59-238	N	Right Angle Plug	Solder	Kings Electronics
KN-59-28	N	Straight Plug	Solder	Kings Electronics
KN-59-29	N	Right Angle Plug	Solder	Kings Electronics
KN-59-31	N	Right Angle Plug	Solder	Kings Electronics
KN-59-34	N	Straight Plug	Solder	Kings Electronics
KN-59-46	N	Straight Plug	Solder	Kings Electronics
KN-59-47	N	Right Angle Plug	Solder	Kings Electronics
KN-59-48	N	Straight Plug	Solder	Kings Electronics
KN-59-49	N	Straight Plug	Solder	Kings Electronics
KN-59-50	N	Right Angle Plug	Solder	Kings Electronics
KN-59-53	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-56	N	Right Angle Plug	Solder	Kings Electronics
KN-59-57	N	Straight Plug	Solder	Kings Electronics
KN-59-69	N	Straight Plug	Solder	Kings Electronics
KS-89-31	-	End Seal	-	Kings Electronics
KS-89-35	-	End Seal	-	Kings Electronics
KS-89-42	-	End Seal	-	Kings Electronics
KU-59-19	UHF	Right Angle Plug	Solder	Kings Electronics
KU-59-21	UHF	Right Angle Plug	Solder	Kings Electronics
KU-59-25	UHF	Right Angle Plug	Solder	Kings Electronics
KU-59-32	UHF	Right Angle Plug	Solder	Kings Electronics
KU-59-67	UHF	Right Angle Plug	Solder	Kings Electronics

Table 2
ALTERNATIVE COAX CONNECTORS

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KA-19-25	KA-19-162	Subject 20-51-15	-
KA-19-50	KA-19-83	Subject 20-51-15	-
KA-19-51	KA-19-193	Subject 20-51-15	-
KA-19-63	KA-19-163	Subject 20-51-15	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 2 ALTERNATIVE COAX CONNECTORS (Continued)

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KA-39-12	KA-39-82	Subject 20-51-15	-
KA-39-15	KA-39-85	Subject 20-51-15	-
KA-39-31	KA-39-44	Subject 20-51-15	-
KA-39-32	KA-39-83	Subject 20-51-15	-
KA-59-128	KA-59-438-M06	Subject 20-51-15	-
KA-59-134	KA-59-438-M06	Subject 20-51-15	-
KA-59-166	KA-59-439-M06	Subject 20-51-15	-
KA-59-251	KA-59-438-M06	Subject 20-51-15	-
KA-59-267	KA-59-353-M06	Subject 20-51-15	-
KA-59-29	KA-59-277	Subject 20-51-15	-
KA-59-31	KA-59-185	Subject 20-51-15	-
KA-59-32	KA-59-186	Subject 20-51-15	-
KA-59-39	KA-59-313	Subject 20-51-15	-
KA-59-40	KA-59-437-M06	Subject 20-51-15	-
KA-59-41	KA-59-304	Subject 20-51-15	-
KA-59-59	KA-59-187	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KA-59-98	KA-59-188	Subject 20-51-15	-
KA-59-99	KA-59-189	Subject 20-51-15	-
KC-19-100	KC-19-170	Subject 20-51-15	-
KC-19-101	KC-19-256	Subject 20-51-15	-
KC-19-113	KC-19-169	Subject 20-51-15	-
KC-19-116	KC-19-129-M06	Subject 20-51-15	-
KC-19-125	KC-19-262	Subject 20-51-15	-
KC-19-136	KC-19-329-M06	Subject 20-51-15	-
KC-19-21	KC-19-129-M06	Subject 20-51-15	-
KC-19-31	KC-19-254	Subject 20-51-15	-
KC-19-32	KC-19-327-M06	Subject 20-51-15	-
KC-19-34	KC-19-327-M06	Subject 20-51-15	-
KC-19-57	KC-19-261	Subject 20-51-15	-
KC-39-102	KC-39-111	Subject 20-51-15	-
KC-39-14	KC-39-140-M06	Subject 20-51-15	-
KC-39-20	KC-39-108	Subject 20-51-15	-
KC-39-21	KC-39-29	Subject 20-51-15	-
KC-39-22	KC-39-109	Subject 20-51-15	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 2 ALTERNATIVE COAX CONNECTORS (Continued)

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KC-39-25	KC-39-56	Subject 20-51-15	-
KC-39-31	KC-39-81	Subject 20-51-15	-
KC-39-44	KC-39-142-M06	Subject 20-51-15	-
KC-39-48	KC-39-110	Subject 20-51-15	-
KC-39-56	KC-39-140-M06	Subject 20-51-15	-
KC-59-111	KC-59-446	Subject 20-51-15	-
KC-59-177	KC-59-267	Subject 20-51-15	-
KC-59-178	KC-59-447	Subject 20-51-15	-
KC-59-188	KC-59-383	Subject 20-51-15	-
KC-59-191	KC-59-669-M06	Subject 20-51-15	-
KC-59-194	KC-59-448	Subject 20-51-15	-
KC-59-33	KC-59-383	Subject 20-51-15	-
KC-59-38	KC-59-383	Subject 20-51-15	-
KC-59-42	KC-59-444	Subject 20-51-15	-
KC-59-61	KC-59-411	Subject 20-51-15	-
KC-59-62	KC-59-261	Subject 20-51-15	-
KC-59-63	KC-59-262	Subject 20-51-15	-
KC-59-64	KC-59-263	Subject 20-51-15	-
KC-59-85	KC-59-445	Subject 20-51-15	-
KC-59-96	KC-59-265	Subject 20-51-15	-
KD-19-28	KD-19-66	Subject 20-51-15	-
KD-19-29	KD-19-90	Subject 20-51-15	-
KD-19-33	KD-19-67	Subject 20-51-15	-
KD-19-45	KD-19-55	Subject 20-51-15	-
KD-19-49	KD-19-68	Subject 20-51-15	-
KD-19-52	KD-19-69	Subject 20-51-15	-
KD-19-56	KD-19-95	Subject 20-51-15	-
KD-39-08	KD-39-42	Subject 20-51-15	-
KD-39-09	KD-39-37	Subject 20-51-15	-
KD-39-10	KD-39-27	Subject 20-51-15	-
KD-39-21	KD-39-28	Subject 20-51-15	-
KD-59-100	KD-59-202-M06	Subject 20-51-15	-
KD-59-101	KD-59-202-M06	Subject 20-51-15	-
KD-59-155	KD-59-193-M06	Subject 20-51-15	-

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

Table 2 ALTERNATIVE COAX CONNECTORS (Continued)

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KD-59-33	KD-59-163	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KD-59-35	KD-59-58	Subject 20-51-15	-
KD-59-38	KD-59-163	Subject 20-51-15	-
KD-59-40	KD-59-120	Subject 20-51-15	-
KD-59-41	KD-59-164	Subject 20-51-15	-
KD-59-42	KD-59-165	Subject 20-51-15	-
KD-59-43	KD-59-165	Subject 20-51-15	-
KD-59-44	KD-59-161	Subject 20-51-15	-
KD-59-50	KD-59-201-M06	Subject 20-51-15	-
KD-59-55	KD-59-166	Subject 20-51-15	-
KD-59-57	KD-59-129	Subject 20-51-15	-
KD-59-90	KD-59-201-M06	Subject 20-51-15	-
KD-59-94	KD-59-125	Subject 20-51-15	-
KD-59-95	KD-59-126	Subject 20-51-15	-
KG-59-16	KG-59-28	Subject 20-51-15	-
KG-59-22	KG-59-33-M06	Subject 20-51-15	-
KG-59-23	KG-59-32-M06	Subject 20-51-15	-
KG-59-26	KG-59-31-M06	Subject 20-51-15	-
KH-19-13	KH-19-18	Subject 20-51-15	-
KH-39-11	KH-39-21	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-19	KH-59-63	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-21	KH-59-65	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-24	KH-59-66	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-28	KH-59-102-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-31	KH-59-103-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-50	KH-59-65	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KH-59-56	KH-59-69	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 2 ALTERNATIVE COAX CONNECTORS (Continued)

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KH-59-78	KH-59-104-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KA-39-44	KA-39-102-M06	Subject 20-51-15	-
KN-19-30	KN-19-208-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-31	KN-19-162	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-44	KN-19-145	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-48	KN-19-205-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-68	KN-19-115	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-73	KN-19-206-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-78	KN-19-117	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-19-79	KN-19-118	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-19	KN-39-122-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-20	KN-39-93	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-21	KN-39-87	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-23	KN-39-121-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-42	KN-39-71	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-51	KN-39-73	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-39-55	KN-39-121-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-59-107	KN-59-313-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-59-110	KN-59-313-M06	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-59-113	KN-59-183	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-59-128	KN-59-185	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 2 ALTERNATIVE COAX CONNECTORS (Continued)

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KN-59-129	KN-59-186	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only
KN-59-131	KN-59-220	Subject 20-51-15	-
KN-59-135	KN-59-367-M06	Subject 20-51-15	-
KN-59-136	KN-59-368-M06	Subject 20-51-15	-
KN-59-138	KN-59-313-M06	Subject 20-51-15	-
KN-59-18	KN-59-261	Subject 20-51-15	-
KN-59-237	KN-59-329-M06	Subject 20-51-15	-
KN-59-238	KN-59-264	Subject 20-51-15	Applicable for the RG-393 cable only
KN-59-31	KN-59-368-M06	Subject 20-51-15	-
KN-59-46	KN-59-261	Subject 20-51-15	-
KN-59-47	KN-59-262	Subject 20-51-15	-
KN-59-48	KN-59-220	Subject 20-51-15	-
KN-59-49	KN-59-247	Subject 20-51-15	-
KN-59-50	KN-59-263	Subject 20-51-15	-
KN-59-53	KN-59-263	Subject 20-51-15	-
KN-59-56	KN-59-368-M06	Subject 20-51-15	-
KN-59-57	KN-59-367-M06	Subject 20-51-15	-
KN-59-69	KN-59-183	Subject 20-51-15	-

B. Necessary Materials

Table 3
NECESSARY MATERIALS

Material	Part Number or Specification	Supplier
Primer	Product 7471, Primer T	Loctite
Sleeve, Heat Shrinkable	DWP-125	Raychem
Solvent	Isopropyl Alcohol	Any Source
Thread Lock Compound	222	Loctite
	Product 081 Grade D	Loctite

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL

**ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS**

2. COAX CONNECTOR ASSEMBLY TOOLS

A. Coax Cable Trim Jigs

Table 4
COAX CABLE TRIM JIGS

Connector	Trim Jig	
	Cable Jacket	Dielectric
KA-19-21	KTJ-24	KTD-81
KA-19-23	KTJ-17	KTD-78
KA-19-24	KTJ-17	KTD-78
KA-19-25	KTJ-17	KTD-77
KA-19-48	-	KTD-6
KA-19-50	KTJ-17	KTD-77
KA-19-51	KTJ-17	KTD-77
KA-19-63	KTJ-17	KTD-77
KA-39-12	KTJ-17	KTD-77
KA-39-15	KTJ-17	KTD-77
KA-39-31	KTJ-19	KTD-89
KA-39-32	KTJ-17	KTD-77
KA-59-128	KTJ-17	KTD-77
KA-59-134	KTJ-17	KTD-77
KA-59-138	KTJ-24	KTD-81
KA-59-166	KTJ-17	KTD-77
KA-59-267	KTJ-24	KTD-81
KA-59-29	KTJ-17	KTD-77
KA-59-31	KTJ-25	KTD-82
KA-59-318	KTJ-24	KTD-81
KA-59-319	KTJ-24	KTD-81
KA-59-32	KTJ-24	KTD-81
KA-59-36	KTJ-22	KTD-81
KA-59-39	KTJ-17	KTD-78
KA-59-40	KTJ-17	KTD-78
KA-59-41	KTJ-17	KTD-77
KA-59-59	KTJ-24	KTD-81
KA-59-98	KTJ-17	KTD-77
KA-59-99	KTJ-17	KTD-77
KC-19-100	KTJ-17	KTD-77
KC-19-101	KTJ-17	KTD-77

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 4 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KC-19-113	KTJ-17	KTD-78
KC-19-116	KTJ-17	KTD-77
KC-19-121	KTJ-57	KTD-25
KC-19-125	KTJ-17	KTD-78
KC-19-136	KTJ-19	KTD-89
KC-19-21	KTJ-17	KTD-77
KC-19-31	KTJ-17	KTD-77
KC-19-32	KTJ-17	KTD-78
KC-19-33	KTJ-17	KTD-78
KC-19-34	KTJ-17	KTD-78
KC-19-57	KTJ-17	KTD-78
KC-19-69	KTJ-19	KTD-89
KC-39-102	KTJ-17	KTD-77
KC-39-14	KTJ-17	KTD-77
KC-39-20	KTJ-17	KTD-77
KC-39-21	KTJ-17	KTD-78
KC-39-22	KTJ-17	KTD-78
KC-39-25	KTJ-17	KTD-77
KC-39-31	KTJ-19	KTD-89
KC-39-44	KTJ-19	KTD-89
KC-39-48	KTJ-17	KTD-77
KC-39-56	KTJ-17	KTD-77
KC-39-57	KTJ-17	KTD-77
KC-59-111	KTJ-19	KTD-89
KC-59-136	KTJ-39	KTD-6
KC-59-172	KTJ-22	KTD-81
KC-59-177	KTJ-17	KTD-77
KC-59-178	KTJ-17	KTD-77
KC-59-188	KTJ-17	KTD-77
KC-59-191	KTJ-17	KTD-77
KC-59-194	KTJ-19	KTD-89
KC-59-33	KTJ-17	KTD-77
KC-59-38	KTJ-17	KTD-77
KC-59-41	KTJ-17	KTD-78

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 4 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KC-59-42	KTJ-17	KTD-80
KC-59-61	KTJ-17	KTD-77
KC-59-62	KTJ-17	KTD-77
KC-59-63	KTJ-17	KTD-78
KC-59-64	KTJ-17	KTD-78
KC-59-85	KTJ-24	KTD-81
KC-59-96	KTJ-19	KTD-89
KD-19-26	KTJ-24	KTD-81
KD-19-28	KTJ-22	KTD-81
KD-19-29	KTJ-23	KTD-84
KD-19-33	KTJ-18	KTD-88
KD-19-44	KTJ-18	KTD-88
KD-19-45	KTJ-18	KTD-88
KD-19-49	KTJ-18	KTD-88
KD-19-52	KTJ-18	KTD-88
KD-19-56	KTJ-18	KTD-88
KD-39-08	KTJ-24	KTD-81
KD-39-09	KTJ-24	KTD-81
KD-39-10	KTJ-23	KTD-214
KD-39-21	KTJ-18	KTD-88
KD-59-100	KTJ-17	KTD-77
KD-59-101	KTJ-17	KTD-77
KD-59-155	KTJ-24	KTD-81
KD-59-156	KTJ-24	KTD-81
KD-59-33	KTJ-22	KTD-81
KD-59-35	KTJ-22	KTD-81
KD-59-38	KTJ-24	KTD-81
KD-59-40	KTJ-24	KTD-81
KD-59-41	KTJ-24	KTD-81
KD-59-42	KTJ-23	KTD-84
KD-59-43	KTJ-24	KTD-81
KD-59-44	KTJ-18	KTD-88
KD-59-50	KTJ-18	KTD-88
KD-59-55	KTJ-88	KTD-90

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 4 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KD-59-57	KTJ-17	KTD-79
KD-59-90	KTJ-18	KTD-88
KD-59-94	KTJ-18	KTD-88
KD-59-95	KTJ-17	KTD-88
KG-59-16	KTJ-24	KTD-81
KG-59-22	KTJ-17	KTD-79
KG-59-23	KTJ-62	KTD-117
KG-59-25	KTJ-24	KTD-81
KG-59-26	KTJ-17	KTD-79
KH-19-12	KTJ-23	KTD-82
KH-19-13	KTJ-23	KTD-82
KH-19-14	KTJ-23	KTD-82
KH-19-22	KTJ-23	KTD-82
KH-39-11	KTJ-23	KTD-82
KH-39-12	KTJ-23	KTD-82
KH-59-19	KTJ-23	KTD-82
KH-59-20	KTJ-23	KTD-82
KH-59-21	KTJ-23	KTD-82
KH-59-24	KTJ-23	KTD-82
KH-59-28	KTJ-49	KTD-105
KH-59-31	KTJ-25	KTD-82
KH-59-47	-	-
KH-59-50	KTJ-23	KTD-82
KH-59-53	KTJ-11	KTD-82
KH-59-54	KTJ-11	KTD-82
KH-59-56	KTJ-17	KTD-77
KH-59-60	KTJ-23	KTD-82
KH-59-78	KTJ-23	KTD-82
KN-19-30	KTJ-24	KTD-81
KN-19-31	KTJ-24	KTD-81
KN-19-37	KTJ-20	KTD-85
KN-19-44	KTJ-24	KTD-81
KN-19-48	KTJ-18	KTD-117
KN-19-68	KTJ-18	KTD-117

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 4 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KN-19-73	KTJ-24	KTD-81
KN-19-78	KTJ-18	KTD-117
KN-19-79	KTJ-18	KTD-103
KN-39-19	KTJ-22	KTD-81
KN-39-20	KTJ-22	KTD-81
KN-39-21	KTJ-18	KTD-117
KN-39-23	KTJ-22	KTD-81
KN-39-42	KTJ-18	KTD-117
KN-39-48	KTJ-18	KTD-117
KN-39-51	KTJ-18	KTD-103
KN-39-55	KTJ-22	KTD-81
KN-59-107	KTJ-6	KTD-79
KN-59-110	KTJ-73	KTD-79
KN-59-113	KTJ-18	KTD-117
KN-59-128	KTJ-18	KTD-117
KN-59-129	KTJ-63	KTD-79
KN-59-131	KTJ-211	KTD-81
KN-59-133	KTJ-17	KTD-94
KN-59-135	KTJ-22	KTD-81
KN-59-136	KTJ-27	KTD-81
KN-59-138	KTJ-17	KTD-77
KN-59-18	KTJ-22	KTD-31
KN-59-237	KTJ-24	KTD-81
KN-59-238	KTJ-33	KTD-81
KN-59-28	-	-
KN-59-29	KTJ-63	KTD-79
KN-59-31	KTJ-45	KTD-104
KN-59-34	KTJ-22	KTD-81
KN-59-46	KTJ-22	KTD-81
KN-59-47	KTJ-23	KTD-81
KN-59-48	KTJ-24	KTD-81
KN-59-49	KTJ-18	KTD-117
KN-59-50	KTJ-24	KTD-81
KN-59-53	KTJ-33	KTD-81

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

Table 4 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KN-59-56	KTJ-27	KTD-81
KN-59-57	KTJ-22	KTD-81
KN-59-69	KTJ-18	KTD-117
KS-89-31	-	-
KS-89-35	-	-
KS-89-42	-	-
KU-59-19	KTJ-141	KTD-91
KU-59-21	KTJ-44	KTD-86
KU-59-25	KTJ-16	KTD-106
KU-59-32	KTJ-44	KTD-86
KU-59-67	KTJ-16	KTD-106

B. Coax Connector Crimp Tools

Table 5
COAX CRIMP TOOL TYPES

Crimp Tool Basic Unit	Type
CT-32	Pneumatic
HX23	Pneumatic
HX4	Hand
KTH-1000	Hand
KTM-1000	Electric
KTM-3000	Pneumatic
KTM-4000	Pneumatic
M22520/5-01	Hand

Table 6
COAX CONNECTOR TOOL CODES

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KA-19-21	429H	-
KA-19-23	255H	-
KA-19-24	255H	-
KA-19-25	213H	-
KA-19-48	105H	-
KA-19-50	213H	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 6 COAX CONNECTOR TOOL CODES (Continued)

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KA-19-51	213H	-
KA-19-63	255H	-
KA-39-12	213H	-
KA-39-15	213H	-
KA-39-31	178H	-
KA-39-32	213H	-
KA-59-128	213H	-
KA-59-134	213H	-
KA-59-138	429H	-
KA-59-166	213H	-
KA-59-267	429H	-
KA-59-29	213H	-
KA-59-31	429H	-
KA-59-318	429H	-
KA-59-319	429H	-
KA-59-32	429H	-
KA-59-36	429H	-
KA-59-39	255H	-
KA-59-40	255H	-
KA-59-41	213H	-
KA-59-59	384H	-
KA-59-98	213H	-
KA-59-99	213H	-
KC-19-100	213H	-
KC-19-101	213H	-
KC-19-113	255H	-
KC-19-116	213H	-
KC-19-121	213H	069H
KC-19-125	255H	-
KC-19-136	178H	-
KC-19-21	213H	-
KC-19-31	213H	-
KC-19-32	255H	-
KC-19-33	255H	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 6 COAX CONNECTOR TOOL CODES (Continued)

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KC-19-34	255H	-
KC-19-57	255H	-
KC-19-69	178H	-
KC-39-102	213H	-
KC-39-14	213H	-
KC-39-20	213H	-
KC-39-21	255H	-
KC-39-22	255H	-
KC-39-25	213H	-
KC-39-31	178H	-
KC-39-44	178H	-
KC-39-48	213H	-
KC-39-56	213H	-
KC-39-57	213H	-
KC-59-111	178H	-
KC-59-136	105H	-
KC-59-172	429H	-
KC-59-177	213H	-
KC-59-178	213H	-
KC-59-188	213H	-
KC-59-191	213H	-
KC-59-194	178H	-
KC-59-33	213H	-
KC-59-38	213H	-
KC-59-41	255H	-
KC-59-42	255H	-
KC-59-61	213H	069H
KC-59-62	213H	-
KC-59-63	255H	-
KC-59-64	255H	-
KC-59-85	429H	-
KC-59-96	178H	-
KD-19-26	384H	-
KD-19-28	429H	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 6 COAX CONNECTOR TOOL CODES (Continued)

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KD-19-29	429H	-
KD-19-33	213H	-
KD-19-44	213H	-
KD-19-45	213H	-
KD-19-49	213H	-
KD-19-52	213H	-
KD-19-56	213H	-
KD-39-08	384H	-
KD-39-09	429H	-
KD-39-10	384H	-
KD-39-21	213H	-
KD-59-100	213H	-
KD-59-101	213H	-
KD-59-155	429H	-
KD-59-156	429H	-
KD-59-33	384H	-
KD-59-35	384H	-
KD-59-38	384H	-
KD-59-40	384H	-
KD-59-41	429H	-
KD-59-42	429H	-
KD-59-43	429H	-
KD-59-44	213H	-
KD-59-50	213H	-
KD-59-55	178H	-
KD-59-57	213H	-
KD-59-90	213H	-
KD-59-94	213H	-
KD-59-95	213H	-
KG-59-16	429H	-
KG-59-22	213H	-
KG-59-23	213H	-
KG-59-25	429H	100H
KG-59-26	213H	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 6 COAX CONNECTOR TOOL CODES (Continued)

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KH-19-12	429H	-
KH-19-13	384H	-
KH-19-14	429H	-
KH-19-22	429H	-
KH-39-11	384H	-
KH-39-12	429H	-
KH-59-19	384H	-
KH-59-20	384H	-
KH-59-21	429H	-
KH-59-24	429H	-
KH-59-28	429H	-
KH-59-31	429H	-
KH-59-47	384H	-
KH-59-50	429H	-
KH-59-53	429H	-
KH-59-54	213H	-
KH-59-56	213H	-
KH-59-60	429H	-
KH-59-78	429H	-
KN-19-30	384H	-
KN-19-31	429H	-
KN-19-37	213H	-
KN-19-44	429H	-
KN-19-48	213H	-
KN-19-68	213H	-
KN-19-73	429H	-
KN-19-78	213H	-
KN-19-79	255H	-
KN-39-19	384H	-
KN-39-20	429H	-
KN-39-21	213H	-
KN-39-23	429H	-
KN-39-42	213H	-
KN-39-48	213H	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 6 COAX CONNECTOR TOOL CODES (Continued)

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KN-39-51	255H	-
KN-39-55	429H	-
KN-59-107	213H	-
KN-59-110	213H	-
KN-59-113	213H	-
KN-59-128	213H	-
KN-59-129	213H	-
KN-59-131	429H	-
KN-59-133	255H	-
KN-59-135	429H	-
KN-59-136	429H	-
KN-59-138	213H	-
KN-59-18	384H	-
KN-59-237	429H	-
KN-59-238	429H	-
KN-59-28	429H	-
KN-59-29	213H	-
KN-59-31	384H	-
KN-59-34	429H	-
KN-59-46	384H	-
KN-59-47	384H	-
KN-59-48	429H	-
KN-59-49	213H	-
KN-59-50	429H	-
KN-59-53	429H	100H
KN-59-56	429H	-
KN-59-57	429H	-
KN-59-69	213H	-
KS-89-31	213H	-
KS-89-35	429H	-
KS-89-42	255H	-
KU-59-19	178H	-
KU-59-21	384H	-
KU-59-25	213H	-

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 6 COAX CONNECTOR TOOL CODES (Continued)

Connector	Tool Code	
	K-Grip Sleeve	Center Contact
KU-59-32	429H	-
KU-59-67	213H	-

Table 7
COAX CONNECTOR CENTER CONTACT CRIMP TOOLS

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
069H	CT-32	-	683-51470-1	0.069
			KTH-2001	0.069
			KTH-2061	0.069
			KTH-2111	0.069
			KTH-2128	0.069
			KTH-2161	0.069
			KTH-2216	0.069
069H	KTH-1000	-	683-51470-1	0.069
			KTH-2001	0.069
			KTH-2061	0.069
			KTH-2111	0.069
			KTH-2128	0.069
			KTH-2161	0.069
			KTH-2216	0.069
069H	KTM-1000	KTM-1099	683-51470-1	0.069
			KTH-2001	0.069
			KTH-2061	0.069
			KTH-2111	0.069
			KTH-2128	0.069
			KTH-2161	0.069
			KTH-2216	0.069

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 7 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
069H	KTM-3000	-	683-51470-1	0.069
			KTH-2001	0.069
			KTH-2061	0.069
			KTH-2111	0.069
			KTH-2128	0.069
			KTH-2161	0.069
			KTH-2216	0.069
069H	KTM-4000	-	683-51470-1	0.069
			KTH-2001	0.069
			KTH-2061	0.069
			KTH-2111	0.069
			KTH-2128	0.069
			KTH-2161	0.069
			KTH-2216	0.069
100H	227-944	-	227-1221-25	0.100
			227-1221-57	0.100
			227-1351-3	0.100
			227-956-4	0.100
			M22520/5-57	0.100
100H	227-956-4	-	-	0.100
100H	CT-32	-	KTH-1078	0.100
			KTH-1079	0.100
			KTH-2004	0.100
			KTH-2042	0.100
			KTH-2105	0.100
			KTH-2106	0.100
			KTH-2127	0.100
			KTH-2211	0.100
			KTH-2212	0.100
			KTH-2213	0.100
			KTH-2231	0.100

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 7 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
100H	HX23	-	227-1221-25	0.100
			227-1221-57	0.100
			227-1351-3	0.100
			227-1351-4	0.100
			227-956-4	0.100
			M22520/5-57	0.100
100H	HX4	-	227-1221-25	0.100
			227-1221-57	0.100
			227-1351-3	0.100
			227-1351-4	0.100
			227-956-4	0.100
			M22520/5-57	0.100
100H	KTH-1000	-	KTH-1078	0.100
			KTH-1079	0.100
			KTH-2004	0.100
			KTH-2042	0.100
			KTH-2105	0.100
			KTH-2106	0.100
			KTH-2127	0.100
			KTH-2211	0.100
			KTH-2212	0.100
			KTH-2213	0.100
			KTH-2231	0.100

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

Table 7 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
100H	KTM-1000	KTM-1099	KTH-1078	0.100
			KTH-1079	0.100
			KTH-2004	0.100
			KTH-2042	0.100
			KTH-2105	0.100
			KTH-2106	0.100
			KTH-2127	0.100
			KTH-2211	0.100
			KTH-2212	0.100
			KTH-2213	0.100
			KTH-2231	0.100
100H	KTM-3000	-	KTH-1078	0.100
			KTH-1079	0.100
			KTH-2004	0.100
			KTH-2042	0.100
			KTH-2105	0.100
			KTH-2106	0.100
			KTH-2127	0.100
			KTH-2211	0.100
			KTH-2212	0.100
			KTH-2213	0.100
			KTH-2231	0.100
100H	KTM-4000	-	KTH-1078	0.100
			KTH-1079	0.100
			KTH-2004	0.100
			KTH-2042	0.100
			KTH-2105	0.100
			KTH-2106	0.100
			KTH-2127	0.100
			KTH-2211	0.100
			KTH-2212	0.100
			KTH-2213	0.100
			KTH-2231	0.100

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 7 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
100H	M22520/5-01	-	227-1221-25	0.100
			227-1221-57	0.100
			227-1351-3	0.100
			227-1351-4	0.100
			227-956-4	0.100
			M22520/5-57	0.100

Table 8
COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
105H	612648	-	612734	0.105
	CT-32	-	KTH-2008	0.105
			KTH-2230	0.105
	HX23	-	M22520/5-03	0.105
	HX4	-	M22520/5-03	0.105
	KTH-1000	-	KTH-2008	0.105
			KTH-2230	0.105
	KTM-1000	KTM-1099	KTH-2008	0.105
			KTH-2230	0.105
	KTM-3000	-	KTH-2008	0.105
			KTH-2230	0.105
	KTM-4000	-	KTH-2008	0.105
			KTH-2230	0.105
	M22520/5-01	-	M22520/5-03	0.105

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 8 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
178H	612648	-	612642	0.178
	CT-32	-	KTH-2007	0.178
	HX23	-	M22520/5-05	0.178
			M22520/5-41	0.178
			Y197	0.178
	HX4	-	M22520/5-05	0.178
			M22520/5-41	0.178
			Y197	0.178
	KTH-1000	-	KTH-2007	0.178
	KTM-1000	KTM-1099	KTH-2007	0.178
	KTM-3000	-	KTH-2007	0.178
	KTM-4000	-	KTH-2007	0.178
	M22520/5-01	-	M22520/5-05	0.178
			M22520/5-41	0.178
			Y197	0.178
213H	227-944	-	M22520/5-19	0.213
	612648	-	612673	0.213
	CT-32	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	HX23	-	M22520/5-05	0.213
			M22520/5-19	0.213
			Y142	0.213
			Y197	0.213
			Y322	0.213
	HX4	-	M22520/5-05	0.213
			M22520/5-19	0.213
			Y142	0.213
			Y197	0.213
			Y322	0.213
	KTH-1000	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 8 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
213H	KTM-1000	KTM-1099	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	KTM-3000	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	KTM-4000	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	M22520/5-01	-	M22520/5-05	0.213
			M22520/5-19	0.213
			Y142	0.213
			Y197	0.213
			Y322	0.213
	ST2966M	-	ST2966M-6	0.213
255H	612648	-	612675	0.255
	HX23	-	M22520/5-19	0.255
			Y142	0.255
	HX4	-	M22520/5-19	0.255
			Y142	0.255
	KTH-1000	-	KTH-2002	0.255
	KTM-1000	KTM-1099	KTH-2002	0.255
	KTM-3000	-	KTH-2002	0.255
	KTM-4000	-	KTH-2002	0.255
	M22520/5-01	-	M22520/5-19	0.255
			Y142	0.255
	ST2966M	-	ST2966M-8	0.255

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 8 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
384H	612648	-	612739	0.384
	CT-32	-	KTH-2003	0.384
	HX23	-	M22520/5-23	0.384
	HX4	-	M22520/5-23	0.384
	KTH-1000	-	KTH-2003	0.384
	KTM-1000	KTM-1099	KTH-2003	0.384
	KTM-3000	-	KTH-2003	0.384
	KTM-4000	-	KTH-2003	0.384
	M22520/5-01	-	M22520/5-23	0.384
	ST2352-5-Y	-	ST2352-5-1	0.384
	ST2966M	-	ST2966M-13	0.384
429H	612648	-	612807	0.429
	CT-32	-	KTH-2004	0.429
			KTH-2235	0.429
	HX23	-	M22520/5-25	0.429
	HX4	-	M22520/5-25	0.429
	KTH-1000	-	KTH-2004	0.429
			KTH-2235	0.429
	KTM-1000	KTM-1099	KTH-2004	0.429
			KTH-2235	0.429
	KTM-3000	-	KTH-2004	0.429
			KTH-2235	0.429
	KTM-4000	-	KTH-2004	0.429
			KTH-2235	0.429
	M22520/5-01	-	M22520/5-25	0.429
	ST2352-5-Y	-	ST2352-5-2	0.429
	ST2966M	-	ST2966M-16	0.429

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

3. CONNECTOR ASSEMBLY

A. Cable Preparation Dimensions

Table 9
CABLE PREPARATION DIMENSIONS

Connector	Dimension	Length (inch)	
		Target	Tolerance
KA-19-21	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KA-19-23	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02
KA-19-24	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-19-25	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-19-48	A	0.77	±0.02
	B	0.58	±0.02
	C	0.11	±0.02
	D	0.24	±0.02
KA-19-50	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-19-51	A	0.72	±0.02
	B	0.22	±0.02
	C	0.11	±0.02
	D	0.11	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KA-19-63	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-39-12	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-39-15	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-39-31	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-39-32	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-128	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-134	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-138	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KA-59-166	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-267	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KA-59-29	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-31	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KA-59-318	A	0.82	±0.02
	B	0.60	±0.02
	C	0.16	±0.02
	D	0.40	±0.02
KA-59-319	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KA-59-32	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KA-59-36	A	0.86	±0.02
	B	0.64	±0.02
	C	0.20	±0.02
	D	0.04	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KA-59-39	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02
KA-59-40	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-41	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-59	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KA-59-98	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KA-59-99	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-100	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-101	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KC-19-113	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-116	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-121	A	0.58	±0.02
	B	0.22	±0.02
	C	0.11	±0.02
	D	0.47	±0.02
KC-19-125	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02
KC-19-136	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-21	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-31	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-32	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KC-19-33	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02
KC-19-34	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-57	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-19-69	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-102	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-14	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-20	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-21	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KC-39-22	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-25	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-31	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-44	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-48	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-56	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-39-57	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-111	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KC-59-136	A	0.77	±0.02
	B	0.58	±0.02
	C	0.11	±0.02
	D	0.24	±0.02
KC-59-172	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KC-59-177	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-178	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-188	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-191	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-194	A	0.75	±0.02
	B	0.56	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-33	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KC-59-38	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-41	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-42	A	0.77	±0.02
	B	0.55	±0.02
	C	0.09	±0.02
	D	0.17	±0.02
KC-59-61	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-62	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-63	A	0.72	±0.02
	B	0.50	±0.02
	C	0.14	±0.02
	D	0.08	±0.02
KC-59-64	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KC-59-85	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KC-59-96	A	0.75	±0.02
	B	0.56	±0.02
	C	0.19	±0.02
	D	0.11	±0.02
KD-19-26	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-19-28	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-19-29	A	1.11	±0.02
	B	0.89	±0.02
	C	0.16	±0.02
	D	0.34	±0.02
KD-19-33	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-19-44	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-19-45	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-19-49	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KD-19-52	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-19-56	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-39-08	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-39-09	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-39-10	A	1.13	±0.02
	B	0.91	±0.02
	C	0.14	±0.02
	D	0.47	±0.02
KD-39-21	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-59-100	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KD-59-101	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KD-59-155	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-59-156	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-59-33	A	0.88	±0.02
	B	0.66	±0.02
	C	0.22	±0.02
	D	0.04	±0.02
KD-59-35	A	0.88	±0.02
	B	0.66	±0.02
	C	0.22	±0.02
	D	0.04	±0.02
KD-59-38	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-59-40	A	0.77	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.05	±0.02
KD-59-41	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KD-59-42	A	1.11	±0.02
	B	0.89	±0.02
	C	0.16	±0.02
	D	0.34	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KD-59-43	A	0.77	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.05	±0.02
KD-59-44	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-59-50	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-59-55	A	0.81	±0.02
	B	0.63	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-59-57	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02
KD-59-90	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-59-94	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KD-59-95	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KG-59-16	A	0.83	±0.02
	B	0.61	±0.02
	C	0.17	±0.02
	D	0.04	±0.02
KG-59-22	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02
KG-59-23	A	1.06	±0.02
	B	0.84	±0.02
	C	0.22	±0.02
	D	0.12	±0.02
KG-59-25	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KG-59-26	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02
KH-19-12	A	1.16	±0.02
	B	0.25	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-19-13	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-19-14	A	1.16	±0.02
	B	0.25	±0.02
	C	0.22	±0.02
	D	0.30	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KH-19-22	A	1.13	±0.02
	B	0.91	±0.02
	C	0.28	±0.02
	D	0.29	±0.02
KH-39-11	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-39-12	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-59-19	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-59-20	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-59-21	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-59-24	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-59-28	A	2.06	±0.02
	B	1.84	±0.02
	C	0.70	±0.02
	D	0.74	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KH-59-31	A	1.30	±0.02
	B	1.08	±0.02
	C	0.39	±0.02
	D	0.29	±0.02
KH-59-47	A	0.77	±0.02
	B	0.22	±0.02
	C	0.11	±0.02
	D	0.04	±0.02
KH-59-50	A	0.81	±0.02
	B	0.59	±0.02
	C	0.16	±0.02
	D	0.04	±0.02
KH-59-53	A	0.89	±0.02
	B	0.67	±0.02
	C	0.13	±0.02
	D	0.34	±0.02
KH-59-54	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KH-59-56	A	0.72	±0.02
	B	0.50	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KH-59-60	A	1.13	±0.02
	B	0.91	±0.02
	C	0.22	±0.02
	D	0.30	±0.02
KH-59-78	A	1.13	±0.02
	B	0.91	±0.02
	C	0.28	±0.02
	D	0.29	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KN-19-30	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-19-31	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-19-37	A	1.03	±0.02
	B	0.81	±0.02
	C	0.16	±0.02
	D	0.37	±0.02
KN-19-44	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-19-48	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-19-68	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-19-73	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-19-78	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KN-19-79	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KN-39-19	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-39-20	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-39-21	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-39-23	A	0.88	±0.02
	B	0.66	±0.02
	C	0.22	±0.02
	D	0.04	±0.02
KN-39-42	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.19	±0.02
KN-39-48	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-39-51	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.13	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KN-39-55	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-107	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02
KN-59-110	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02
KN-59-113	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-59-128	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-59-129	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02
KN-59-131	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-133	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.19	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KN-59-135	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-136	A	0.77	±0.02
	B	0.54	±0.02
	C	0.11	±0.02
	D	0.05	±0.02
KN-59-138	A	0.72	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.11	±0.02
KN-59-18	A	0.88	±0.02
	B	0.66	±0.02
	C	0.22	±0.02
	D	0.04	±0.02
KN-59-237	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-238	A	0.77	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.05	±0.02
KN-59-28	A	2.09	±0.02
	B	0.38	±0.02
	C	0.72	±0.02
	D	0.74	±0.02
KN-59-29	A	0.83	±0.02
	B	0.61	±0.02
	C	0.11	±0.02
	D	0.21	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KN-59-31	A	1.20	±0.02
	B	0.98	±0.02
	C	0.13	±0.02
	D	0.47	±0.02
KN-59-34	A	0.88	±0.02
	B	0.66	±0.02
	C	0.22	±0.02
	D	0.04	±0.02
KN-59-46	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-47	A	0.77	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.05	±0.02
KN-59-48	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-49	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KN-59-50	A	0.81	±0.02
	B	0.59	±0.02
	C	0.19	±0.02
	D	0.04	±0.02
KN-59-53	A	0.77	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.05	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KN-59-56	A	0.77	±0.02
	B	0.55	±0.02
	C	0.11	±0.02
	D	0.05	±0.02
KN-59-57	A	0.88	±0.02
	B	0.66	±0.02
	C	0.22	±0.02
	D	0.04	±0.02
KN-59-69	A	0.78	±0.02
	B	0.56	±0.02
	C	0.16	±0.02
	D	0.12	±0.02
KS-89-31	A	-	±0.02
	B	-	±0.02
	C	-	±0.02
	D	-	±0.02
KS-89-35	A	-	±0.02
	B	-	±0.02
	C	-	±0.02
	D	-	±0.02
KS-89-42	A	-	±0.02
	B	-	±0.02
	C	-	±0.02
	D	-	±0.02
KU-59-19	A	1.00	±0.02
	B	0.81	±0.02
	C	0.13	±0.02
	D	0.34	±0.02
KU-59-21	A	1.24	±0.02
	B	1.02	±0.02
	C	0.13	±0.02
	D	0.50	±0.02

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 9 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Dimension	Length (inch)	
		Target	Tolerance
KU-59-25	A	0.89	±0.02
	B	0.67	±0.02
	C	0.13	±0.02
	D	0.34	±0.02
KU-59-32	A	1.24	±0.02
	B	1.02	±0.02
	C	0.13	±0.02
	D	0.50	±0.02
KU-59-67	A	0.89	±0.02
	B	0.67	±0.02
	C	0.13	±0.02
	D	0.34	±0.02

B. Cable Preparation

For the general conditions that are applicable for the preparation of coax connectors, refer to Subject 20-51-00.

- (1) Make a selection of a heat shrinkable sleeve from Table 3.

NOTE: An equivalent sleeve is a satisfactory alternative. Refer to Subject 20-00-11.

- (2) Put a 1.5 inch length of heat shrinkable sleeve on the cable.
- (3) Examine the threads on the rear of the connector shell for contamination or thread lock compound.
- (4) If the threads have material on them, clean the threads:
- (a) Fully engage the threads the clamp nut and the threads of the connector shell.
 - (b) Remove the clamp nut from the connector shell.
- (5) Put these components on the cable in this sequence:
- The clamp nut
 - The gland
 - The vee gasket
 - The K-Grip sleeve
 - The jacket gasket.

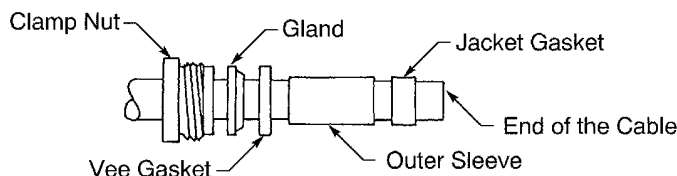
Refer to Figure 3.

NOTE: The jacket gasket is not supplied with all connectors.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447607 S00061545996_V1

POSITION OF THE COMPONENTS ON THE CABLE

Figure 3

- (6) Cut the end of the cable to make it perpendicular to the longitudinal axis of the cable.
- (7) Make a selection of a cable jacket trim jig from Table 4.

NOTE: Cable preparation without a trim jig is a satisfactory alternative. Refer to Paragraph 4.A.

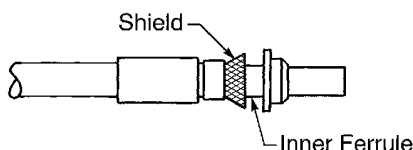
NOTE: If a trim jig is not specified for the connector, the cable must be prepared without a trim jig. Refer to Paragraph 4.A.

- (8) Prepare the cable with the trim jig. Refer to Paragraph 4.B.

C. K-Grip Assembly

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

- (1) Find the K-Grip sleeve crimp tool code. Refer to Table 6.
- (2) Make a selection of the K-Grip sleeve crimp tool from Table 8.
Make sure that the tool is applicable for the tool code.
- (3) Move the strands of the shield apart.
- (4) Put the K-Grip on the end of the cable. Refer to Figure 4.
Make sure that the inner ferrule is between the shield and the dielectric.



2447608 S00061545997_V1

POSITION OF THE K-GRIP ON THE CABLE

Figure 4

- (5) Push the K-Grip rearward on the cable. Refer to Figure 5.

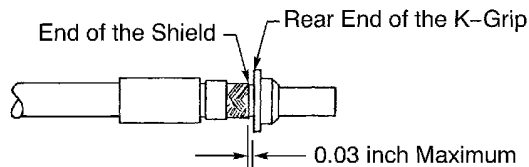
20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Make sure that:

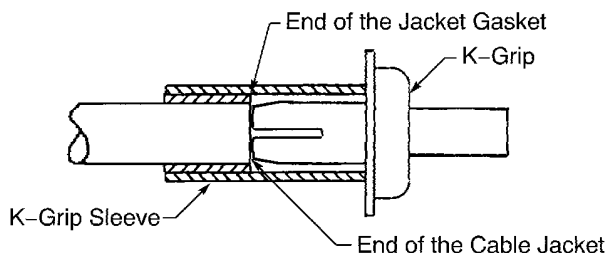
- The rear end of the inner ferrule is against the end of the jacket
- The end of the shield is not more than 0.03 inch from the rear end of the K-Grip.



2447609 S00061545998_V1

POSITION OF THE K-GRIP
Figure 5

- (6) If a jacket gasket is on the cable, push the jacket gasket forward until the forward end of the gasket is aligned with the end of the cable jacket. Refer to Figure 6.



2450270 S00061545999_V1

POSITION OF THE K-GRIP, THE JACKET GASKET, AND THE K-GRIP SLEEVE
Figure 6

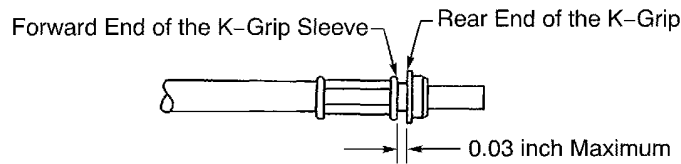
- (7) Push the K-Grip sleeve forward until the forward end of the sleeve is against the rear end of the K-Grip. Refer to Figure 6.
- (8) Hold the K-Grip, the K-Grip sleeve, and the cable in their positions.
- (9) Put the assembly in the crimp tool.
- (10) Align the rear end of the K-Grip sleeve with the nearest edge of the tool die.
- (11) Crimp the K-Grip sleeve. Refer to Figure 7.

Make sure the forward end of the K-Grip sleeve is not more than 0.03 inch from the rear end of the K-Grip.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

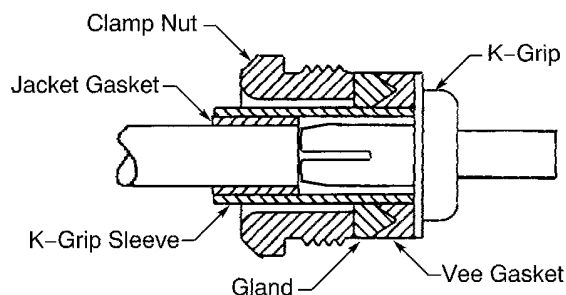


2447610 S00061546000_V1

POSITION OF THE K-GRIP SLEEVE

Figure 7

- (12) Push the vee gasket forward until it is against the rear end of the K-Grip. Refer to Figure 8.



2450238 S00061546001_V1

POSITION OF THE VEE GASKET, THE GLAND, AND THE CLAMP NUT

Figure 8

- (13) Push the gland forward until it is against the vee gasket. Refer to Figure 8.
- (14) Push the clamp nut forward until it is against the gland. Refer to Figure 8.

D. Center Contact Assembly - Crimp Type Contacts

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

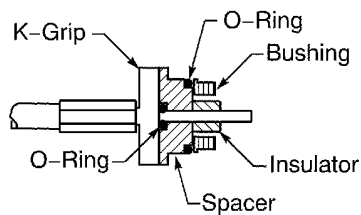
- (1) Find the center contact tool code. Refer to Table 6.
- (2) Make a selection of a contact crimp tool from Table 7.
Make sure that the tool is applicable for the tool code.
- (3) If the connector is supplied with these components, put them on the end of the cable in this sequence:
 - A smaller O-Ring
 - A spacer
 - A larger O-Ring
 - A bushing
 - An insulator.

Refer to Figure 9.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447612 S00061546002_V1

POSITION OF THE COMPONENTS ON THE END OF THE CABLE

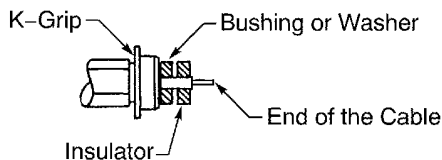
Figure 9

- (4) If the connector is supplied with these components, put them on the end of the cable in this sequence:

- A bushing or a washer
- A cable end insulator
- A mating end insulator.

Refer to:

- Figure 10 for the installation of the insulator and the bushing or the washer
- Figure 11 for the installation of the washer, the cable end insulator, and the mating end insulator.



2447611 S00061546003_V1

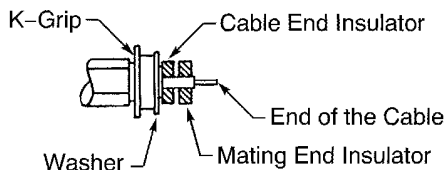
POSITION OF THE INSULATOR AND THE BUSHING OR THE WASHER

Figure 10

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2450271 S00061546004_V1

POSITION OF THE WASHER, THE CABLE END INSULATOR, AND THE MATING END INSULATOR

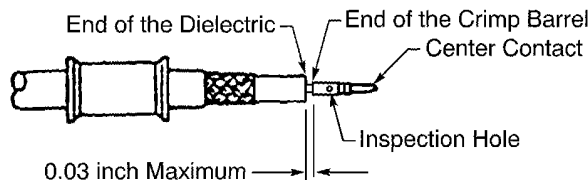
Figure 11

- (5) If an insulator is installed, or the dielectric is a metal, semi-rigid material, remove the necessary length of dielectric without a trim jig.
Refer to Paragraph 4.C.
- (6) If an insulator is not installed and the dielectric is not a metal, semi-rigid material:
 - (a) Make a selection of a dielectric trim jig from Table 4.
NOTE: Removal of the dielectric without a trim jig is a satisfactory alternative. Refer to Paragraph 4.C.
NOTE: If a trim jig is not specified for the connector, the dielectric must be removed without a trim jig. Refer to Paragraph 4.C.
 - (b) Remove the dielectric with the trim jig. Refer to Paragraph 4.D.
- (7) If the dielectric is a metal, semi-rigid material and a spacer is supplied with the connector, put the spacer on the end of the dielectric.
- (8) Put the conductor in the crimp barrel of the center contact. Refer to Figure 12.
Make sure that:
 - All of the strands of the conductor are in the crimp barrel of the contact
 - The conductor can be seen in the inspection hole of the contact
 - The distance from the end of the dielectric to the rear end of the crimp barrel is not more than 0.03 inch.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447571 S00061546005_V1

POSITION OF THE CENTER CONTACT ON THE CONDUCTOR

Figure 12

- (9) Crimp the contact.
Make sure that the crimp is between the inspection hole and the rear end of the crimp barrel.
- (10) Examine the contact assembly for these types of damage:
 - The finish has damage
 - The crimp barrel of the contact has a crack.

NOTE: If the contact has damage, it must be replaced.

E. Center Contact Assembly - Solder Type Contacts

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Make a selection of a Temperature Grade C solder. Refer to Subject 20-00-11.

CAUTION: DO NOT USE A TEMPERATURE GRADE D SOLDER. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CABLE CAN OCCUR.

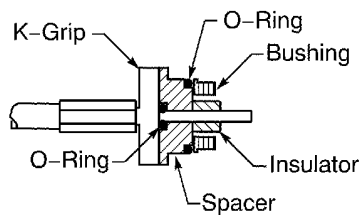
- (2) If the connector is supplied with these components, put them on the end of the cable in this sequence:
 - A smaller O-Ring
 - A spacer
 - A larger O-Ring
 - A bushing
 - An insulator.

Refer to Figure 13.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447612 S00061546002_V1

POSITION OF THE COMPONENTS ON THE END OF THE CABLE

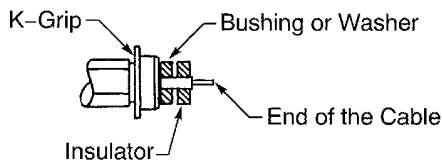
Figure 13

- (3) If the connector is supplied with these components, put them on the end of the cable in this sequence:

- A bushing or the washer
- A cable end insulator
- A mating end insulator.

Refer to:

- Figure 14 for the installation of the insulator and the bushing or the washer
- Figure 15 for the installation of the washer, the cable end insulator, and the mating end insulator.



2447611 S00061546003_V1

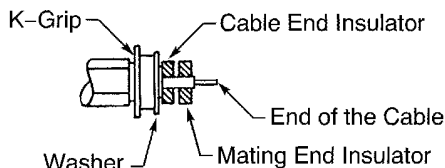
POSITION OF THE INSULATOR AND THE BUSHING OR THE WASHER

Figure 14

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2450271 S00061546004_V1

POSITION OF THE WASHER, THE CABLE END INSULATOR, AND THE MATING END INSULATOR

Figure 15

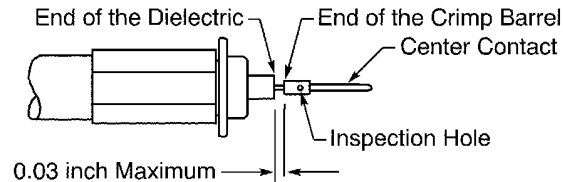
- (4) If an insulator is installed, or the dielectric is a metal, semi-rigid material, remove the necessary length of dielectric without a trim jig.
Refer to Paragraph 4.C.
- (5) If an insulator is not installed and the dielectric is not a metal, semi-rigid material:
 - (a) Make a selection of a dielectric trim jig from Table 4.
NOTE: Removal of the dielectric without a trim jig is a satisfactory alternative. Refer to Paragraph 4.C.
NOTE: If a trim jig is not specified for the connector, the dielectric must be removed without a trim jig. Refer to Paragraph 4.C.
 - (b) Remove the dielectric with the trim jig. Refer to Paragraph 4.D.
- (6) Tin the center conductor.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.
- (7) If the dielectric is a metal, semi-rigid material and a spacer is supplied with the connector, put the spacer on the end of the dielectric.
- (8) Put the center conductor in the solder barrel of the center contact. Refer to Figure 16.
Make sure that:
 - All of the strands of the conductor are in the solder barrel
 - The conductor can be seen in the inspection hole
 - The distance from the end of the dielectric to the rear end of the solder barrel is not more than 0.03 inch.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447621 S00061546008_V1

POSITION OF THE CENTER CONTACT ON THE CONDUCTOR

Figure 16

- (9) Apply a small quantity of solder in the inspection hole of the contact.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (10) Remove all of the solder and the flux from the outer surface of the contact.

- (11) Examine the contact for damage to the finish.

NOTE: If the contact has damage, it must be replaced.

- (12) If a solder access cover is supplied with the contact, install the cover.

F. Center Contact Assembly - Solder Type Contacts of Right Angle Plug Connectors

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Make a selection of a Temperature Grade C solder. Refer to Subject 20-00-11.

CAUTION: DO NOT USE A TEMPERATURE GRADE D SOLDER. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CABLE CAN OCCUR.

- (2) Make a selection of a solvent from Table 3.

- (3) Make a selection of a primer from Table 3.

- (4) Make a selection of a thread lock compound from Table 3.

- (5) If an insulator is installed, or the dielectric is a metal, semi-rigid material, remove the necessary length of dielectric without a trim jig.

Refer to Paragraph 4.C.

- (6) If an insulator is not installed and the dielectric is not a metal, semi-rigid material:

- (a) Make a selection of a dielectric trim jig from Table 4.

NOTE: Removal of the dielectric without a trim jig is a satisfactory alternative. Refer to Paragraph 4.C.

NOTE: If a trim jig is not specified for the connector, the dielectric must be removed without a trim jig. Refer to Paragraph 4.C.

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

- (b) Remove the dielectric with the trim jig. Refer to Paragraph 4.D.
- (7) Tin the center conductor.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (8) If the dielectric is a metal, semi-rigid material and a spacer is supplied with the connector, put the spacer on the end of the dielectric.
- (9) Install the connector shell. Refer to Paragraph 3.G.
- (10) Apply a small quantity of solder to the end of the conductor and the contact.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (11) Hold the connector shell and lightly pull the cable to make sure that the solder joint is satisfactory.
- (12) If the access cap has threads:
 - (a) Clean the cap with solvent and a clean wiper.
 - (b) Dry the cap with a clean wiper.
 - (c) Apply the primer to the threads of the cap.
 - (d) Let the primer dry for 10 minutes minimum at room temperature.
 - (e) Apply a thin smooth layer of the compound to one or two full threads of the cap.

CAUTION: THE THREAD LOCK COMPOUND DOES NOT MAKE A BOND IF THE COMPONENTS ARE ASSEMBLED MORE THAN 30 MINUTES AFTER THE COMPOUND IS APPLIED.

- (f) Remove the unwanted compound from the cap.
 - (g) Fully engage the threads of the cap and the threads of the connector shell.
 - (h) Tighten the cap.
- (13) If the access cap does not have threads:
 - (a) Put the cap on the connector shell.
 - (b) Apply a small amount of solder around the edge of the cap.

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

G. Connector Shell Installation

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

Table 10
CLAMP NUT TORQUE VALUES

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KA-19-21	90	100
KA-19-23	40	50
KA-19-24	40	50
KA-19-25	40	50
KA-19-48	40	50
KA-19-50	40	50
KA-19-51	40	50
KA-19-63	40	50
KA-39-12	40	50
KA-39-15	40	50
KA-39-31	40	50
KA-39-32	40	50
KA-59-128	40	50
KA-59-134	40	50
KA-59-138	90	100
KA-59-166	40	50
KA-59-267	90	100
KA-59-29	40	50
KA-59-31	65	75
KA-59-318	90	100
KA-59-319	90	100
KA-59-32	65	75
KA-59-36	90	100
KA-59-39	40	50
KA-59-40	40	50
KA-59-41	40	50
KA-59-59	90	100
KA-59-98	40	50
KA-59-99	40	50
KC-19-100	40	50

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 10 CLAMP NUT TORQUE VALUES (Continued)

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KC-19-101	40	50
KC-19-113	40	50
KC-19-116	40	50
KC-19-121	40	50
KC-19-125	40	50
KC-19-136	40	50
KC-19-21	40	50
KC-19-31	40	50
KC-19-32	40	50
KC-19-33	40	50
KC-19-34	40	50
KC-19-57	40	50
KC-19-69	40	50
KC-39-102	40	50
KC-39-14	40	50
KC-39-20	40	50
KC-39-21	40	50
KC-39-22	40	50
KC-39-25	40	50
KC-39-31	40	50
KC-39-44	40	50
KC-39-48	40	50
KC-39-56	40	50
KC-39-57	40	50
KC-59-111	40	50
KC-59-136	40	50
KC-59-172	40	50
KC-59-177	40	50
KC-59-178	40	50
KC-59-188	40	50
KC-59-191	40	50
KC-59-194	40	50
KC-59-33	40	50
KC-59-38	40	50

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 10 CLAMP NUT TORQUE VALUES (Continued)

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KC-59-41	40	50
KC-59-42	40	50
KC-59-61	40	50
KC-59-62	40	50
KC-59-63	40	50
KC-59-64	40	50
KC-59-85	65	75
KC-59-96	40	50
KD-19-26	90	100
KD-19-28	65	75
KD-19-29	65	75
KD-19-33	40	50
KD-19-44	40	50
KD-19-45	40	50
KD-19-49	40	50
KD-19-52	40	50
KD-19-56	40	50
KD-39-08	65	75
KD-39-09	65	75
KD-39-10	65	75
KD-39-21	40	50
KD-59-100	40	50
KD-59-101	40	50
KD-59-155	90	100
KD-59-156	90	100
KD-59-33	65	75
KD-59-35	65	75
KD-59-38	90	100
KD-59-40	90	100
KD-59-41	65	75
KD-59-42	65	75
KD-59-43	65	75
KD-59-44	40	50
KD-59-50	40	50

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 10 CLAMP NUT TORQUE VALUES (Continued)

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KD-59-55	40	50
KD-59-57	40	50
KD-59-90	40	50
KD-59-94	40	50
KD-59-95	40	50
KG-59-16	65	75
KG-59-22	40	50
KG-59-23	40	50
KG-59-25	65	75
KG-59-26	40	50
KH-19-12	90	100
KH-19-13	65	75
KH-19-14	90	100
KH-19-22	65	75
KH-39-11	65	75
KH-39-12	90	100
KH-59-19	65	75
KH-59-20	65	75
KH-59-21	90	100
KH-59-24	90	100
KH-59-28	90	100
KH-59-31	90	100
KH-59-47	65	75
KH-59-50	90	100
KH-59-53	90	100
KH-59-54	90	100
KH-59-56	40	50
KH-59-60	90	100
KH-59-78	90	100
KN-19-30	90	100
KN-19-31	65	75
KN-19-37	40	50
KN-19-44	90	100
KN-19-48	40	50

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 10 CLAMP NUT TORQUE VALUES (Continued)

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KN-19-68	40	50
KN-19-73	90	100
KN-19-78	40	50
KN-19-79	40	50
KN-39-19	90	100
KN-39-20	65	75
KN-39-21	40	50
KN-39-23	90	100
KN-39-42	40	50
KN-39-48	40	50
KN-39-51	40	50
KN-39-55	90	100
KN-59-107	40	50
KN-59-110	40	50
KN-59-113	40	50
KN-59-128	40	50
KN-59-129	40	50
KN-59-131	65	75
KN-59-133	40	50
KN-59-135	90	100
KN-59-136	90	100
KN-59-138	40	50
KN-59-18	90	100
KN-59-237	90	100
KN-59-238	90	100
KN-59-28	90	100
KN-59-29	40	50
KN-59-31	90	100
KN-59-34	40	50
KN-59-46	90	100
KN-59-47	90	100
KN-59-48	90	100
KN-59-49	40	50
KN-59-50	65	75

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 10 CLAMP NUT TORQUE VALUES (Continued)

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KN-59-53	65	75
KN-59-56	90	100
KN-59-57	90	100
KN-59-69	40	50
KS-89-31	40	50
KS-89-35	40	50
KS-89-42	40	50
KU-59-19	40	50
KU-59-21	65	75
KU-59-25	40	50
KU-59-32	65	75
KU-59-67	40	50

- (1) Make a selection of a solvent from Table 3.
- (2) Make a selection of a primer from Table 3.
- (3) Make a selection of a thread lock compound from Table 3.
- (4) If the connector is a right angle connector with an access cap, remove the cap.
- (5) Clean the clamp nut with solvent and a clean wiper.
- (6) Dry the nut with a clean wiper.
- (7) Apply the primer with a spray to the threads of the nut
- (8) Let the primer to dry for 10 minutes minimum at room temperature.
- (9) Apply a layer of thread lock compound on the threads of the clamp nut.

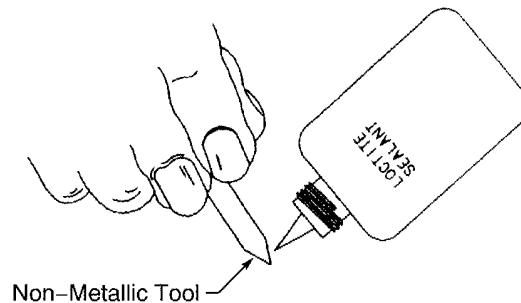
CAUTION: THE THREAD LOCK COMPOUND DOES NOT MAKE A BOND IF THE COMPONENTS ARE ASSEMBLED MORE THAN 30 MINUTES AFTER THE COMPOUND IS APPLIED.

- (a) Put a small quantity of the compound on the tip of a non-metallic, pointed tool. Refer to Figure 17.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



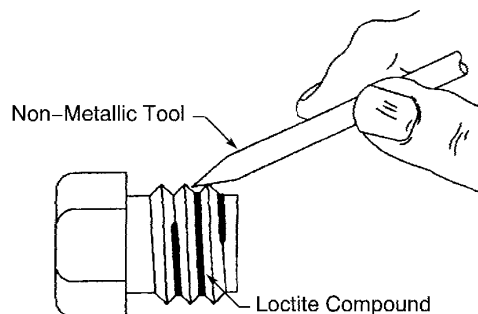
2445958 S00061546010_V1

LOCATION OF THE THREAD LOCK COMPOUND ON THE TOOL

Figure 17

- (b) Apply a thin smooth layer of the compound to one or two full threads of the nut. Refer to Figure 18.

CAUTION: THREAD LOCK COMPOUND IS AN INSULATOR. TOO MUCH THREAD LOCK COMPOUND CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CONNECTOR.



2445959 S00061546012_V1

LOCATION OF THE LOCTITE COMPOUND ON THE THREADS OF THE CLAMP NUT

Figure 18

- (c) If too much thread lock compound is applied, remove the unwanted compound from the nut.
- (10) Push the components rearward until they are against the K-Grip.
- (11) Fully engage the threads of the clamp nut and the threads of the connector shell. Refer to Figure 19.

20-51-11

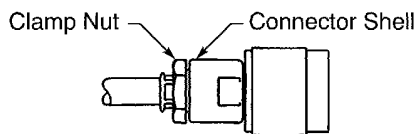


707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

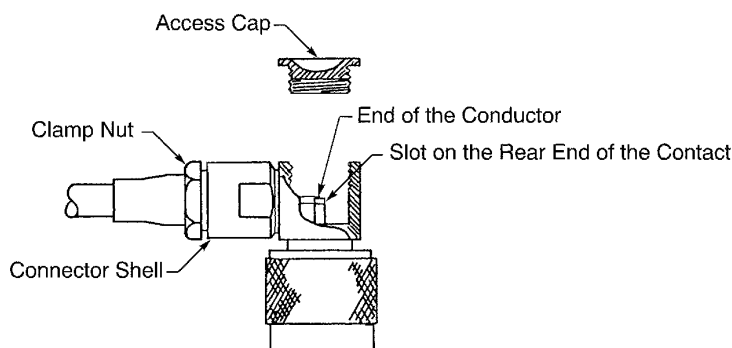
If the connector is a right angle connector with a solder type contact, make sure the end of the center conductor goes in the slot on the end of the center contact. Refer to Figure 20.



2447613 S00061546013_V1

POSITION OF THE CONNECTOR SHELL AND THE CLAMP NUT

Figure 19



2447620 S00061546014_V1

INSTALLATION OF A RIGHT ANGLE CONNECTOR SHELL WITH A SOLDER TYPE CONTACT

Figure 20

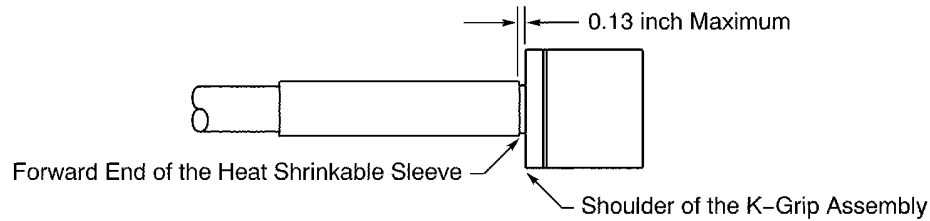
- (12) Tighten the clamp nut to the specified torque value. Refer to Table 10.
- (13) Push the heat shrinkable sleeve forward on the cable until the forward end of the sleeve is against the shoulder of the K-Grip assembly. Refer to Figure 21.

Make sure that the forward end of the heat shrinkable sleeve is not more than 0.13 inch from the rear end of the clamp nut.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447650 S00061546015_V1

POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 21

- (14) Shrink the sleeve into its position. Refer to Subject 20-10-14.

4. COAX CABLE PREPARATION PROCEDURES

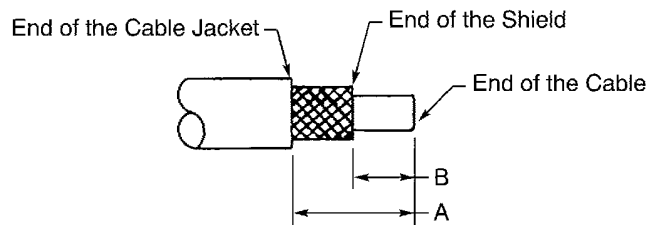
A. Cable Preparation - No Trim Jig

NOTE: If the cable has two shields, the shields are prepared as one shield.

- (1) Remove the necessary length of jacket to make the distance from the end of the jacket to the end of the cable equal to dimension A.

Refer to Figure 22 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2445957 S00061546017_V1

REMOVAL OF THE CABLE JACKET AND THE SHIELD

Figure 22

- (2) Remove the necessary length of shield to make the distance from the end of the cable jacket to the end of the shield equal to dimension B.

Refer to Figure 22 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE DIELECTRIC. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

B. Cable Preparation - Cable Jacket Trim Jig

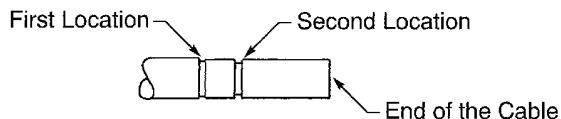
NOTE: If the cable has two shields, the shields are prepared as one shield.

- (1) Put the trim jig on the end of the cable.

Make sure that the end of the trim jig is against the end of the cable.

- (2) Turn the cable in the jig, and at the same time, apply light pressure to the cable at the location of the blades. Refer to Figure 23.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD OR THE DIELECTRIC.
UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

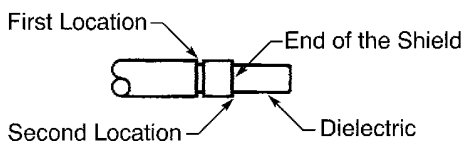


2447603 S00061546020_V1

LOCATIONS TO CUT THE CABLE JACKET

Figure 23

- (3) Remove the trim jig from the end of the cable.
- (4) Remove the length of the cable jacket and the shield from the second location to the end of the cable. Refer to Figure 24.



2447622 S00061546021_V1

SHIELD REMOVAL

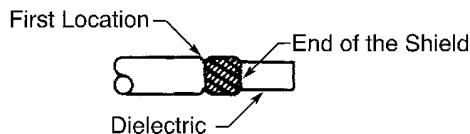
Figure 24

- (5) Remove the length of the cable jacket from the first location to the end of the shield. Refer to Figure 25.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447623 S00061546022_V1

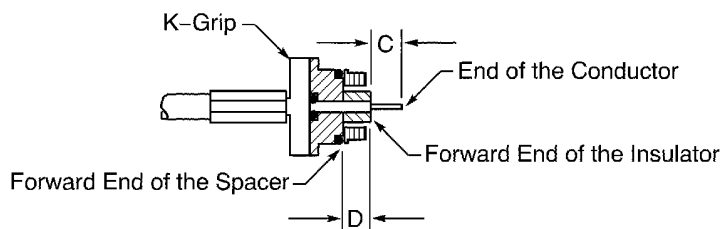
CABLE JACKET REMOVAL

Figure 25

C. Dielectric Removal - No Trim Jig

- (1) For a cable with a spacer and an insulator installed:
 - (a) Remove the length of the dielectric from the forward end of the insulator to the end of the cable. Refer to Figure 26 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2447604 S00061546024_V1

DIELECTRIC REMOVAL WITH A SPACER AND AN INSULATOR INSTALLED

Figure 26

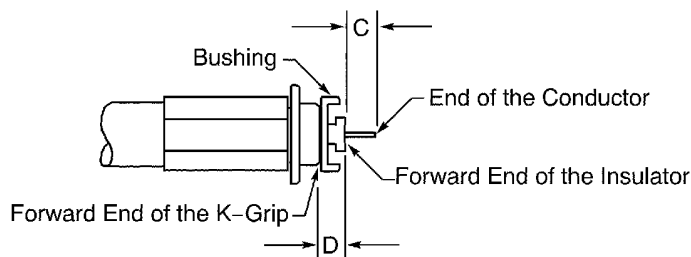
- (b) Remove the necessary length of the conductor to make the distance from the forward end of the insulator to the end of the conductor equal to dimension C. Refer to Figure 26 and Table 9.
- (2) For a cable with a bushing and an insulator installed:
 - (a) Remove the length of dielectric from the forward end of the insulator to the end of the cable. Refer to Figure 27 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



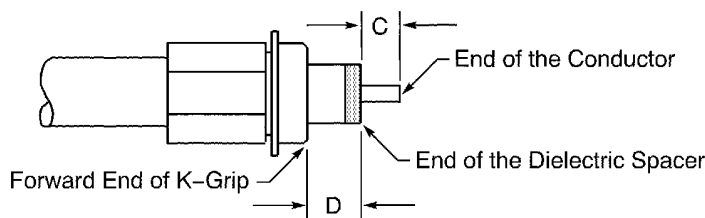
2447606 S00061546025_V1

DIELECTRIC REMOVAL WITH A BUSHING AND AN INSULATOR INSTALLED

Figure 27

- (b) Remove the necessary length of the conductor to make the distance from the end of the insulator to the end of the conductor equal to dimension C. Refer to Figure 27 and Table 9.
- (3) For a cable with a semi-rigid dielectric:
 - (a) Remove the necessary length of dielectric to make the distance from the end of the K-Grip to the end of the dielectric equal to dimension D minus the width of the spacer. Refer to Figure 28 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2447683 S00061546026_V1

DIELECTRIC REMOVAL WITH A DIELECTRIC SPACER INSTALLED

Figure 28

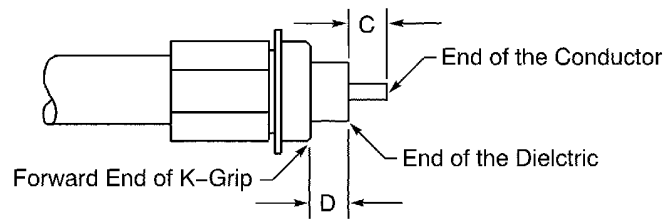
- (b) Install the dielectric spacer.
- (c) Remove the necessary length of the conductor to make the distance from the end of the spacer to the end of the conductor equal to dimension C. Refer to Figure 28 and Table 9.
- (4) For a cable without spacers, insulators, or bushings installed:
 - (a) Remove the necessary length of dielectric to make the distance from the end of the K-Grip to the end of the dielectric equal to dimension D. Refer to Figure 29 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS



2447605 S00061546027_V1

DIELECTRIC REMOVAL

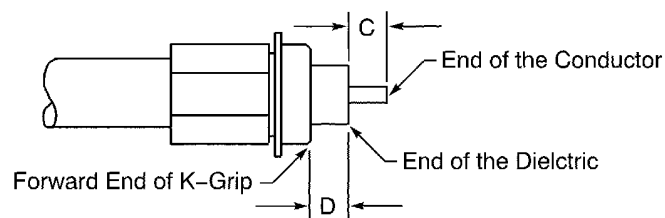
Figure 29

- (b) Remove the necessary length of the conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C. Refer to Figure 29 and Table 9.

D. Dielectric Removal - Dielectric Trim Jig

- (1) Put the dielectric trim jig on the end of the cable.
- (2) Remove the necessary length of dielectric that extends farther than the end of the trim jig. Refer to Figure 30 and Table 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2447605 S00061546027_V1

DIELECTRIC REMOVAL

Figure 30

- (3) Remove the necessary length of the conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C. Refer to Figure 30 and Table 9.

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

5. APPROVED TOOL SUPPLIERS

A. Coax Cable Trim Jigs

Table 11
TRIM JIG TOOL SUPPLIERS

Trim Jig	Supplier
KTD-103	Kings Electronics
KTD-104	Kings Electronics
KTD-105	Kings Electronics
KTD-106	Kings Electronics
KTD-117	Kings Electronics
KTD-214	Kings Electronics
KTD-25	Kings Electronics
KTD-31	Kings Electronics
KTD-6	Kings Electronics
KTD-77	Kings Electronics
KTD-78	Kings Electronics
KTD-79	Kings Electronics
KTD-80	Kings Electronics
KTD-81	Kings Electronics
KTD-82	Kings Electronics
KTD-84	Kings Electronics
KTD-85	Kings Electronics
KTD-86	Kings Electronics
KTD-88	Kings Electronics
KTD-89	Kings Electronics
KTD-90	Kings Electronics
KTD-91	Kings Electronics
KTD-94	Kings Electronics
KTJ-11	Kings Electronics
KTJ-141	Kings Electronics
KTJ-16	Kings Electronics
KTJ-17	Kings Electronics
KTJ-18	Kings Electronics
KTJ-19	Kings Electronics
KTJ-20	Kings Electronics
KTJ-211	Kings Electronics
KTJ-22	Kings Electronics

20-51-11



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX CONNECTORS

Table 11 TRIM JIG TOOL SUPPLIERS (Continued)

Trim Jig	Supplier
KTJ-23	Kings Electronics
KTJ-24	Kings Electronics
KTJ-25	Kings Electronics
KTJ-27	Kings Electronics
KTJ-33	Kings Electronics
KTJ-39	Kings Electronics
KTJ-44	Kings Electronics
KTJ-45	Kings Electronics
KTJ-49	Kings Electronics
KTJ-57	Kings Electronics
KTJ-6	Kings Electronics
KTJ-62	Kings Electronics
KTJ-63	Kings Electronics
KTJ-73	Kings Electronics
KTJ-88	Kings Electronics

B. Coax Connector Crimp Tools

Table 12
CRIMP TOOL SUPPLIERS

Crimp Tool	Supplier
227-1221-25	Amphenol
227-1221-57	Amphenol
227-1351-3	Amphenol
227-1351-4	Amphenol
227-944	Amphenol
227-956-4	Amphenol
612642	Buchanan
612648	Buchanan
612673	Buchanan
612675	Buchanan
612734	Buchanan
612739	Buchanan
612807	Buchanan
683-51470-1	Kings Electronics
CT-32	Schleuniger
HX23	Daniels

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 12 CRIMP TOOL SUPPLIERS (Continued)

Crimp Tool	Supplier
HX4	Daniels
KTH-1000	Kings Electronics
KTH-1078	Kings Electronics
KTH-1079	Kings Electronics
KTH-2001	Kings Electronics
KTH-2002	Kings Electronics
KTH-2003	Kings Electronics
KTH-2004	Kings Electronics
KTH-2007	Kings Electronics
KTH-2008	Kings Electronics
KTH-2042	Kings Electronics
KTH-2061	Kings Electronics
KTH-2105	Kings Electronics
KTH-2106	Kings Electronics
KTH-2111	Kings Electronics
KTH-2127	Kings Electronics
KTH-2128	Kings Electronics
KTH-2161	Kings Electronics
KTH-2211	Kings Electronics
KTH-2212	Kings Electronics
KTH-2213	Kings Electronics
KTH-2216	Kings Electronics
KTH-2220	Kings Electronics
KTH-2230	Kings Electronics
KTH-2231	Kings Electronics
KTH-2235	Kings Electronics
KTM-1000	Kings Electronics
KTM-1099	Kings Electronics
KTM-3000	Kings Electronics
KTM-4000	Kings Electronics
M22520/5-01	QPL
M22520/5-03	QPL
M22520/5-05	QPL
M22520/5-19	QPL
M22520/5-23	QPL

20-51-11



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-GRIP WEATHERPROOF COAX
CONNECTORS

Table 12 CRIMP TOOL SUPPLIERS (Continued)

Crimp Tool	Supplier
M22520/5-25	QPL
M22520/5-41	QPL
M22520/5-57	QPL
ST2352-5-1	Boeing
ST2352-5-2	Boeing
ST2352-5-Y	Boeing
ST2966M	Boeing
ST2966M-13	Boeing
ST2966M-16	Boeing
ST2966M-6	Boeing
ST2966M-8	Boeing
Y142	Daniels
Y197	Daniels
Y322	Daniels

20-51-11

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Page 81
Oct 15/2015



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
B. Necessary Materials	2
2. <u>COAX CONNECTOR ASSEMBLY TOOLS</u>	2
A. Coax Cable Trim Jigs	2
B. Coax Connector Crimp Tools	3
3. <u>CONNECTOR ASSEMBLY</u>	6
A. Cable Preparation Dimensions	6
B. Cable Preparation	6
C. K-Grip Assembly	7
D. Center Contact Assembly	8
E. Connector Shell Installation	9
4. <u>COAX CABLE PREPARATION</u>	12
A. Cable Preparation - No Trim Jig	12
B. Cable Preparation - Cable Jacket Trim Jig	13
C. Dielectric Removal - No Trim Jig	14
D. Dielectric Removal - Dielectric Trim Jig	14
5. <u>APPROVED TOOL SUPPLIERS</u>	15
A. Coax Cable Trim Jig Tools	15
B. Coax Connector K-Grip Sleeve Crimp Tools	15

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Series	Configuration	Supplier
KD-19-08	C	Bulkhead Jack	Kings Electronics
KM-59-05	KM	Straight Plug	Kings Electronics
KY-59-02	-	Straight Plug	Kings Electronics

Table 2
ALTERNATIVE COAX CONNECTORS

Specified Connector	Alternative Connector		Special Instructions
	Part Number	Assembly Procedure	
KM-59-05	KM-59-36	Subject 20-51-15	Applicable for the 10-008, 10-008R, RG-11A, RG-213 cables only

B. Necessary Materials

Table 3
NECESSARY MATERIALS

Material	Part Number or Specification	Supplier
Primer	Product 7471, Primer T	Loctite
Sleeve, Heat Shrinkable	DWP-125	Raychem
Solvent	Isopropyl Alcohol	Any Source
Thread Lock Compound	222	Loctite
	Product 081 Grade D	Loctite

2. COAX CONNECTOR ASSEMBLY TOOLS

A. Coax Cable Trim Jigs

Table 4
COAX CABLE TRIM JIGS

Connector	Trim Jig	
	Cable Jacket	Dielectric
KD-19-08	KTB-4	-
KM-59-05	KTB-4	KTD-1
KY-59-02	KTB-5	KTD-76

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

B. Coax Connector Crimp Tools

Table 5
COAX CRIMP TOOL TYPES

Crimp Tool Basic Unit	Type
CT-32	Pneumatic
HX23	Pneumatic
HX4	Hand
KTH-1000	Hand
KTM-1000	Electric
KTM-3000	Pneumatic
KTM-4000	Pneumatic
M22520/5-01	Hand

Table 6
COAX CONNECTOR K-GRIP SLEEVE TOOL CODES

Connector	Tool Code
KD-19-08	213H
KM-59-05	213H
KY-59-02	255H

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

Table 7
COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
213H	227-944	-	M22520/5-19	0.213
	612648	-	612673	0.213
	CT-32	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	HX23	-	M22520/5-05	0.213
			M22520/5-19	0.213
			Y142	0.213
			Y197	0.213
			Y322	0.213
	HX4	-	M22520/5-05	0.213
			M22520/5-19	0.213
			Y142	0.213
			Y197	0.213
			Y322	0.213
	KTH-1000	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213

20-51-13



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

Table 7 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
213H	KTM-1000	KTM-1099	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	KTM-3000	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	KTM-4000	-	KTH-2001	0.213
			KTH-2042	0.213
			KTH-2220	0.213
	M22520/5-01	-	M22520/5-05	0.213
			M22520/5-19	0.213
			Y142	0.213
			Y197	0.213
			Y322	0.213
	ST2966M	-	ST2966M-6	0.213
255H	612648	-	612675	0.255
	CT-32	-	KTH-2002	0.255
	HX23	-	M22520/5-19	0.255
			Y142	0.255
	HX4	-	M22520/5-19	0.255
			Y142	0.255
	KTH-1000	-	KTH-2002	0.255
	KTM-1000	KTM-1099		0.255
	KTM-3000	-		0.255
	KTM-4000	-		0.255
	M22520/5-01	-	M22520/5-19	0.255
			Y142	0.255
	ST2966M	-	ST2966M-8	0.255

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

3. CONNECTOR ASSEMBLY

A. Cable Preparation Dimensions

Table 8
CABLE PREPARATION DIMENSIONS

Connector	Dimension	Length (inch)	
		Target	Tolerance
KD-19-08	A	1.28	±0.02
	B	0.97	±0.02
	C	0.16	±0.02
	D	0.13	±0.02
KM-59-05	A	0.88	±0.02
	B	0.56	±0.02
	C	0.08	±0.02
	D	0.05	±0.02
KY-59-02	A	0.88	±0.02
	B	0.56	±0.02
	C	0.08	±0.02
	D	0.05	±0.02

B. Cable Preparation

For the general conditions that are applicable for the preparation of coax cable, refer to Subject 20-51-00.

- (1) Make a selection of a heat shrinkable sleeve from Table 3.
Make sure that the sleeve has the smallest diameter that can be moved easily on the K-Grip sleeve.
- (2) Put a 1.5 inch length of heat shrinkable sleeve on the cable.
- (3) Cut the end of the cable to make it perpendicular to the longitudinal axis of the cable.
- (4) Put the K-Grip sleeve on the cable.
- (5) Prepare the cable with a trim jig.

NOTE: Preparation of the cable without a trim jig is a satisfactory alternative. Refer to Paragraph 4.A.

- (a) Make a selection of a cable jacket trim jig from Table 4.
- (b) Prepare the cable with the trim jig. Refer to Paragraph 4.B.

20-51-13



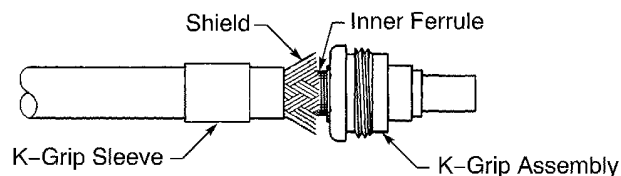
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

C. K-Grip Assembly

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

- (1) Find the K-Grip sleeve crimp tool code. Refer to Table 6.
- (2) Make a selection of the K-Grip sleeve crimp tool from Table 7.
Make sure that the tool is applicable for the tool code.
- (3) Examine the threads on the rear of the connector shell for contamination or thread lock compound.
- (4) If the threads have material on them, clean the threads:
 - (a) Fully engage the threads the clamp nut and the threads of the connector shell.
 - (b) Remove the clamp nut from the connector shell.
- (5) Move the strands of the shield apart.
- (6) Put the K-Grip assembly on the end of the cable. Refer to Figure 1.
Make sure that the inner ferrule is between the shield and the dielectric.



2447615 S00061546029_V1

POSITION OF THE K-GRIP ASSEMBLY ON THE CABLE
Figure 1

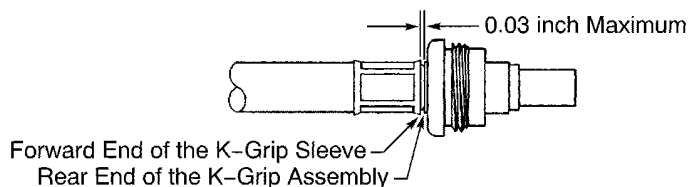
- (7) Push the K-Grip assembly rearward.
Make sure that:
 - The rear end of the inner ferrule is against the end of the jacket
 - The end of the shield is not more than 0.03 inch from the rear end of the K-Grip assembly.
- (8) Push the K-Grip sleeve forward until the forward end of the sleeve is against the rear end of the K-Grip assembly.
- (9) Put the assembly in the crimp tool.
Make sure that the K-Grip assembly, the sleeve, and the cable stay in their position.
- (10) Align the rear end of the sleeve with the nearest edge of the tool die.
- (11) Crimp the sleeve. Refer to Figure 2.
Make sure the forward end of the sleeve is not more than 0.03 inch from the rear end of the K-Grip assembly.

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS



2447616 S00061546030_V1

POSITION OF THE K-GRIP SLEEVE

Figure 2

D. Center Contact Assembly

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Make a selection of a Temperature Grade C solder. Refer to Subject 20-00-11.

CAUTION: DO NOT USE A TEMPERATURE GRADE D SOLDER. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CABLE CAN OCCUR.

- (2) Remove the necessary length of dielectric with a trim jig.

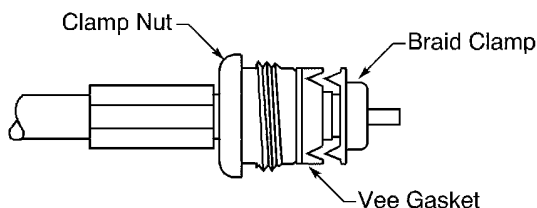
NOTE: Removal of the dielectric without a trim jig is a satisfactory alternative. Refer to Paragraph 4.C.

- (a) Make a selection of a dielectric trim jig from Table 4.

NOTE: If a trim jig is not specified for the connector, the dielectric must be removed without a trim jig. Refer to Paragraph 4.C.

- (b) Remove the dielectric with the trim jig. Refer to Paragraph 4.D.

- (3) If the connector is supplied with a vee gasket and a braid clamp, put gasket and the clamp on the end of the cable. Refer to Figure 3.



2447618 S00061546031_V1

POSITION OF THE VEE GASKET AND THE BRAID CLAMP ON THE END OF THE CABLE

Figure 3

- (4) Tin the center conductor.

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

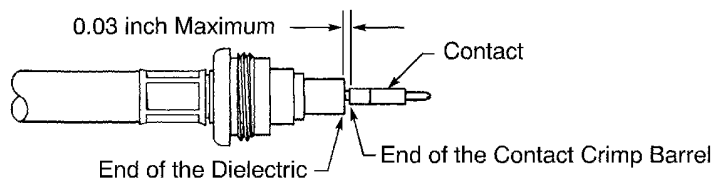
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (5) Put the center conductor in the solder barrel of the center contact. Refer to Figure 4.

Make sure that:

- All of the strands of the conductor are in the solder barrel
- The conductor can be seen in the inspection hole
- The distance from the end of the dielectric to the rear end of the solder barrel is not more than 0.03 inch.



2447619 S00061546032_V1

POSITION OF THE CENTER CONTACT ON THE CONDUCTOR

Figure 4

- (6) Apply a small quantity of solder in the inspection hole of the contact.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (7) Remove all of the solder and the flux from the outer surface of the contact.
(8) Examine the contact for damage to the finish.

NOTE: If the contact has damage, it must be replaced.

- (9) If a solder access cover is supplied with the contact, install the cover.

E. Connector Shell Installation

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

Table 9
CLAMP NUT TORQUE VALUES

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KD-19-08	40	50
KM-59-05	40	50

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

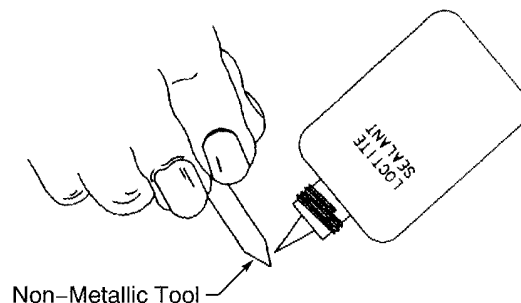
Table 9 CLAMP NUT TORQUE VALUES (Continued)

Connector	Torque Value (inch-pound)	
	Minimum	Maximum
KY-59-02	40	50

- (1) Make a selection of a solvent from Table 3.
- (2) Make a selection of a primer from Table 3.
- (3) Make a selection of a thread lock compound from Table 3.
- (4) Clean the clamp nut with a wiper and solvent.
- (5) Dry the nut with a clean wiper.
- (6) Apply the primer with a spray on the threads of the nut.
- (7) Let the primer to dry for 10 minutes minimum at room temperature.
- (8) Apply a layer of thread lock compound on the threads of the clamp nut.

CAUTION: THE THREAD LOCK COMPOUND DOES NOT MAKE A BOND IF THE COMPONENTS ARE ASSEMBLED MORE THAN 30 MINUTES AFTER THE COMPOUND IS APPLIED.

- (a) Put a small quantity of the compound on the tip of a non-metallic, pointed tool. Refer to Figure 5.



2445958 S00061546010_V1

LOCATION OF THE THREAD LOCK COMPOUND ON THE TOOL

Figure 5

- (b) Apply a thin smooth layer of the compound on one or two full threads of the nut. Refer to Figure 6.

CAUTION: THREAD LOCK COMPOUND IS AN INSULATOR. TOO MUCH THREAD LOCK COMPOUND CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CONNECTOR.

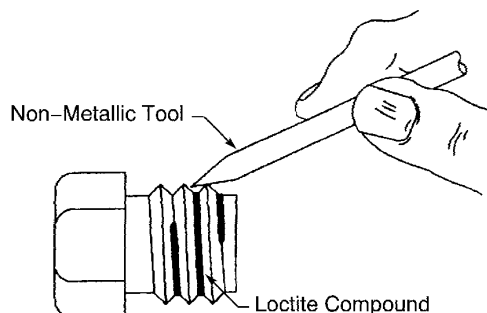
20-51-13



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

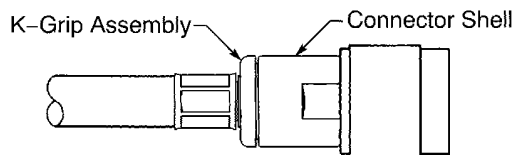


2445959 S00061546012_V1

LOCATION OF THE THREAD LOCK COMPOUND ON THE THREADS OF THE CLAMP NUT

Figure 6

- (c) If too much thread lock compound is applied, remove the unwanted compound from the nut.
- (9) If a vee gasket is on the cable, push it rearward until it is against the K-Grip assembly.
- (10) If a braid clamp is on the cable, push it rearward until it is against the vee gasket.
- (11) Put the K-Grip assembly in the rear end of the connector shell.
- (12) Fully engage the threads of the connector shell and the threads of the clamp nut on the K-Grip assembly. Refer to Figure 7.



2447617 S00061546033_V1

POSITION OF THE CONNECTOR SHELL ON THE K-GRIP ASSEMBLY

Figure 7

- (13) Tighten the clamp nut to the specified torque value. Refer to Table 9.
- (14) Push the heat shrinkable sleeve forward on the cable until the forward end of the sleeve is against the shoulder of the K-Grip assembly. Refer to Figure 8.

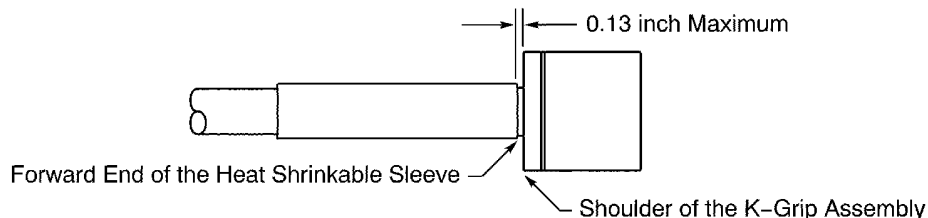
20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

Make sure that the forward end of the sleeve is not more than 0.13 inch from the shoulder of the K-Grip assembly.



2447650 S00061546015_V1

POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 8

- (15) Shrink the sleeve into its position. Refer to Subject 20-10-14.

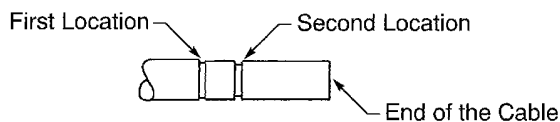
4. COAX CABLE PREPARATION

A. Cable Preparation - No Trim Jig

NOTE: If the cable has two shields, the shields are prepared as one shield.

- (1) Put the trim jig on the end of the cable.
Make sure that the end of the cable is against the end of the trim jig.
- (2) Turn the cable in the jig, and at the same time, apply light pressure on the cable at the location that is opposite the blades. Refer to Figure 9.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD OR THE DIELECTRIC.
UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2447603 S00061546020_V1

LOCATIONS TO CUT THE CABLE JACKET

Figure 9

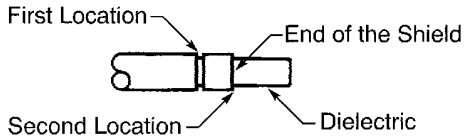
- (3) Remove the trim jig from the end of the cable.
- (4) Remove the lengths of the cable jacket and the shield from the second location to the end of the cable. Refer to Figure 10.

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

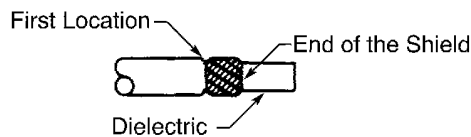


2447622 S00061546021_V1

SHIELD REMOVAL

Figure 10

- (5) Remove the length of cable jacket from the first location to the end of the shield. Refer to Figure 11.



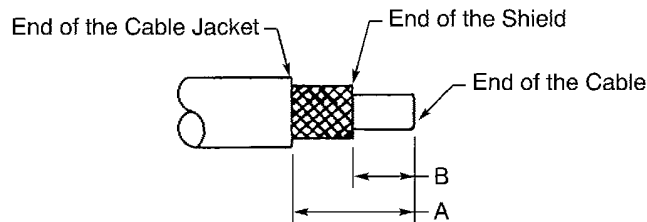
2447623 S00061546022_V1

CABLE JACKET REMOVAL

Figure 11

B. Cable Preparation - Cable Jacket Trim Jig

NOTE: If the cable has two shields, the shields are prepared as one shield.



2445957 S00061546017_V1

CABLE PREPARATION

Figure 12

- (1) Remove the necessary length of jacket to make the distance from the end of the jacket to the end of the cable equal to dimension A.
Refer to Figure 12 and Table 8.

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

- (2) Remove the necessary length of shield to make the distance from the end of the shield to the end of the cable equal to dimension B.

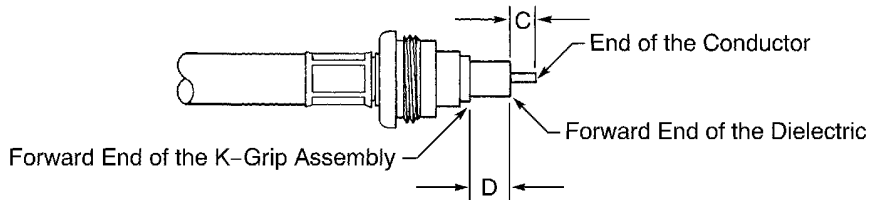
Refer to Figure 12 and Table 8.

CAUTION: DO NOT CAUSE DAMAGE TO THE DIELECTRIC. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

C. Dielectric Removal - No Trim Jig

- (1) Remove the necessary length of the dielectric to make the distance from the forward end of the K-Grip assembly to the end of the dielectric equal to dimension D.

Refer to Figure 13 and Table 8.



2447614 S00061546034_V1

DIELECTRIC REMOVAL

Figure 13

- (2) Remove the necessary length of conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C. Refer to Figure 13 and Table 8.

D. Dielectric Removal - Dielectric Trim Jig

- (1) Put the trim jig on the end of the cable.
- (2) Remove the dielectric that extends farther than the end of the trim jig. Refer to Figure 14 and Table 8.

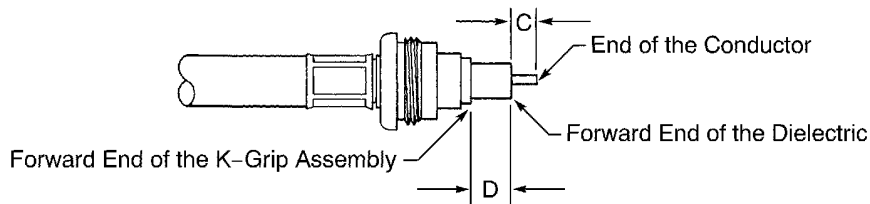
Make sure that the distance from the forward end of the K-Grip assembly to the end of the dielectric is equal to dimension D.

20-51-13



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS



2447614 S00061546034_V1

DIELECTRIC REMOVAL

Figure 14

- (3) Remove the necessary length of conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C. Refer to Figure 14 and Table 8.

5. APPROVED TOOL SUPPLIERS

A. Coax Cable Trim Jig Tools

**Table 10
TRIM JIG TOOL SUPPLIERS**

Trim Jig	Supplier
KTB-4	Kings Electronics
KTB-5	Kings Electronics
KTD-1	Kings Electronics
KTD-76	Kings Electronics

B. Coax Connector K-Grip Sleeve Crimp Tools

**Table 11
CRIMP TOOL SUPPLIERS**

Crimp Tool	Supplier
227-944	Amphenol
612648	Buchanan
612673	Buchanan
612675	Buchanan
CT-32	Schleuniger
HX23	Daniels
HX4	Daniels
KTH-1000	Kings Electronics
KTH-2001	Kings Electronics
KTH-2002	Kings Electronics

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) STANDARD K-GRIP COAX CONNECTORS

Table 11 CRIMP TOOL SUPPLIERS (Continued)

Crimp Tool	Supplier
KTH-2042	Kings Electronics
KTH-2220	Kings Electronics
KTM-1000	Kings Electronics
KTM-1099	Kings Electronics
KTM-3000	Kings Electronics
KTM-4000	Kings Electronics
M22520/5-01	QPL
M22520/5-05	QPL
M22520/5-19	QPL
ST2966M	Boeing
ST2966M-6	Boeing
ST2966M-8	Boeing
Y142	Daniels
Y197	Daniels
Y322	Daniels

20-51-13



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers and Description	2
	B. Necessary Materials	17
2.	<u>COAX CONNECTOR ASSEMBLY TOOLS</u>	17
	A. Coax Cable Trim Jigs	17
	B. Coax Connector Crimp Tools	26
3.	<u>CONNECTOR ASSEMBLY</u>	56
	A. Cable Preparation Dimensions	56
	B. Heat Shrinkable Sleeve Configurations	70
	C. Cable Preparation	72
	D. Center Contact Assembly - Crimp Type Contacts	73
	E. Center Contact Assembly - Solder Type Contacts	74
	F. Connector Shell Installation	75
	G. Insulation Installation	79
4.	<u>CONNECTOR ASSEMBLY - RIGHT ANGLE CONNECTORS WITH SOLDER TYPE CONTACTS</u>	79
	A. Cable Preparation Dimensions	79
	B. Cable Preparation	80
	C. Connector Shell Installation	81
	D. Center Contact Assembly	82
5.	<u>COAX CABLE PREPARATION</u>	82
	A. Cable Preparation - No Trim Jigs	82
	B. Cable Preparation - Cable Jacket Trim Jig with Two Slots	84
	C. Cable Preparation - Cable Jacket Trim Jig with Three Slots	85
6.	<u>INSULATION INSTALLATION CONFIGURATIONS</u>	88
	A. Heat Shrinkable Sleeve - Standard Configuration	88
	B. Heat Shrinkable Sleeves - 125-88-9, 125-95-9 and KA-59-438-M06 Connectors	89
	C. Heat Shrinkable Sleeves - 125-91-9 Connector	90
	D. Heat Shrinkable Sleeves - 126-58-9, 126-71-9, 126-85-9 and KA-59-439-M06 Connectors	91
	E. Heat Shrinkable Sleeves - 2985-3-() Connectors	93
	F. Heat Shrinkable Sleeves - 2430-2-16 and 796-17-9 Connectors	95
7.	<u>CONNECTOR INSTALLATION</u>	95
	A. Connection of N, TNC, and SC Series Plugs and Jacks	95
8.	<u>APPROVED TOOL SUPPLIERS</u>	97
	A. Coax Cable Trim Jig Tools	97
	B. Crimp Tool Suppliers	99

20-51-15



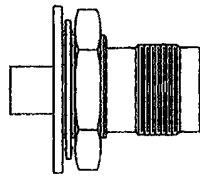
707, 727-787

STANDARD WIRING PRACTICES MANUAL

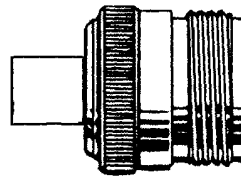
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

1. PART NUMBERS AND DESCRIPTION

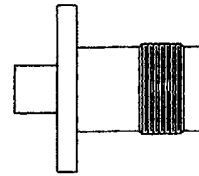
A. Connector Part Numbers and Description



Bulkhead Jack



In-Line Jack

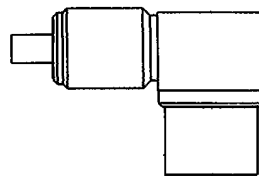


Panel Jack

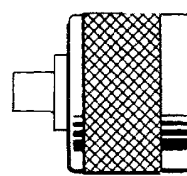
2447590 S00061546036_V1

WEATHERPROOF K-GRIP JUNIOR COAX JACK CONNECTORS

Figure 1



Right Angle Plug



Straight Plug

2447681 S00061546037_V1

WEATHERPROOF K-GRIP JUNIOR COAX PLUG CONNECTORS

Figure 2

Table 1

COAX CONNECTOR PART NUMBERS

Part Number	Series	Configuration	Contact Type	Supplier
1075-13-9	K-Loc	Straight Plug	Crimp	Kings Electronics
1201-11-9	N	Panel Jack	Crimp	Kings Electronics
1201-12-9	N	Panel Jack	Crimp	Kings Electronics
1201-13-9	N	Panel Jack	Crimp	Kings Electronics
1201-14-9	N	Panel Jack	Crimp	Kings Electronics
1201-20-9	N	Panel Jack	Crimp	Kings Electronics
1201-21-9	N	Panel Jack	Crimp	Kings Electronics
1201-22-9	N	Panel Jack	Crimp	Kings Electronics
1201-23-9	N	Panel Jack	Crimp	Kings Electronics
1201-24-9	N	Panel Jack	Crimp	Kings Electronics
1201-25-9	N	Panel Jack	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
1201-6-9	N	Panel Jack	Crimp	Kings Electronics
1202-20-9	N	Bulkhead Jack	Crimp	Kings Electronics
1202-23-9	N	Bulkhead Jack	Crimp	Kings Electronics
1202-26-9	N	Bulkhead Jack	Crimp	Kings Electronics
1203-13-9	N	In-Line Jack	Crimp	Kings Electronics
1203-14-9	N	In-Line Jack	Crimp	Kings Electronics
1203-15-9	N	Right Angle Jack	Crimp	Kings Electronics
1203-16-9	N	In-Line Jack	Crimp	Kings Electronics
1203-19-9	N	In-Line Jack	Crimp	Kings Electronics
1203-20-9	N	In-Line Jack	Crimp	Kings Electronics
1203-21-9	N	In-Line Jack	Crimp	Kings Electronics
1203-4-9	N	In-Line Jack	Crimp	Kings Electronics
1205-20-9	N	Straight Plug	Crimp	Kings Electronics
1205-31-9	N	Straight Plug	Crimp	Kings Electronics
1205-47-9	N	Straight Plug	Crimp	Kings Electronics
1205-48-9	N	Straight Plug	Crimp	Kings Electronics
1205-49-9	N	Straight Plug	Crimp	Kings Electronics
1205-61-9	N	Straight Plug	Crimp	Kings Electronics
1205-62-9	N	Straight Plug	Crimp	Kings Electronics
1206-11-9	N	Right Angle Plug	Crimp	Kings Electronics
1206-21-9	N	Right Angle Plug	Crimp	Kings Electronics
1206-22-9	N	Right Angle Plug	Crimp	Kings Electronics
1206-26-9	N	Right Angle Plug	Crimp	Kings Electronics
1206-29-9	N	Right Angle Plug	Crimp	Kings Electronics
1206-30-9	N	Right Angle Plug	Crimp	Kings Electronics
121-11-9	TNC	Panel Jack	Solder	Kings Electronics
121-24-9	TNC	Panel Jack	Crimp	Kings Electronics
121-35-9	TNC	Panel Jack	Crimp	Kings Electronics
121-36-9	TNC	Panel Jack	Crimp	Kings Electronics
121-37-9	TNC	Panel Jack	Crimp	Kings Electronics
121-38-9	TNC	Panel Jack	Crimp	Kings Electronics
121-39-9	TNC	Panel Jack	Crimp	Kings Electronics
121-40-9	TNC	Panel Jack, Isolated Ground	Crimp	Kings Electronics
121-44-9	TNC	Panel Jack	Crimp	Kings Electronics
121-45-9	TNC	Panel Jack	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
121-46-9	TNC	Panel Jack	Crimp	Kings Electronics
121-52-9	TNC	Panel Jack, Isolated Ground	Crimp	Kings Electronics
122-37-9	TNC	Bulkhead Jack	Crimp	Kings Electronics
123-22-5	TNC	In-Line Jack	Crimp	Kings Electronics
123-23-9	TNC	In-Line Jack	Crimp	Kings Electronics
123-24-9	TNC	Right Angle Jack	Crimp	Kings Electronics
123-26-9	TNC	Right Angle Jack	Crimp	Kings Electronics
125-60-9	TNC	Straight Plug	Crimp	Kings Electronics
125-61-9	TNC	Straight Plug	Crimp	Kings Electronics
125-69-9	TNC	Straight Plug	Crimp	Kings Electronics
125-88-9	TNC	Straight Plug	Crimp	Kings Electronics
125-89-9	TNC	Straight Plug	Crimp	Kings Electronics
125-91-9	TNC	Straight Plug	Crimp	Kings Electronics
125-92-9	TNC	Straight Plug	Crimp	Kings Electronics
125-94-9	TNC	Straight Hex Plug	Crimp	Kings Electronics
125-95-9	TNC	Straight Hex Plug	Crimp	Kings Electronics
125-96-9	TNC	Straight Hex Plug	Crimp	Kings Electronics
125-101-9	TNC	Straight Hex Plug	Crimp	Kings Electronics
125-105-9	TNC	Straight Plug	Crimp	Kings Electronics
125-126-9	TNC	Straight Plug	Crimp	Kings Electronics
126-14-5	TNC	Right Angle Plug	Crimp	Kings Electronics
126-50-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-58-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-59-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-64-9	TNC	Long Right Angle Plug	Crimp	Kings Electronics
126-67-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-70-9	TNC	Long Right Angle Plug	Crimp	Kings Electronics
126-71-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-73-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-74-9	TNC	Right Angle Plug	Crimp	Kings Electronics
126-78-1	TNC	Right Angle Plug	Crimp	Kings Electronics
126-78-6	TNC	Right Angle Plug	Crimp	Kings Electronics
126-85-9	TNC	Right Angle Plug	Crimp	Kings Electronics
1525-4-9	TPS	Straight Plug	Crimp	Kings Electronics
2255-6-4	-	Straight Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
2430-1-()	TNC	Keyed Right Angle Panel Jack	Crimp	Kings Electronics
2430-2-()	TNC	Keyed Right Angle Panel Jack	Crimp	Kings Electronics
2431-74-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-76-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-80-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-81-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-82-()	TNC	Keyed Panel Jack, Isolated Ground	Crimp	Kings Electronics
2431-83-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-84-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-85-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-87-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-88-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2431-89-()	TNC	Keyed Panel Jack	Crimp	Kings Electronics
2435-74-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2435-77-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2435-81-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2435-82-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2435-83-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2435-84-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2435-87-()	TNC	Keyed Straight Plug	Crimp	Kings Electronics
2436-81-()	TNC	Keyed Right Angle Plug	Crimp	Kings Electronics
2436-83-()	TNC	Keyed Right Angle Plug	Crimp	Kings Electronics
2436-85-()	TNC	Keyed Right Angle Plug	Crimp	Kings Electronics
2971-2-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2971-3-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2971-4-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2971-5-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2971-6-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2971-7-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2971-8-()	N	Keyed Panel Jack	Crimp	Kings Electronics
2975-2-()	N	Keyed Straight Plug	Crimp	Kings Electronics
2975-4-()	N	Keyed Straight Plug	Crimp	Kings Electronics
2975-5-()	N	Keyed Straight Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
2975-6-()	N	Keyed Straight Plug	Crimp	Kings Electronics
2976-1-()	N	Keyed Right Angle Plug	Crimp	Kings Electronics
2976-3-()	N	Keyed Right Angle Plug	Crimp	Kings Electronics
2981-1-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2981-3-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2981-4-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2981-5-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2981-6-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2981-7-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2981-8-()	SC	Keyed Panel Jack	Crimp	Kings Electronics
2985-2-()	SC	Keyed Straight Plug	Crimp	Kings Electronics
2985-3-()	SC	Keyed Straight Plug	Crimp	Kings Electronics
2985-4-()	SC	Keyed Straight Plug	Crimp	Kings Electronics
2986-1-()	SC	Keyed Right Angle Plug	Crimp	Kings Electronics
2986-3-()	SC	Keyed Right Angle Plug	Crimp	Kings Electronics
751-10-9	BNC	Panel Jack	Crimp	Kings Electronics
751-11-9	BNC	Panel Jack	Crimp	Kings Electronics
751-2-9	BNC	Panel Jack	Crimp	Kings Electronics
751-20-9	BNC	Panel Jack	Crimp	Kings Electronics
751-22-9	BNC	Panel Jack	Crimp	Kings Electronics
751-3-9	BNC	Panel Jack	Crimp	Kings Electronics
751-4-9	BNC	Panel Jack	Crimp	Kings Electronics
752-43-9	BNC	Splitter Tee Bulkhead Jack	Crimp	Kings Electronics
755-78-9	BNC	Straight Plug	Crimp	Kings Electronics
755-79-9	BNC	Straight Plug	Crimp	Kings Electronics
755-93-9	BNC	Straight Plug	Crimp	Kings Electronics
755-129-9	BNC	Straight Plug	Crimp	Kings Electronics
756-10-9	BNC	Right Angle Plug	Crimp	Kings Electronics
756-16-9	BNC	Right Angle Plug	Crimp	Kings Electronics
756-4-9	BNC	Right Angle Plug	Crimp	Kings Electronics
791-10-9	C	Panel Jack	Crimp	Kings Electronics
791-11-9	C	Panel Jack	Crimp	Kings Electronics
791-5-9	C	Panel Jack	Crimp	Kings Electronics
791-6-9	C	Panel Jack	Crimp	Kings Electronics
791-7-9	C	Panel Jack	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
791-8-9	C	Panel Jack	Crimp	Kings Electronics
791-9-9	C	Panel Jack	Crimp	Kings Electronics
795-15-9	C	Straight Plug	Crimp	Kings Electronics
795-16-9	C	Straight Plug	Crimp	Kings Electronics
795-20-9	C	Straight Plug	Crimp	Kings Electronics
795-21-9	C	Straight Plug	Crimp	Kings Electronics
795-23-9	C	Straight Plug	Crimp	Kings Electronics
795-29-9	C	Straight Plug	Crimp	Kings Electronics
795-30-9	C	Straight Plug	Crimp	Kings Electronics
795-33-9	C	Straight Plug	Crimp	Kings Electronics
796-15-9	C	Right Angle Plug	Crimp	Kings Electronics
796-17-9	C	Right Angle Plug	Crimp	Kings Electronics
796-18-9	C	Right Angle Plug	Crimp	Kings Electronics
796-19-9	C	Right Angle Plug	Crimp	Kings Electronics
796-4-9	C	Right Angle Plug	Crimp	Kings Electronics
821-2-9	SC	Panel Jack	Crimp	Kings Electronics
821-3-9	SC	Panel Jack	Crimp	Kings Electronics
821-4-9	SC	Panel Jack	Crimp	Kings Electronics
821-5-9	SC	Panel Jack	Crimp	Kings Electronics
821-6-9	SC	Panel Jack	Crimp	Kings Electronics
821-7-9	SC	Panel Jack	Crimp	Kings Electronics
821-9-9	SC	Panel Jack	Crimp	Kings Electronics
823-1-9	SC	In-Line Jack	Crimp	Kings Electronics
823-2-9	SC	In-Line Jack	Crimp	Kings Electronics
825-10-9	SC	Straight Plug	Crimp	Kings Electronics
825-11-9	SC	Straight Plug	Crimp	Kings Electronics
825-12-9	SC	Straight Plug	Crimp	Kings Electronics
825-14-9	SC	Straight Plug	Crimp	Kings Electronics
825-7-9	SC	Straight Plug	Crimp	Kings Electronics
826-10-9	SC	Right Angle Plug	Crimp	Kings Electronics
826-8-9	SC	Right Angle Plug	Crimp	Kings Electronics
826-9-9	SC	Right Angle Plug	Crimp	Kings Electronics
841-1-9	SMA	Panel Jack	Crimp	Kings Electronics
843-2-9	HN	In-Line Jack	Crimp	Kings Electronics
845-3-9	SMA	Straight Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
846-5-9	SMA	Right Angle Plug	Crimp	Kings Electronics
871-59-3	SMA	Panel Jack	Crimp	Kings Electronics
875-100-3	SMA	Straight Plug	Crimp	Kings Electronics
875-105-3	SMA	Straight Plug	Crimp	Kings Electronics
875-91-3	SMA	Straight Plug	Crimp	Kings Electronics
875-92-3	SMA	Straight Plug	Crimp	Kings Electronics
876-64-3	SMA	Right Angle Plug	Crimp	Kings Electronics
892-2-9	KM	Bulkhead Jack	Crimp	Kings Electronics
892-3-9	KM	Bulkhead Jack	Crimp	Kings Electronics
895-3-9	KM	Straight Plug	Crimp	Kings Electronics
895-6-9	KM	Straight Plug	Crimp	Kings Electronics
896-4-9	KM	Right Angle Plug	Crimp	Kings Electronics
KA-19-102	TNC	Bulkhead Jack	Crimp	Kings Electronics
KA-19-143	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-143-M06	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-155	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-162	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-163	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-193	TNC	Bulkhead Jack	Crimp	Kings Electronics
KA-19-195-M06	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-198-M06	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-213	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-213-M06	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-216	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-216-M06	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-68	TNC	Panel Jack	Crimp	Kings Electronics
KA-19-83	TNC	Panel Jack	Crimp	Kings Electronics
KA-39-100-M06	TNC	In-Line Jack	Crimp	Kings Electronics
KA-39-102-M06	TNC	In-Line Jack	Crimp	Kings Electronics
KA-39-44	TNC	Straight Jack	Solder	Kings Electronics
KA-39-82	TNC	In-Line Jack	Crimp	Kings Electronics
KA-39-83	TNC	In-Line Jack	Crimp	Kings Electronics
KA-39-85	TNC	In-Line Jack	Crimp	Kings Electronics
KA-39-94-M06	TNC	Right Angle Jack	Crimp	Kings Electronics
KA-59-185	TNC	Straight Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KA-59-185-MC7	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-186	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-187	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-188	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-189	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-230	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-236	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-251	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-260	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-277	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-292	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-304	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-313	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-316	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-317	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-324	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-353-M06	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-391-M06	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-392-M06	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-393-M06	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-437-M06	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-438-M06	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-439-M06	TNC	Right Angle Plug	Crimp	Kings Electronics
KA-59-57	TNC	Straight Plug	Crimp	Kings Electronics
KA-59-73	TNC	Right Angle Plug	Solder	Kings Electronics
KC-19-121	BNC	Right Angle Bulkhead Jack	Crimp	Kings Electronics
KC-19-122	BNC	Tee Jack	Crimp	Kings Electronics
KC-19-129	BNC	Panel Jack	Solder	Kings Electronics
KC-19-129-M06	BNC	Panel Jack	Solder	Kings Electronics
KC-19-161	BNC	Bulkhead Jack	Crimp	Kings Electronics
KC-19-169	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-170	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-177	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-177-M06	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-226	BNC	Panel Jack	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KC-19-254	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-255	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-256	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-261	BNC	Bulkhead Jack	Crimp	Kings Electronics
KC-19-262	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-307-M06	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-308-M06	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-327-M06	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-328-M06	BNC	Panel Jack	Crimp	Kings Electronics
KC-19-329-M06	BNC	Panel Jack	Crimp	Kings Electronics
KC-39-108	BNC	In-Line Jack	Crimp	Kings Electronics
KC-39-109	BNC	In-Line Jack	Crimp	Kings Electronics
KC-39-110	BNC	In-Line Jack	Crimp	Kings Electronics
KC-39-111	BNC	Right Angle Jack	Crimp	Kings Electronics
KC-39-140-M06	BNC	In-Line Jack	Crimp	Kings Electronics
KC-39-142-M06	BNC	In-Line Jack	Crimp	Kings Electronics
KC-39-29	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-36	BNC	In-Line Jack	Solder	Kings Electronics
KC-39-45	BNC	Straight Plug	Crimp	Kings Electronics
KC-39-81	BNC	In-Line Jack	Crimp	Kings Electronics
KC-59-104	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-128	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-152	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-218	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-222	BNC	Right Angle Plug	Solder	Kings Electronics
KC-59-259	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-261	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-262	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-263	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-265	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-267	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-281	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-287	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-291	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-383	BNC	Straight Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KC-59-411	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-425-M06	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-444	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-445	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-446	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-447	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-448	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-557-M06	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-585-M06	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-604-M06	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-605-M06	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-609	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-609-M06	BNC	Straight Plug	Crimp	Kings Electronics
KC-59-660-M06	BNC	Right Angle Plug	Crimp	Kings Electronics
KC-59-669-M06	BNC	Right Angle Plug	Crimp	Kings Electronics
KD-19-104	C	Panel Jack	Crimp	Kings Electronics
KD-19-104-M06	C	Panel Jack	Crimp	Kings Electronics
KD-19-105-M06	C	Panel Jack	Crimp	Kings Electronics
KD-19-107-M06	C	Bulkhead Jack	Crimp	Kings Electronics
KD-19-55	C	Bulkhead Jack	Crimp	Kings Electronics
KD-19-66	C	Panel Jack	Crimp	Kings Electronics
KD-19-67	C	Panel Jack	Crimp	Kings Electronics
KD-19-68	C	Panel Jack	Crimp	Kings Electronics
KD-19-69	C	Panel Jack	Crimp	Kings Electronics
KD-19-90	C	In-Line Jack	Crimp	Kings Electronics
KD-19-94	C	Panel Jack	Crimp	Kings Electronics
KD-19-95	C	Panel Jack	Crimp	Kings Electronics
KD-39-27	C	Tee Jack	Crimp	Kings Electronics
KD-39-28	C	In-Line Jack	Crimp	Kings Electronics
KD-39-37	C	In-Line Jack	Crimp	Kings Electronics
KD-39-42	C	In-Line Jack	Crimp	Kings Electronics
KD-59-110	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-120	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-125	C	Straight Plug	Crimp	Kings Electronics
KD-59-126	C	Right Angle Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KD-59-128	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-129	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-161	C	Straight Plug	Crimp	Kings Electronics
KD-59-163	C	Straight Plug	Crimp	Kings Electronics
KD-59-164	C	Straight Plug	Crimp	Kings Electronics
KD-59-165	C	Straight Plug	Crimp	Kings Electronics
KD-59-166	C	Straight Plug	Crimp	Kings Electronics
KD-59-180-M06	C	Straight Plug	Crimp	Kings Electronics
KD-59-184-M06	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-185	C	Straight Plug	Crimp	Kings Electronics
KD-59-185-M06	C	Straight Plug	Crimp	Kings Electronics
KD-59-186	C	Straight Plug	Crimp	Kings Electronics
KD-59-186-M06	C	Straight Plug	Crimp	Kings Electronics
KD-59-187-M06	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-193-M06	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-199-M06	C	Straight Plug	Crimp	Kings Electronics
KD-59-201	C	Straight Plug	Crimp	Kings Electronics
KD-59-201-M06	C	Straight Plug	Crimp	Kings Electronics
KD-59-202	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-202-M06	C	Right Angle Plug	Crimp	Kings Electronics
KD-59-52	C	Straight Plug	Crimp	Kings Electronics
KD-59-58	C	Straight Plug	Crimp	Kings Electronics
KD-59-63	C	Straight Plug	Solder	Kings Electronics
KD-59-64	C	Straight Plug	Solder	Kings Electronics
KG-19-15-M06	SC	Panel Jack	Crimp	Kings Electronics
KG-59-28	SC	Right Angle Plug	Crimp	Kings Electronics
KG-59-31-M06	SC	Right Angle Plug	Crimp	Kings Electronics
KG-59-32-M06	SC	Straight Plug	Crimp	Kings Electronics
KG-59-33-M06	SC	Right Angle Plug	Crimp	Kings Electronics
KG-59-34-M06	SC	Straight Plug	Crimp	Kings Electronics
KH-19-18	HN	Panel Jack	Crimp	Kings Electronics
KH-39-21	HN	In-Line Jack	Crimp	Kings Electronics
KH-39-22	HN	In-Line Jack	Crimp	Kings Electronics
KH-39-25-M06	HN	In-Line Jack	Crimp	Kings Electronics
KH-59-102-M06	HN	Straight Plug	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KH-59-103-M06	HN	Right Angle Plug	Crimp	Kings Electronics
KH-59-104-M06	HN	Straight Plug	Crimp	Kings Electronics
KH-59-63	HN	Straight Plug	Crimp	Kings Electronics
KH-59-64	HN	Right Angle Plug	Crimp	Kings Electronics
KH-59-65	HN	Straight Plug	Crimp	Kings Electronics
KH-59-66	HN	Right Angle Plug	Crimp	Kings Electronics
KH-59-69	HN	Right Angle Plug	Crimp	Kings Electronics
KH-59-99-M06	HN	Right Angle Plug	Crimp	Kings Electronics
KM-19-08	KM	In-Line Jack	Solder	Kings Electronics
KM-39-07	KM	Tee Jack	Solder	Kings Electronics
KM-59-18	KM	Straight Plug	Solder	Kings Electronics
KM-59-20	KM	Right Angle Plug	Solder	Kings Electronics
KM-59-31	KM	Straight Plug	Solder	Kings Electronics
KM-59-36	KM	Straight Plug	Crimp	Kings Electronics
KM-59-41	KM	Straight Plug	Crimp	Kings Electronics
KN-19-115	N	Panel Jack	Crimp	Kings Electronics
KN-19-117	N	Panel Jack	Crimp	Kings Electronics
KN-19-118	N	Panel Jack	Crimp	Kings Electronics
KN-19-125	N	Bulkhead Jack	Crimp	Kings Electronics
KN-19-145	N	Bulkhead Jack	Crimp	Kings Electronics
KN-19-149	N	Bulkhead Jack	Crimp	Kings Electronics
KN-19-151	N	Bulkhead Jack	Crimp	Kings Electronics
KN-19-162	N	Panel Jack	Crimp	Kings Electronics
KN-19-195-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-196-M06	N	Bulkhead Jack	Crimp	Kings Electronics
KN-19-198-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-199-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-205-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-206-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-207-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-208-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-209-M06	N	Panel Jack	Crimp	Kings Electronics
KN-19-331-M06	-	-	Crimp	Kings Electronics
KN-39-114-M06	N	In-Line Jack	Crimp	Kings Electronics
KN-39-121-M06	N	In-Line Jack	Crimp	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KN-39-122-M06	N	In-Line Jack	Crimp	Kings Electronics
KN-39-71	N	In-Line Jack	Crimp	Kings Electronics
KN-39-72	N	Straight Plug	Crimp	Kings Electronics
KN-39-73	N	In-Line Jack	Crimp	Kings Electronics
KN-39-87	N	In-Line Jack	Crimp	Kings Electronics
KN-39-93	N	In-Line Jack	Crimp	Kings Electronics
KN-59-120	N	Straight Plug	Solder	Kings Electronics
KN-59-159	N	Straight Plug	Crimp	Kings Electronics
KN-59-183	N	Straight Plug	Crimp	Kings Electronics
KN-59-183-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-185	N	Straight Plug	Crimp	Kings Electronics
KN-59-186	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-190	N	Straight Plug	Crimp	Kings Electronics
KN-59-201-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-220	N	Straight Plug	Crimp	Kings Electronics
KN-59-220-M07	N	Straight Plug	Crimp	Kings Electronics
KN-59-239	N	Straight Plug	Crimp	Kings Electronics
KN-59-242-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-247	N	Straight Plug	Crimp	Kings Electronics
KN-59-261	N	Straight Plug	Crimp	Kings Electronics
KN-59-262	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-263	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-264	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-264-M06	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-313-M06	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-329-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-330-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-331-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-332-M06	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-361-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-367-M06	N	Straight Plug	Crimp	Kings Electronics
KN-59-368-M06	N	Right Angle Plug	Crimp	Kings Electronics
KN-59-369-M06	N	Straight Plug	Crimp	Kings Electronics
KS-89-108	-	End Seal, Panel	-	Kings Electronics
KS-89-164	-	End Seal, Bulkhead	-	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Contact Type	Supplier
KS-89-55	-	End Seal, Panel	-	Kings Electronics
KU-59-03	UHF	Straight Plug	Solder	Kings Electronics

Table 2
KEY ANGLES OF KEYED CONNECTORS

Connector Part Number	Key Angle (Degrees)
()-()-1	42
()-()-2	54
()-()-3	66
()-()-4	78
()-()-5	90
()-()-6	102
()-()-7	114
()-()-8	127
()-()-9	138
()-()-10	150
()-()-11	162
()-()-12	174
()-()-13	186
()-()-14	198
()-()-15	210
()-()-16	222
()-()-17	234
()-()-18	246
()-()-19	258
()-()-20	270
()-()-21	282
()-()-22	294
()-()-23	306
()-()-24	318

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 3
ALTERNATIVE COAX CONNECTORS

Specified Connector		Alternative Connector		Notes
Part Number	Supplier	Part Number	Supplier	
1206-11-9	Kings Electronics	1206-30-9	Kings Electronics	-
126-64-9	Kings Electronics	126-70-9	Kings Electronics	-
751-3-9	Kings Electronics	KC-19-129-M06	Kings Electronics	-
795-23-9	Kings Electronics	795-29-9	Kings Electronics	-
795-30-9	Kings Electronics	KD-59-180-M06	Kings Electronics	-
KA-19-143	Kings Electronics	KA-19-143-M06	Kings Electronics	-
KA-19-213	Kings Electronics	KA-19-213-M06	Kings Electronics	-
KA-19-216	Kings Electronics	KA-19-216-M06	Kings Electronics	-
KA-39-44	Kings Electronics	KA-39-102-M06	Kings Electronics	-
KA-59-251	Kings Electronics	KA-59-438-M06	Kings Electronics	-
KA-59-392-M06	Kings Electronics	125-94-9	Kings Electronics	-
KC-19-129	Kings Electronics	KC-19-129-M06	Kings Electronics	-
KC-19-226	Kings Electronics	KC-19-177	Kings Electronics	-
KC-19-261	Kings Electronics	KC-19-261	Kings Electronics	-
KC-19-307-M06	Kings Electronics	751-22-9	Kings Electronics	-
KC-39-45	Kings Electronics	KC-39-109	Kings Electronics	-
KC-59-152	Kings Electronics	755-129-9	Kings Electronics	-
KC-59-259	Kings Electronics	KC-59-383	Kings Electronics	-
KC-59-281	Kings Electronics	KC-59-557-M06	Kings Electronics	-
KC-59-557-M06	Kings Electronics	KC-59-281	Kings Electronics	-
KC-59-585-M06	Kings Electronics	755-79-9	Kings Electronics	-
KC-59-609	Kings Electronics	KC-59-609-M06	Kings Electronics	-
KD-59-120	Kings Electronics	KD-59-163	Kings Electronics	-
KD-59-128	Kings Electronics	KD-59-126	Kings Electronics	-
KD-59-164	Kings Electronics	KD-59-165	Kings Electronics	-
KD-59-180-M06	Kings Electronics	795-30-9	Kings Electronics	-
KD-59-185-M06	Kings Electronics	795-15-9	Kings Electronics	-
KD-59-193-M06	Kings Electronics	796-19-9	Kings Electronics	-
KD-59-199-M06	Kings Electronics	KD-59-201-M06	Kings Electronics	-
KG-19-15-M06	Kings Electronics	821-5-9	Kings Electronics	-
KM-59-18	Kings Electronics	KM-59-41	Kings Electronics	Applicable for the 10-008, 10-008R, RG-11A, and RG-213 cables only

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 3 ALTERNATIVE COAX CONNECTORS (Continued)

Specified Connector		Alternative Connector		Notes
Part Number	Supplier	Part Number	Supplier	
KM-59-31	Kings Electronics	KM-59-41	Kings Electronics	Applicable for the 10-008, 10-008R, RG-11A, and RG-213 cables only
KN-19-115	Kings Electronics	KN-19-207-M06	Kings Electronics	Applicable for the 10-008, 10-008R, RG-11A, and RG-213 cables only
KN-19-199-M06	Kings Electronics	1201-22-9	Kings Electronics	-
KN-19-209-M06	Kings Electronics	KN-19-195-M06	Kings Electronics	Applicable for the 10-008, 10-008R, RG-11A, and RG-213 cables only
KN-39-71	Kings Electronics	1203-14-9	Kings Electronics	Applicable for the 10-008, 10-008R, RG-11A, and RG-213 cables only
KN-59-159	Kings Electronics	KN-59-369-M06	Kings Electronics	-
KN-59-183	Kings Electronics	KN-59-183-M06	Kings Electronics	-
KN-59-183	Kings Electronics	KN-59-369-M06	Kings Electronics	-
KN-59-190	Kings Electronics	KN-59-329-M06	Kings Electronics	-
KN-59-220	Kings Electronics	KN-59-220-M07	Kings Electronics	-
KN-59-264	Kings Electronics	KN-59-264-M06	Kings Electronics	-

B. Necessary Materials

Table 4
NECESSARY MATERIALS

Material	Part Number or Specification	Supplier
Sleeve, Heat Shrinkable	DWP-125	Raychem
Solvent	Isopropyl Alcohol	An available source

2. COAX CONNECTOR ASSEMBLY TOOLS

A. Coax Cable Trim Jigs

Table 5
COAX CABLE TRIM JIGS

Connector	Trim Jig	
	Cable Jacket	Dielectric
1201-6-9	KTJ-223	KTD-404
1203-13-9	KTJ-223	KTD-404
1203-4-9	KTJ-150	KTD-138

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
1205-20-9	KTJ-150	KTD-138
1205-31-9	KTJ-223	KTD-404
1206-11-9	KTJ-223	KTD-404
121-11-9	KTJ-222	KTD-159
121-24-9	KTJ-149	KTD-166
125-60-9	KTJ-149	KTD-166
125-61-9	KTJ-100	KTD-145
125-69-9	KTJ-153	KTD-161
126-14-5	KTJ-150	KTD-138
126-50-9	KTJ-153	KTD-161
126-64-9	KTJ-150	KTD-138
126-70-9	KTJ-150	KTD-138
2431-74-()	KTJ-113	KTD-166
2431-76-()	KTJ-150	KTD-138
2435-74-()	KTJ-113	KTD-166
2435-77-()	KTJ-150	KTD-138
2971-2-()	KTJ-224	KTD-268
2971-3-()	KTJ-160	KTD-208
2975-2-()	KTJ-162	KTD-208
2976-1-()	KTJ-150	KTD-138
2981-1-()	KTJ-223	KTD-404
2981-3-()	KTJ-200	KTD-208
2981-4-()	KTJ-150	KTD-138
2985-2-()	KTJ-162	KTD-208
2986-1-()	KTJ-223	KTD-404
751-2-9	KTJ-187	KTD-225
751-3-9	KTJ-149	KTD-166
751-4-9	KTJ-100	KTD-145
756-4-9	KTJ-187	KTD-225
796-19-9	KTJ-150	KTD-138
796-4-9	KTJ-138	KTD-150
821-2-9	KTJ-160	KTD-208
821-3-9	KTJ-223	KTD-404
823-1-9	KTJ-223	KTD-404

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
825-7-9	KTJ-223	KTD-404
841-1-9	KTJ-154	KTD-137
843-2-9	KTJ-137	KTD-154
845-3-9	KTJ-154	KTD-137
892-2-9	KTJ-154	KTD-208
895-3-9	KTJ-225	KTD-405
KA-19-102	KTJ-113	KTD-166
KA-19-143	KTJ-137	KTD-166
KA-19-143-M06	KTJ-149	KTD-166
KA-19-155	KTJ-116	KTD-161
KA-19-162	KTJ-149	KTD-166
KA-19-163	KTJ-149	KTD-184
KA-19-193	KTJ-113	KTD-184
KA-19-195-M06	KTJ-150	KTD-138
KA-19-198-M06	KTJ-153	KTD-161
KA-19-213	KTJ-150	KTD-138
KA-19-213-M06	KTJ-150	KTD-138
KA-19-216	KTJ-149	KTD-166
KA-19-216-M06	KTJ-149	KTD-166
KA-19-68	KTJ-58	KTD-43
KA-19-83	KTJ-149	KTD-166
KA-39-100-M06	KTJ-150	KTD-138
KA-39-102-M06	KTJ-153	KTD-161
KA-39-44	KTJ-41	KTD-98
KA-39-82	KTJ-149	KTD-166
KA-39-83	KTJ-149	KTD-166
KA-39-85	KTJ-149	KTD-166
KA-39-94-M06	KTJ-149	KTD-166
KA-59-185	KTJ-150	KTD-138
KA-59-185-MC7	KTJ-150	KTD-138
KA-59-186	KTJ-150	KTD-138
KA-59-187	KTJ-150	KTD-138
KA-59-188	KTJ-149	KTD-166
KA-59-189	KTJ-149	KTD-166

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KA-59-230	KTJ-113	KTD-166
KA-59-251	KTJ-131	KTD-166
KA-59-260	KTJ-100	KTD-145
KA-59-277	KTJ-149	KTD-166
KA-59-292	KTJ-113	KTD-166
KA-59-304	KTJ-149	KTD-166
KA-59-313	KTJ-149	KTD-184
KA-59-316	KTJ-150	KTD-138
KA-59-317	KTJ-150	KTD-138
KA-59-324	KTJ-150	KTD-133
KA-59-353-M06	KTJ-150	KTD-138
KA-59-391-M06	KTJ-187	KTD-225
KA-59-392-M06	KTJ-153	KTD-161
KA-59-393-M06	KTJ-153	KTD-161
KA-59-437-M06	KTJ-149	KTD-184
KA-59-438-M06	KTJ-113	KTD-166
KA-59-439-M06	KTJ-149	KTD-166
KA-59-57	KTJ-57	KTD-25
KA-59-73	KTJ-57	KTD-25
KC-19-121	KTJ-57	KTD-25
KC-19-122	KTJ-57	KTD-25
KC-19-129	KTJ-57	KTD-25
KC-19-129-M06	KTJ-57	KTD-25
KC-19-161	KTJ-83	KTD-122
KC-19-169	KTJ-149	KTD-184
KC-19-170	KTJ-149	KTD-166
KC-19-177	KTJ-110	KTD-159
KC-19-177-M06	KTJ-110	KTD-159
KC-19-226	KTJ-110	KTD-159
KC-19-254	KTJ-149	KTD-166
KC-19-255	KTJ-149	KTD-184
KC-19-256	KTJ-149	KTD-166
KC-19-261	KTJ-149	KTD-184
KC-19-262	KTJ-149	KTD-184

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KC-19-307-M06	KTJ-153	KTD-161
KC-19-308-M06	KTJ-153	KTD-161
KC-19-327-M06	KTJ-144	KTD-184
KC-19-328-M06	KTJ-149	KTD-166
KC-19-329-M06	KTJ-153	KTD-161
KC-39-108	KTJ-149	KTD-166
KC-39-109	KTJ-149	KTD-184
KC-39-110	KTJ-149	KTD-166
KC-39-111	KTJ-149	KTD-166
KC-39-140-M06	KTJ-149	KTD-166
KC-39-142-M06	KTJ-153	KTD-161
KC-39-29	KTJ-57	KTD-26
KC-39-36	KTJ-41	KTD-98
KC-39-45	KTJ-57	KTD-26
KC-39-81	KTJ-153	KTD-161
KC-59-104	KTJ-57	KTD-25
KC-59-128	KTJ-57	KTD-26
KC-59-152	KTJ-38	-
KC-59-218	KTJ-57	KTD-25
KC-59-222	KTJ-57	KTD-26
KC-59-259	KTJ-149	KTD-166
KC-59-261	KTJ-149	KTD-166
KC-59-262	KTJ-149	KTD-184
KC-59-263	KTJ-149	KTD-184
KC-59-265	KTJ-153	KTD-161
KC-59-267	KTJ-149	KTD-166
KC-59-281	KTJ-100	KTD-145
KC-59-287	KTJ-100	KTD-145
KC-59-291	KTJ-57	KTD-25
KC-59-383	KTJ-131	KTD-166
KC-59-411	KTJ-149	KTD-166
KC-59-425-M06	KTJ-113	KTD-184
KC-59-444	KTJ-149	KTD-184
KC-59-445	KTJ-150	KTD-138

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KC-59-446	KTJ-153	KTD-161
KC-59-447	KTJ-149	KTD-166
KC-59-448	KTJ-153	KTD-161
KC-59-557-M06	KTJ-174	KTD-218
KC-59-585-M06	KTJ-100	KTD-145
KC-59-604-M06	KTJ-153	KTD-161
KC-59-605-M06	KTJ-153	KTD-161
KC-59-609	KTJ-187	KTD-225
KC-59-609-M06	KTJ-187	KTD-255
KC-59-660-M06	KTJ-100	KTD-145
KC-59-669-M06	KTJ-149	KTD-166
KD-19-104	KTJ-60	KTD-28
KD-19-104-M06	KTJ-160	KTD-138
KD-19-105-M06	KTJ-187	KTD-225
KD-19-107-M06	KTJ-153	KTD-161
KD-19-55	KTJ-160	KTD-208
KD-19-66	KTJ-150	KTD-138
KD-19-67	KTJ-160	KTD-208
KD-19-68	KTJ-160	KTD-208
KD-19-69	KTJ-160	KTD-208
KD-19-90	KTJ-137	KTD-138
KD-19-94	KTJ-150	KTD-138
KD-19-95	KTJ-160	KTD-208
KD-39-27	KTJ-150	KTD-138
KD-39-28	KTJ-160	KTD-208
KD-39-37	KTJ-150	KTD-138
KD-39-42	KTJ-150	KTJ-138
KD-59-110	KTJ-150	KTD-138
KD-59-120	KTJ-150	KTJ-138
KD-59-125	KTJ-160	KTD-208
KD-59-126	KTJ-160	KTD-208
KD-59-128	KTJ-65	KTD-51
KD-59-129	KTJ-160	KTD-208
KD-59-161	KTJ-160	KTD-208

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KD-59-163	KTJ-150	KTJ-138
KD-59-164	KTJ-150	KTD-138
KD-59-165	KTJ-155	KTD-137
KD-59-166	KTJ-153	KTD-161
KD-59-180-M06	KTJ-150	KTD-138
KD-59-184-M06	KTJ-153	KTD-161
KD-59-185	KTJ-153	KTD-161
KD-59-185-M06	KTJ-153	KTD-161
KD-59-186	KTJ-187	KTD-225
KD-59-186-M06	KTJ-187	KTD-225
KD-59-187-M06	KTJ-187	KTD-225
KD-59-193-M06	KTJ-150	KTD-138
KD-59-199-M06	KTJ-160	KTD-208
KD-59-201	KTJ-160	KTD-208
KD-59-201-M06	KTJ-160	KTD-208
KD-59-202	KTJ-160	KTD-208
KD-59-202-M06	KTJ-160	KTD-208
KD-59-52	KTJ-79	KTD-28
KD-59-58	KTJ-79	KTD-50
KD-59-63	KTJ-67	KTD-51
KD-59-64	KTJ-67	KTD-51
KG-19-15-M06	KTJ-150	KTD-138
KG-59-28	KTJ-150	KTD-138
KG-59-31-M06	KTJ-160	KTD-208
KG-59-32-M06	KTJ-160	KTD-208
KG-59-33-M06	KTJ-160	KTD-208
KG-59-34-M06	KTJ-150	KTD-138
KH-19-18	KTJ-154	KTD-137
KH-39-21	KTJ-154	KTD-137
KH-39-22	KTJ-154	KTD-137
KH-39-25-M06	KTJ-190	KTD-233
KH-59-102-M06	KTJ-154	KTD-403
KH-59-103-M06	KTJ-154	KTD-403
KH-59-104-M06	KTJ-154	KTD-437

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KH-59-63	KTJ-154	KTD-137
KH-59-64	KTJ-154	KTD-137
KH-59-65	KTJ-154	KTD-137
KH-59-66	KTJ-154	KTD-137
KH-59-69	KTJ-160	KTD-208
KH-59-99-M06	KTJ-190	KTD-233
KM-19-08	KTJ-114	KTD-216
KM-59-18	KTJ-84	KTD-124
KM-59-20	KTJ-102	KTD-150
KM-59-31	KTJ-84	KTD-124
KM-59-36	KTJ-117	KTD-172
KM-59-41	KTJ-84	KTD-216
KN-19-115	KTJ-160	KTD-208
KN-19-117	KTJ-160	KTD-208
KN-19-125	KTJ-150	KTD-138
KN-19-145	KTJ-137	KTD-138
KN-19-149	KTJ-137	KTD-138
KN-19-162	KTJ-150	KTD-138
KN-19-195-M06	KTJ-150	KTD-138
KN-19-196-M06	KTJ-150	KTD-138
KN-19-198-M06	KTJ-187	KTD-225
KN-19-199-M06	KTJ-153	KTD-161
KN-19-205-M06	KTJ-160	KTD-208
KN-19-206-M06	KTJ-150	KTD-138
KN-19-207-M06	KTJ-160	KTD-208
KN-19-208-M06	KTJ-150	KTD-138
KN-19-209-M06	KTJ-150	KTD-138
KN-39-114-M06	KTJ-187	KTD-225
KN-39-121-M06	KTJ-150	KTD-402
KN-39-122-M06	KTJ-150	KTD-138
KN-39-71	KTJ-160	KTD-208
KN-39-72	KTJ-160	KTD-208
KN-39-73	KTJ-200	KTD-123
KN-39-87	KTJ-160	KTD-208

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 5 COAX CABLE TRIM JIGS (Continued)

Connector	Trim Jig	
	Cable Jacket	Dielectric
KN-39-93	KTJ-150	KTD-138
KN-59-120	KTJ-65	KTD-38
KN-59-159	KTJ-38	KTD-108
KN-59-183	KTJ-149	KTD-166
KN-59-183-M06	KTJ-149	KTD-166
KN-59-185	KTJ-160	KTD-208
KN-59-186	KTJ-160	KTD-208
KN-59-190	KTJ-92	KTD-138
KN-59-201-M06	KTJ-137	KTD-138
KN-59-220	KTJ-150	KTD-138
KN-59-220-M07	KTJ-150	KTD-138
KN-59-239	KTJ-137	KTD-138
KN-59-242-M06	KTJ-162	KTD-208
KN-59-247	KTJ-160	KTD-208
KN-59-261	KTJ-150	KTD-138
KN-59-262	KTJ-150	KTD-138
KN-59-263	KTJ-150	KTD-138
KN-59-264	KTJ-150	KTD-138
KN-59-264-M06	KTJ-150	KTD-138
KN-59-313-M06	KTJ-149	KTD-166
KN-59-329-M06	KTJ-150	KTD-138
KN-59-330-M06	KTJ-187	KTD-225
KN-59-331-M06	KTJ-153	KTD-161
KN-59-332-M06	KTJ-187	KTD-225
KN-59-361-M06	KTJ-200	KTD-123
KN-59-367-M06	KTJ-150	KTD-402
KN-59-368-M06	KTJ-150	KTD-402
KN-59-369-M06	KTJ-160	KTD-208
KS-89-108	KTJ-10	-
KS-89-164	KTJ-10	-
KS-89-55	KTJ-2	-
KU-59-03	KTJ-68	KTD-35

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

B. Coax Connector Crimp Tools

Table 6
COAX CONNECTOR CRIMP TOOL TYPES

Crimp Tool Basic Unit	Type
CT-32	Pneumatic
HX23	Pneumatic
HX4	Hand
KTH-1000	Hand
KTM-1000	Electric
KTM-3000	Pneumatic
KTM-4000	Pneumatic
M22520/5-01	Hand

Table 7
COAX CONNECTOR CRIMP TOOL CODES

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
1075-13-9	051H	213HLS
1201-11-9	043H	178HLS
1201-12-9	100H	213HLS
1201-13-9	100H	334HLS
1201-14-9	100H	384HLS
1201-20-9	100H	255HLS
1201-21-9	144H	552HLS
1201-22-9	100H	213HLS
1201-23-9	100H	334HLS
1201-24-9	100H	384HLS
1201-25-9	100H	255HLS
1201-6-9	132H	522H
1202-20-9	100H	334HLS
1202-23-9	144H	552HLS
1202-26-9	100H	384HLS
1203-13-9	132H	522H
1203-14-9	100H	213HLS
1203-15-9	100H	213HLS
1203-16-9	100H	384HLS
1203-19-9	100H	255HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
1203-20-9	100H	334HLS
1203-21-9	144H	552HLS
1203-4-9	100H	429HLS
1205-20-9	100H	384HS
1205-31-9	132H	522H
1205-47-9	100H	213HLS
1205-48-9	100H	334HLS
1205-49-9	100H	384HLS
1205-61-9	144H	552HLS
1205-62-9	100H	255HLS
1206-11-9	132H	522H
1206-21-9	100H	213HLS
1206-22-9	100H	334HLS
1206-26-9	100H	384HLS
1206-29-9	100H	255HLS
1206-30-9	144H	552HLS
121-11-9	-	105H
121-24-9	069H	213HS
121-35-9	043H	178HLS
121-36-9	069H	213HLS
121-37-9	100H	334HLS
121-38-9	100H	384HLS
121-39-9	069H	255HLS
121-40-9	069H	213HLS
121-44-9	069H	213HLS
121-45-9	100H	334HLS
121-46-9	069H	255HLS
121-52-9	043H	178HLS
122-37-9	069H	213HLS
123-22-5	069H	213HLS
123-23-9	100H	334HLS
123-24-9	069H	255HLS
123-26-9	069H	213HLS
125-101-9	100H	334HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
125-105-9	144H	552HLS
125-126-9	100H	384HLS
125-60-9	069H	213HLS
125-61-9	041H	128HS
125-69-9	069H	178HS
125-88-9	069H	213HLS
125-89-9	043H	178HLS
125-91-9	100H	334HLS
125-92-9	100H	384HLS
125-94-9	069H	213HLS
125-95-9	069H	255HLS
125-96-9	069H	255HLS
126-14-5	100H	429HLS
126-50-9	069H	178HS
126-58-9	069H	213HLS
126-59-9	100H	334HLS
126-64-9	100H	429HLS
126-67-9	043H	178HLS
126-70-9	100H	429HLS
126-71-9	069H	255HLS
126-73-9	100H	384HLS
126-74-9	144H	552HLS
126-78-1	100H	384HLS
126-78-6	100H	384HLS
126-85-9	100H	334H:S
1525-4-9	051H	213HLS
1525-4-9	051H	213HLS
2255-6-4	043H	213HLS
2430-1-()	100H	334HLS
2430-2-()	069H	255HLS
2431-74-()	069H	213HS
2431-76-()	100H	429HS
2431-80-()	069H	213HLS
2431-81-()	043H	178HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
2431-82-()	069H	213HLS
2431-83-()	100H	334HLS
2431-84-()	069H	213HLS
2431-85-()	069H	255HLS
2431-87-()	069H	255HLS
2431-88-()	100H	334HLS
2431-89-()	100H	384HLS
2435-74-()	069H	213HLS
2435-77-()	100H	429HS
2435-81-()	069H	213HLS
2435-82-()	043H	178HLS
2435-83-()	100H	334HLS
2435-84-()	069H	255HLS
2435-87-()	100H	384HLS
2436-81-()	069H	213HLS
2436-83-()	100H	334HLS
2436-85-()	100H	384HLS
2971-2-()	100H	429HLS
2971-3-()	100H	213HS
2971-4-()	100H	213HLS
2971-5-()	100H	384HLS
2971-6-()	100H	334HLS
2971-7-()	100H	334HLS
2971-8-()	100H	213HLS
2975-2-()	100H	213HS
2975-4-()	100H	213HLS
2975-5-()	100H	384HLS
2975-6-()	100H	334HLS
2976-1-()	100H	429HLS
2976-3-()	100H	213HLS
2981-1-()	132H	522H
2981-3-()	100H	213HS
2981-4-()	100H	429HLS
2981-5-()	100H	384HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
2981-6-()	100H	213HLS
2981-7-()	100H	384HLS
2981-8-()	100H	213HLS
2985-2-()	100H	213HS
2985-3-()	100H	213HLS
2985-4-()	100H	384HLS
2986-1-()	132H	522H
2986-3-()	100H	384HLS
751-10-9	069H	213HLS
751-11-9	043H	178HLS
751-2-9	100H	334HLS
751-20-9	069H	255HLS
751-22-9	069H	213HLS
751-3-9	069H	213HS
751-4-9	041H	128HS
752-43-9	069H	213HLS
755-78-9	069H	213HLS
755-79-9	043H	178HLS
755-93-9	069H	255HLS
755-129-9	042H	151H
756-10-9	043H	178HLS
756-16-9	069H	213HLS
756-4-9	100H	334HLS
791-10-9	100H	334HLS
791-11-9	144H	552HLS
791-5-9	100H	213HLS
791-6-9	100H	334HLS
791-7-9	100H	255HLS
791-8-9	100H	255HLS
791-9-9	100H	213HLS
795-15-9	100H	213HLS
795-16-9	100H	334HLS
795-20-9	144H	552HLS
795-21-9	100H	255HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
795-23-9	100H	384HLS
795-29-9	100H	384HLS
795-30-9	100H	429HLS
795-33-9	100H	334HLS
796-15-9	100H	213HLS
796-17-9	100H	255HLS
796-18-9	100H	334HLS
796-19-9	100H	429HLS
796-4-9	100H	384H
821-2-9	100H	213HS
821-3-9	132H	522H
821-4-9	100H	334HLS
821-5-9	100H	384HLS
821-6-9	144H	552HLS
821-7-9	100H	213HLS
821-9-9	144H	552HLS
823-1-9	132H	522H
823-2-9	100H	384HLS
825-10-9	100H	213HLS
825-11-9	100H	334HLS
825-12-9	100H	384HLS
825-14-9	144H	552HLS
825-7-9	132H	522H
826-10-9	100H	384HLS
826-8-9	100H	213HLS
826-9-9	100H	334HLS
841-1-9	100H	384HS
843-2-9	100H	384H
845-3-9	100H	384HS
846-5-9	100H	334HLS
871-59-3	043H	213HLS
875-100-3	051H	255HLS
875-105-3	041H	128HS
875-91-3	043H	213HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
875-92-3	043H	178HLS
876-64-3	043H	213HLS
892-2-9	212HS	213HS
892-3-9	051H	213HLS
895-3-9	051H	212HS
895-6-9	051H	213HLS
896-4-9	051H	213HLS
KA-19-68	100H	213HS
KA-19-83	069H	213HLS
KA-19-102	069H	213H
KA-19-143	069H	213HS
KA-19-143-M06	069H	213HS
KA-19-155	069H	178H
KA-19-162	069H	213HS
KA-19-163	069H	213HS
KA-19-193	069H	255H
KA-19-195-M06	100H	429HS
KA-19-198-M06	069H	178HM
KA-19-213	100H	429HLS
KA-19-213-M06	100H	429HLS
KA-19-216	069H	213HS
KA-19-216-M06	069H	213HS
KA-39-100-M06	100H	429HLS
KA-39-102-M06	069H	178H
KA-39-44	-	178H
KA-39-82	069H	213HS
KA-39-83	069H	213HLS
KA-39-85	069H	213HS
KA-39-94-M06	069H	213HS
KA-59-185	100H	429HS
KA-59-185-MC7	100H	429HS
KA-59-186	100H	429HS
KA-59-187	100H	384HS
KA-59-188	069H	213HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KA-59-189	069H	213HLS
KA-59-230	069H	213H
KA-59-236	069H	213H
KA-59-251	069H	213HS
KA-59-260	041H	128HS
KA-59-277	069H	213HS
KA-59-292	069H	213H
KA-59-304	069H	213HS
KA-59-313	069H	255HS
KA-59-316	100H	429HS
KA-59-317	100H	429HS
KA-59-324	100H	429HLS
KA-59-353-M06	100H	429HLS
KA-59-391-M06	100H	334HLS
KA-59-392-M06	069H	178HM
KA-59-393-M06	069H	178HM
KA-59-437-M06	069H	255HS
KA-59-438-M06	069H	213HS
KA-59-439-M06	069H	213HS
KA-59-57	069H	213H
KA-59-73	-	213H
KC-19-121	069H	213H
KC-19-122	069H	213H
KC-19-129	-	213HS
KC-19-129-M06	-	213HS
KC-19-161	069H	213H
KC-19-169	069H	255HS
KC-19-170	069H	213HLS
KC-19-177	041H	128HS
KC-19-177-M06	041H	128HS
KC-19-226	041H	128HS
KC-19-254	069H	213HS
KC-19-255	069H	255HS
KC-19-256	069H	213HS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KC-19-261	069H	255HS
KC-19-262	069H	255HS
KC-19-307-M06	069H	178HM
KC-19-308-M06	069H	178HM
KC-19-327-M06	069H	255HS
KC-19-328-M06	069H	213HS
KC-19-329-M06	069H	178HS
KC-39-108	069H	213HS
KC-39-109	069H	255HS
KC-39-110	069H	213HLS
KC-39-111	069H	213HS
KC-39-140-M06	069H	213HS
KC-39-142-M06	069H	178HS
KC-39-29	-	255H
KC-39-36	-	178H
KC-39-45	069H	255H
KC-39-81	069H	178H
KC-59-104	069H	213H
KC-59-128	069H	255H
KC-59-152	042H	151H
KC-59-218	069H	213HS
KC-59-222	-	255H
KC-59-259	069H	213HS
KC-59-261	069H	213HS
KC-59-262	069H	255HS
KC-59-263	069H	255HS
KC-59-265	069H	178HS
KC-59-267	069H	213HLS
KC-59-281	041H	128HS
KC-59-287	041H	128HS
KC-59-291	069H	213H
KC-59-383	069H	213HS
KC-59-411	069H	213HS
KC-59-425-M06	069H	255H

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KC-59-444	069H	255HS
KC-59-445	100H	429HS
KC-59-446	069H	178HS
KC-59-447	069H	213HLS
KC-59-448	069H	178HS
KC-59-557-M06	058S	128HLS
KC-59-585-M06	041H	128HS
KC-59-604-M06	069H	178HM
KC-59-605-M06	069H	178HM
KC-59-609	100H	334HLS
KC-59-609-M06	100H	334HLS
KC-59-660-M06	041H	128HS
KC-59-669-M06	069H	213HS
KD-19-104	100H	429HLS
KD-19-104-M06	100H	429HLS
KD-19-105-M06	100H	334HLS
KD-19-107-M06	069H	178HM
KD-19-55	100H	213HS
KD-19-66	100H	429HS
KD-19-67	100H	213HS
KD-19-68	100H	213HS
KD-19-69	100H	213HLS
KD-19-90	100H	429H
KD-19-94	100H	384HS
KD-19-95	100H	213HLS
KD-39-27	100H	384HS
KD-39-28	100H	213HLS
KD-39-37	100H	429HS
KD-39-42	100H	384HS
KD-59-110	100H	429HS
KD-59-120	100H	384HS
KD-59-125	100H	213HLS
KD-59-126	100H	213HLS
KD-59-128	041H	128HS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KD-59-129	100H	213HS
KD-59-161	100H	213HS
KD-59-163	100H	384HS
KD-59-164	100H	429HS
KD-59-165	100H	429HS
KD-59-166	100H	178HS
KD-59-180-M06	100H	429HLS
KD-59-184-M06	100H	178HM
KD-59-185	100H	178HM
KD-59-185-M06	100H	178HM
KD-59-186	100H	334HLS
KD-59-186-M06	100H	334HLS
KD-59-187-M06	100H	334HLS
KD-59-193-M06	100H	429HLS
KD-59-199-M06	100H	213HS
KD-59-201	100H	213HS
KD-59-201-M06	100H	213HS
KD-59-202	100H	213HS
KD-59-202-M06	100H	213HS
KD-59-52	100H	429H
KD-59-58	100H	0.324
KD-59-63	-	213H
KD-59-64	-	213H
KG-19-15-M06	100H	429HLS
KG-59-28	100H	429HS
KG-59-31-M06	100H	213HS
KG-59-32-M06	100H	213HS
KG-59-33-M06	100H	213HS
KG-59-34-M06	100H	429HLS
KH-19-18	100H	384HS
KH-39-21	100H	384HS
KH-39-22	100H	429H
KH-39-25-M06	100H	334HLS
KH-59-102-M06	100H	429H

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KH-59-103-M06	100H	429H
KH-59-104-M06	100H	429HLS
KH-59-63	100H	384HS
KH-59-64	100H	384HS
KH-59-65	100H	429HS
KH-59-66	100H	429HS
KH-59-69	100H	213H
KH-59-99-M06	069H	178HM
KM-19-08	-	128H
KM-39-07	-	128H
KM-59-18	-	128H
KM-59-20	-	128H
KM-59-31	-	128H
KM-59-36	069H	213HS
KM-59-41	051H	128H
KN-19-115	100H	213HS
KN-19-117	100H	213HLS
KN-19-118	069H	255HS
KN-19-125	100H	429HS
KN-19-145	100H	429H
KN-19-149	100H	429H
KN-19-151	100H	213H
KN-19-162	100H	429HS
KN-19-195-M06	100H	429HLS
KN-19-196-M06	100H	429HLS
KN-19-198-M06	100H	334HLS
KN-19-199-M06	069H	178HM
KN-19-205-M06	100H	213HS
KN-19-206-M06	100H	429H
KN-19-207-M06	100H	213HS
KN-19-208-M06	100H	384HS
KN-19-209-M06	100H	429HLS
KN-19-331-M06	069H	178HM
KN-39-114-M06	100H	334HLS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KN-39-121-M06	100H	429H
KN-39-122-M06	100H	384HS
KN-39-71	100H	213HS
KN-39-72	100H	213HLS
KN-39-73	100H	255HS
KN-39-87	100H	213HS
KN-39-93	100H	429HS
KN-59-120	-	213H
KN-59-159	100H	213HS
KN-59-183	069H	213HS
KN-59-183-M06	069H	213HS
KN-59-185	100H	213HLS
KN-59-186	100H	213HLS
KN-59-190	100H	429HLS
KN-59-201-M06	100H	213HS
KN-59-220	100H	429HS
KN-59-220-M07	100H	429H
KN-59-239	100H	429H
KN-59-242-M06	100H	213H
KN-59-247	100H	213HS
KN-59-261	100H	384HS
KN-59-262	100H	384HS
KN-59-263	100H	429HS
KN-59-264	100H	429HLS
KN-59-264-M06	100H	429HLS
KN-59-313-M06	069H	213HS
KN-59-329-M06	100H	429HLS
KN-59-330-M06	100H	334HLS
KN-59-331-M06	069H	178HM
KN-59-332-M06	100H	334HLS
KN-59-361-M06	100H	255HS
KN-59-367-M06	100H	429H
KN-59-368-M06	100H	429H
KN-59-369-M06	100H	213HS

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 7 COAX CONNECTOR CRIMP TOOL CODES (Continued)

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
KS-89-108	-	213HS
KS-89-164	-	213HLS
KS-89-55	-	213H
KU-59-03	-	384H

Table 8
COAX CONNECTOR CENTER CONTACT CRIMP TOOLS

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
041H	CT-32	-	0.041	KTH-2081	B
	KTH-1000	-		KTH-2081	B
	KTM-1000	KTM-1099		KTH-2081	B
	KTM-3000	-		KTH-2081	B
	KTM-4000	-		KTH-2081	B
042H	CT-32	-	0.042	KTH-2021	B
				KTH-2032	A
	KTH-1000	-		KTH-2021	B
				KTH-2032	A
	KTM-1000	KTM-1099		KTH-2021	B
				KTH-2032	A
	KTM-3000	-		KTH-2021	B
				KTH-2032	A
	KTM-4000	-		KTH-2021	B
KTH-2032			A		

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 8 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
043H	CT-32	-	0.043	KTH-2207	B
	KTH-1000	-		KTH-2214	B
				KTH-2207	B
				KTH-2214	B
				KTH-2207	B
	KTH-2214	B			
	KTM-1000	KTM-1099		KTH-2207	B
	KTM-3000	-		KTH-2214	B
				KTH-2207	B
				KTH-2214	B
KTH-2207			B		
KTH-2214	B				
050H	CT-32	-	0.050	KTH-2023	A
	KTH-1000	-		KTH-2023	A
	KTM-1000	KTM-1099		KTH-2023	A
	KTM-3000	-		KTH-2023	A
	KTM-4000	-		KTH-2023	A
				KTH-2023	A
051H	CT-32	-	0.051	KTH-2022	A
				KTH-2087	B
				KTH-2232	B
				KTH-2242	B
051H	KTH-1000	-	0.051	KTH-2022	A
				KTH-2087	B
				KTH-2232	B
				KTH-2242	B
051H	KTM-1000	KTM-1099	0.051	KTH-2022	A
				KTH-2087	B
				KTH-2232	B
				KTH-2242	B
051H	KTM-3000	-	0.051	KTH-2022	A
				KTH-2087	B
				KTH-2232	B
				KTH-2242	B

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 8 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
051H	KTM-4000	-	0.051	KTH-2022	A
				KTH-2087	B
				KTH-2232	B
				KTH-2242	B
058S	KTH-1000	-	0.058	KTH-2138	Square
	KTM-1000	KTM-1099		KTH-2138	Square
	KTM-3000	-		KTH-2138	Square
	KTM-4000	-		KTH-2138	Square
069H	CT-32	-	0.069	683-51470-1	-
				KTH-2001	A
				KTH-2007	A
				KTH-2061	A
				KTH-2111	B
				KTH-2128	A
				KTH-2161	B
				KTH-2216	Small
069H	KTH-1000	-	0.069	683-51470-1	-
				KTH-2001	A
				KTH-2007	A
				KTH-2061	A
				KTH-2111	B
				KTH-2128	A
				KTH-2161	B
				KTH-2216	Small
069H	KTM-1000	KTM-1099	0.069	683-51470-1	-
				KTH-2001	A
				KTH-2007	A
				KTH-2061	A
				KTH-2111	B
				KTH-2128	A
				KTH-2161	B
				KTH-2216	Small

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 8 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
069H	KTM-3000	-	0.069	683-51470-1	-
				KTH-2001	A
				KTH-2007	A
				KTH-2061	A
				KTH-2111	B
				KTH-2128	A
				KTH-2161	B
				KTH-2216	Small
069H	KTM-4000	-	0.069	683-51470-1	-
				KTH-2001	A
				KTH-2007	A
				KTH-2061	A
				KTH-2111	B
				KTH-2128	A
				KTH-2161	B
				KTH-2216	Small
100H	227-944	-	0.100	227-1221-25	-
				227-1221-57	-
				227-1351-3	B
				227-956-4	B
				M22520/5-57	-
	227-956-4	-		-	-
100H	CT-32	-	0.100	KTH-1078	A
				KTH-1079	A
				KTH-2004	A
				KTH-2042	A
				KTH-2105	A
				KTH-2106	A
				KTH-2127	A
				KTH-2211	B
				KTH-2212	B
				KTH-2213	A
				KTH-2231	B

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 8 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
100H	HX23	-	0.100	227-1221-25	-
				227-1221-57	-
				227-1351-3	B
				227-1351-4	B
				227-956-4	-
				M22520/5-57	-
100H	HX4	-	0.100	227-1221-25	-
				227-1221-57	-
				227-1351-3	B
				227-1351-4	B
				227-956-4	-
				M22520/5-57	-
100H	KTH-1000	-	0.100	KTH-1078	A
				KTH-1079	A
				KTH-2004	A
				KTH-2042	A
				KTH-2105	A
				KTH-2106	A
				KTH-2127	A
				KTH-2211	B
				KTH-2212	B
				KTH-2213	A
				KTH-2231	B

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 8 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
100H	KTM-1000	KTM-1099	0.100	KTH-1078	A
				KTH-1079	A
				KTH-2004	A
				KTH-2042	A
				KTH-2105	A
				KTH-2106	A
				KTH-2127	A
				KTH-2211	B
				KTH-2212	B
				KTH-2213	A
				KTH-2231	B
100H	KTM-3000	-	0.100	KTH-1078	A
				KTH-1079	A
				KTH-2004	A
				KTH-2042	A
				KTH-2105	A
				KTH-2106	A
				KTH-2127	A
				KTH-2211	B
				KTH-2212	B
				KTH-2213	A
				KTH-2231	B
100H	KTM-4000	-	0.100	KTH-1078	A
				KTH-1079	A
				KTH-2004	A
				KTH-2042	A
				KTH-2105	A
				KTH-2106	A
				KTH-2127	A
				KTH-2211	B
				KTH-2212	B
				KTH-2213	A
				KTH-2231	B

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 8 COAX CONNECTOR CENTER CONTACT CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
100H	M22520/5-01	-	0.100	227-1221-25	-
				227-1221-57	-
				227-1351-3	B
				227-1351-4	B
				227-956-4	-
				M22520/5-57	-
132H	HX23	-	0.132	Y1731	B
	HX4	-		Y1731	B
	KTH-1000	-		KTH-2177	-
	KTM-1000	KTM-1099		KTH-2177	-
	KTM-3000	-		KTH-2177	-
	KTM-4000	-		KTH-2177	-
	M22520/5-01	-		Y1731	B
144H	KTH-1000	-	0.144	KTH-2229	B
	KTM-1000	KTM-1099		KTH-2229	B
	KTM-3000	-		KTH-2229	B
	KTM-4000	-		KTH-2229	B
212HS	CT-32	-	0.212	KTH-2087	A
	KTH-1000	-		KTH-2087	A
	KTM-1000	KTM-1099		KTH-2087	A
	KTM-3000	-		KTH-2087	A
	KTM-4000	-		KTH-2087	A

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 9
COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
105H	612648	-	0.105	612734	B
	CT-32	-		KTH-2008	A
	HX23	-		KTH-2230	B
	HX4	-		M22520/5-03	B
				M22520/5-03	B
105H	KTH-1000	-	0.105	KTH-2008	A
				KTH-2230	B
	KTM-1000	KTM-1099		KTH-2008	A
				KTH-2230	B
	KTM-3000	-		KTH-2008	A
				KTH-2230	B
	KTM-4000	-		KTH-2008	A
				KTH-2230	B
128H	M22520/5-01	-	0.128	M22520/5-03	B
	227-944	-		M22520/5-08	-
	612648	-		612778	B
				683-51454-3	-
	CT-32	-		KTH-2011	A
				KTH-2021	A
				KTH-2022	A
128H	HX23	-	0.128	M22520/5-03	A
				M22520/5-08	-
				M22520/5-35	B
				Y119	A
				M22520/5-03	-
				M22520/5-08	-
				M22520/5-35	B
	HX4	-		Y119	A

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
128H	KTH-1000	-	0.128	683-51454-3	-
				KTH-2011	A
				KTH-2021	A
				KTH-2022	A
	KTM-1000	KTM-1099		683-51454-3	-
				KTH-2011	A
				KTH-2021	A
				KTH-2022	A
128H	KTM-3000	-	0.128	683-51454-3	-
				KTH-2011	A
				KTH-2021	A
				KTH-2022	A
	KTM-4000	-		683-51454-3	-
				KTH-2011	A
				KTH-2021	A
				KTH-2022	A
128H	M22520/5-01	-	0.128	M22520/5-03	A
				M22520/5-08	-
				M22520/5-35	B
				Y119	A
	ST2966M	-		ST2966M-1	-
	WT-200	-		-	-
128HLS	KTH-1000	-	0.128	KTH-2138	Hex
128HS	KTH-1000	-	0.128	KTH-2081	A

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
151H	CT-32	-	0.151	KTH-2023	B
	KTH-1000	-		KTH-2032	B
				KTH-2023	B
				KTH-2032	C
				KTH-2023	B
	KTH-2032	C			
	KTM-1000	KTM-1099		KTH-2023	B
	KTH-2032	C			
	KTH-2023	B			
	KTH-2032	C			
KTH-2023	B				
KTH-2032	C				
178H	612648	-	0.178	612642	B
	CT-32	-		KTH-2007	C
	HX23	-		M22520/5-05	B
				M22520/5-41	B
				Y197	B
	HX4	-		M22520/5-05	B
				M22520/5-41	B
				Y197	B
178H	KTH-1000	-	0.178	KTH-2007	C
	KTM-1000	KTM-1099		KTH-2007	C
	KTM-3000	-		KTH-2007	C
	KTM-4000	-		KTH-2007	C
	M22520/5-01	-		M22520/5-05	B
				M22520/5-41	B
				Y197	B
178HLS	CT-32	-	0.178	KTH-2214	A
	KTH-1000	-		KTH-2214	A
	KTM-1000	KTM-1099		KTH-2214	A
	KTM-3000	-		KTH-2214	A
	KTM-4000	-		KTH-2214	A

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
178HLSM	CT-32	-	0.178	KTH-2138	Hex
	KTH-1000	-		KTH-2138	Hex
	KTM-1000	KTM-1099		KTH-2138	Hex
	KTM-3000	-		KTH-2138	Hex
	KTM-4000	-		KTH-2138	Hex
178HM	CT-32	-	0.178	KTH-2128	B
	KTH-1000	-		KTH-2128	B
	KTM-1000	KTM-1099		KTH-2128	B
	KTM-3000	-		KTH-2128	B
	KTM-4000	-		KTH-2128	B
178HS	CT-32	-	0.178	KTH-2067	A
		-		KTH-2102	A
	KTH-1000	-		KTH-2067	A
				KTH-2102	A
178HS	KTM-1000	KTM-1099	0.178	KTH-2067	A
				KTH-2102	A
	KTM-3000	-		KTH-2067	A
				KTH-2102	A
	KTM-4000	-		KTH-2067	A
				KTH-2102	A
212HS	CT-32	-	0.212	KTH-2087	A
	KTH-1000	-		KTH-2087	A
	KTM-1000	KTM-1099		KTH-2087	A
	KTM-3000	-		KTH-2087	A
	KTM-4000	-		KTH-2087	A
213H	227-944	-	0.213	M22520/5-19	B
	612648	-		612673	A
	CT-32	-		KTH-2001	B
				KTH-2042	B
				KTH-2220	B

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
213H	HX23	-	0.213	M22520/5-05	A
				M22520/5-19	B
				Y142	B
				Y197	A
				Y322	B
213H	HX4	-	0.213	M22520/5-05	A
				M22520/5-19	B
				Y142	B
				Y197	A
				Y322	B
213H	KTH-1000	-	0.213	KTH-2001	B
				KTH-2042	B
				KTH-2220	B
	KTM-1000	KTM-1099		KTH-2001	B
				KTH-2042	B
				KTH-2220	B
213H	KTM-3000	-	0.213	KTH-2001	B
				KTH-2042	B
				KTH-2220	B
	KTM-4000	-		KTH-2001	B
				KTH-2042	B
				KTH-2220	B
213H	M22520/5-01	-	0.213	M22520/5-05	A
				M22520/5-19	B
				Y142	B
				Y197	A
				Y322	B
	ST2966M	-		ST2966M-6	B
213HLS	CT-32	-	0.213	KTH-2103	B
				KTH-2161	A
				KTH-2207	A
				KTH-2211	A

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
213HLS	KTH-1000	-	0.213	KTH-2103	B
				KTH-2161	A
				KTH-2207	A
				KTH-2211	A
213HLS	KTM-1000	KTM-1099	0.213	KTH-2103	B
				KTH-2161	A
				KTH-2207	A
				KTH-2211	A
213HLS	KTM-3000	-	0.213	KTH-2103	B
				KTH-2161	A
				KTH-2207	A
				KTH-2211	A
213HLS	KTM-4000	-	0.213	KTH-2103	B
				KTH-2161	A
				KTH-2207	A
				KTH-2211	A
213HS	CT-32	-	0.213	KTH-1061	B
				KTH-2061	A
				KTH-2087	A
				KTH-2101	A
213HS	KTH-1000	-	0.213	KTH-1061	B
				KTH-2061	A
				KTH-2087	A
				KTH-2101	A
213HS	KTM-1000	KTM-1099	0.213	KTH-1061	B
				KTH-2061	A
				KTH-2087	A
				KTH-2101	A
213HS	KTM-3000	-	0.213	KTH-1061	B
				KTH-2061	A
				KTH-2087	A
				KTH-2101	A

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
213HS	KTM-4000	-	0.213	KTH-1061	B
				KTH-2061	A
				KTH-2087	A
				KTH-2101	A
255H	612648	-	0.255	612675	B
	CT-32	-		KTH-2002	C
	HX23	-		M22520/5-19	A
				Y142	A
	HX4	-		M22520/5-19	A
				Y142	A
255H	KTH-1000	-	0.255	KTH-2002	C
	KTM-1000	KTM-1099		KTH-2002	C
	KTM-3000	-		KTH-2002	C
	KTM-4000	-		KTH-2002	C
	M22520/5-01	-		M22520/5-19	A
				Y142	A
	ST2966M	-		ST2966M-8	-
255HLS	CT-32	-	0.255	KTH-2216	Large
	KTH-1000	-		KTH-2231	A
				KTH-2216	Large
				KTH-2231	A
				KTH-2216	Large
	KTM-1000	KTM-1099		KTH-2231	A
255HLS	KTM-3000	-	0.255	KTH-2216	Large
	KTM-4000	-		KTH-2231	A
				KTH-2216	Large
				KTH-2231	A
255HS	CT-32	-	0.255	KTH-1062	D
				KTH-2062	C
				KTH-2242	A
	KTH-1000	-		KTH-1062	D
				KTH-2062	C
				KTH-2242	A

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
255HS	KTM-1000	KTM-1099	0.255	KTH-1062	D
				KTH-2062	C
				KTH-2242	A
	KTM-3000	-		KTH-1062	D
				KTH-2062	C
				KTH-2242	A
	KTM-4000	-		KTH-1062	D
				KTH-2062	C
KTH-2242	A				
334HLS	CT-32	-	0.334	KTH-2127	B
	KTH-1000	-		KTH-2212	A
				KTH-2127	B
				KTH-2212	A
				KTH-2127	B
	KTH-2212	A			
334HLS	KTM-3000	-	0.334	KTH-2127	B
	KTM-4000	-		KTH-2212	A
				KTH-2127	B
				KTH-2212	A
384H	612648	-	0.384	612739	B
	CT-32	-		KTH-2003	A
	HX23	-		M22520/5-23	A
	HX4	-		M22520/5-23	A
	KTH-1000	-		KTH-2003	A
384H	KTM-1000	KTM-1099	0.384	KTH-2003	A
	KTM-3000	-		KTH-2003	A
	KTM-4000	-		KTH-2003	A
	M22520/5-01	-		M22520/5-23	A
	ST2352-5-Y	-		ST2352-5-1	B
	ST2966M	-		ST2966M-13	-

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
384HLS	CT-32	-	0.384	KTH-2213	B
	KTH-1000	-		KTH-2213	B
	KTM-1000	KTM-1099		KTH-2213	B
	KTM-3000	-		KTH-2213	B
	KTM-4000	-		KTH-2213	B
384HS	CT-32	-	0.384	KTH-1078	B
	KTH-1000	-		KTH-1078	B
	KTM-1000	KTM-1099		KTH-1078	B
	KTM-3000	-		KTH-1078	B
	KTM-4000	-		KTH-1078	B
429H	612648	-	0.429	612807	B
	CT-32	-		KTH-2004	A
	HX23	-		KTH-2235	A
	HX4	-		M22520/5-25	A
				M22520/5-25	A
429H	KTH-1000	-	0.429	KTH-2004	A
				KTH-2235	A
	KTM-1000	KTM-1099		KTH-2004	A
				KTH-2235	A
	KTM-3000	-		KTH-2004	A
				KTH-2235	A
429H	KTM-4000	-	0.429	KTH-2004	A
				KTH-2235	A
	M22520/5-01	-		M22520/5-25	A
	ST2352-5-Y	-		ST2352-5-2	-
	ST2966M	-		ST2966M-16	-
429HLS	CT-32	-	0.429	KTH-2105	B
	KTH-1000	-		KTH-2105	B
	KTM-1000	KTM-1099		KTH-2105	B
	KTM-3000	-		KTH-2105	B
	KTM-4000	-		KTH-2105	B

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 9 COAX CONNECTOR K-GRIP SLEEVE CRIMP TOOLS (Continued)

Tool Code	Crimp Tool				
	Basic Unit	Master Jaws	Die		
			Opening (inch)	Part Number	Die Opening Designator
429HS	CT-32	-	0.429	KTH-1079	A
	KTH-1000	-		KTH-1079	A
	KTM-1000	KTM-1099		KTH-1079	A
	KTM-3000	-		KTH-1079	A
	KTM-4000	-		KTH-1079	A
522H	CT-32	-	0.522	KTH-2177	B
	KTH-1000	-		KTH-2177	B
	KTM-1000	KTM-1099		KTH-2177	B
	KTM-3000	-		KTH-2177	B
	KTM-4000	-		KTH-2177	B
522HS	CT-32	-	0.522	KTH-2177	B
	KTH-1000	-		KTH-2177	B
	KTM-1000	KTM-1099		KTH-2177	B
	KTM-3000	-		KTH-2177	B
	KTM-4000	-		KTH-2177	B
552HLS	CT-32	-	0.552	KTH-2229	A
	KTH-1000	-		KTH-2229	A
	KTM-1000	KTM-1099		KTH-2229	A
	KTM-3000	-		KTH-2229	A
	KTM-4000	-		KTH-2229	A

Table 10
ALTERNATIVE TOOLS

Specified Tool		Alternative Tool			
		Die		Crimp Tool Basic Unit	
Die Part Number	Supplier	Part Number	Supplier	Part Number	Supplier
KTH-2061	Kings	Y572	Daniels	HX4	Daniels
KTH-2161	Kings	Y679	Daniels	HX4	Daniels
KTH-2177	Kings	Y825	Daniels	HX4	Daniels

20-51-15

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

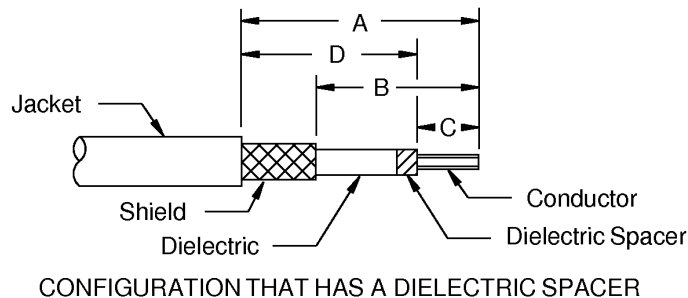
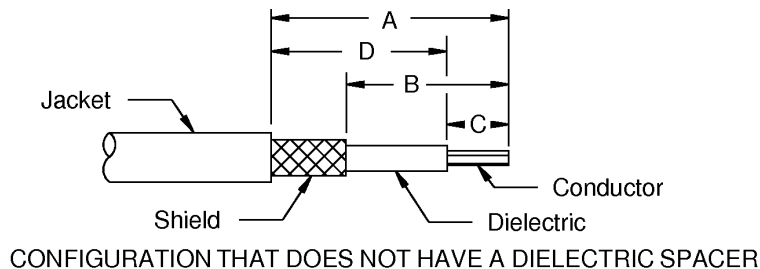
3. CONNECTOR ASSEMBLY

This paragraph gives the procedures to assemble:

- A bulkhead jack
- An in-line jack
- A panel jack
- A straight plug
- A right angle plug with crimp type contacts.

For the procedures to assemble a right angle plug with solder type contacts, refer to Paragraph 4.

A. Cable Preparation Dimensions



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CABLE PREPARATION DIMENSIONS

Figure 3

Table 11

CABLE PREPARATION DIMENSIONS

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
1075-13-9	0.94	0.63	0.19	0.75
1201-11-9	0.59	0.28	0.16	0.43
1201-12-9	0.69	0.38	0.19	0.50
1201-13-9	0.69	0.38	0.19	0.50

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
1201-14-9	0.69	0.38	0.19	0.50
1201-20-9	0.69	0.38	0.19	0.50
1201-21-9	0.69	0.38	0.19	0.50
1201-22-9	0.69	0.38	0.19	0.50
1201-23-9	0.69	0.38	0.19	0.50
1201-24-9	0.69	0.38	0.19	0.50
1201-25-9	0.69	0.38	0.19	0.50
1201-6-9	0.69	0.38	0.19	0.50
1202-20-9	0.69	0.38	0.19	0.50
1202-23-9	0.69	0.38	0.19	0.50
1202-26-9	0.69	0.38	0.19	0.50
1203-13-9	0.69	0.38	0.19	0.50
1203-14-9	0.69	0.38	0.19	0.50
1203-15-9	0.69	0.38	0.19	0.50
1203-16-9	0.69	0.38	0.19	0.50
1203-19-9	0.69	0.38	0.19	0.50
1203-20-9	0.69	0.38	0.19	0.50
1203-21-9	0.69	0.38	0.19	0.50
1203-4-9	0.69	0.38	0.19	0.50
1205-20-9	0.69	0.38	0.19	0.50
1205-31-9	0.69	0.38	0.19	0.50
1205-47-9	0.69	0.38	0.19	0.50
1205-48-9	0.69	0.38	0.19	0.50
1205-49-9	0.69	0.38	0.19	0.50
1205-61-9	0.69	0.38	0.19	0.50
1205-62-9	0.69	0.38	0.19	0.50
1206-11-9	0.69	0.38	0.19	0.50
1206-21-9	0.69	0.38	0.19	0.50
1206-22-9	0.69	0.38	0.19	0.50
1206-26-9	0.69	0.38	0.19	0.50
1206-29-9	0.69	0.38	0.19	0.50
1206-30-9	0.69	0.38	0.19	0.50

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
121-11-9	0.73	0.51	0.28	0.45
121-24-9	0.59	0.31	0.16	0.43
121-35-9	0.59	0.28	0.16	0.43
121-36-9	0.59	0.28	0.16	0.43
121-37-9	0.69	0.38	0.19	0.50
121-38-9	0.69	0.38	0.19	0.50
121-39-9	0.59	0.28	0.16	0.43
121-40-9	0.59	0.28	0.16	0.43
121-44-9	0.59	0.28	0.16	0.43
121-45-9	0.69	0.38	0.19	0.50
121-46-9	0.59	0.28	0.16	0.43
121-52-9	0.59	0.28	0.16	0.43
122-37-9	0.59	0.28	0.16	0.43
123-22-5	0.59	0.28	0.16	0.43
123-23-9	0.69	0.38	0.19	0.50
123-24-9	0.59	0.28	0.16	0.43
123-26-9	0.59	0.28	0.16	0.43
125-101-9	0.69	0.38	0.19	0.50
125-105-9	0.69	0.38	0.19	0.50
125-126-9	0.69	0.38	0.19	0.50
125-60-9	0.59	0.31	0.16	0.43
125-61-9	0.59	0.40	0.28	0.38
125-69-9	0.59	0.31	0.16	0.43
125-88-9	0.59	0.28	0.16	0.43
125-89-9	0.59	0.28	0.16	0.43
125-91-9	0.69	0.38	0.19	0.50
125-92-9	0.69	0.38	0.19	0.50
125-94-9	0.59	0.28	0.16	0.43
125-95-9	0.59	0.28	0.16	0.43
125-96-9	0.59	0.28	0.16	0.43
126-14-5	0.69	0.38	0.19	0.50
126-50-9	0.59	0.31	0.16	0.43

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
126-58-9	0.59	0.28	0.16	0.43
126-59-9	0.69	0.38	0.19	0.50
126-64-9	0.69	0.38	0.19	0.50
126-67-9	0.59	0.28	0.16	0.43
126-70-9	0.69	0.38	0.19	0.50
126-71-9	0.59	0.28	0.16	0.43
126-73-9	0.69	0.38	0.19	0.50
126-74-9	0.69	0.38	0.19	0.50
126-78-1	0.69	0.38	0.19	0.50
126-78-6	0.69	0.38	0.19	0.50
126-85-9	0.69	0.38	0.19	0.50
1525-4-9	0.59	0.28	0.16	0.43
2255-6-4	0.59	0.28	0.16	0.43
2430-1-()	0.69	0.38	0.19	0.50
2430-2-()	0.69	0.38	0.19	0.50
2431-74-()	0.59	0.20	0.16	0.43
2431-76-()	0.69	0.38	0.31	0.50
2431-80-()	0.59	0.28	0.16	0.43
2431-81-()	0.59	0.28	0.16	0.43
2431-82-()	0.59	0.28	0.16	0.43
2431-83-()	0.69	0.38	0.19	0.50
2431-84-()	0.59	0.28	0.16	0.43
2431-85-()	0.59	0.28	0.16	0.43
2431-87-()	0.59	0.28	0.16	0.43
2431-88-()	0.69	0.38	0.19	0.50
2431-89-()	0.69	0.38	0.19	0.50
2435-74-()	0.59	0.25	0.16	0.43
2435-77-()	0.69	0.38	0.31	0.50
2435-81-()	0.59	0.28	0.16	0.43
2435-82-()	0.59	0.28	0.16	0.43
2435-83-()	0.69	0.38	0.19	0.50
2435-84-()	0.59	0.28	0.16	0.43

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
2435-87-()	1.10	0.50	0.25	0.85
2436-81-()	0.59	0.28	0.16	0.43
2436-83-()	0.69	0.38	0.19	0.50
2436-85-()	0.69	0.38	0.19	0.50
2971-2-()	0.71	0.40	0.19	0.53
2971-3-()	0.69	0.41	0.19	0.50
2971-4-()	0.69	0.38	0.19	0.50
2971-5-()	0.69	0.38	0.19	0.50
2971-6-()	0.69	0.38	0.19	0.50
2971-7-()	0.69	0.38	0.19	0.50
2971-8-()	0.69	0.38	0.19	0.50
2975-2-()	0.69	0.38	0.19	0.50
2975-4-()	0.69	0.38	0.19	0.50
2975-5-()	0.69	0.38	0.19	0.50
2975-6-()	0.69	0.38	0.19	0.50
2976-1-()	0.69	0.38	0.19	0.50
2976-3-()	0.69	0.38	0.19	0.50
2981-1-()	0.69	0.38	0.19	0.50
2981-3-()	0.69	0.38	0.19	0.50
2981-4-()	0.69	0.38	0.19	0.50
2981-5-()	0.69	0.38	0.19	0.50
2981-6-()	0.69	0.38	0.19	0.50
2981-7-()	0.69	0.38	0.19	0.50
2981-8-()	0.69	0.38	0.19	0.50
2985-2-()	0.69	0.38	0.19	0.50
2985-3-()	0.69	0.38	0.19	0.50
2985-4-()	0.69	0.38	0.19	0.50
2986-1-()	0.69	0.38	0.19	0.50
2986-3-()	0.69	0.38	0.19	0.50
751-10-9	0.59	0.28	0.16	0.43
751-11-9	0.59	0.28	0.16	0.43
751-2-9	0.69	0.38	0.19	0.50

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
751-20-9	0.59	0.28	0.16	0.43
751-22-9	0.59	0.28	0.16	0.43
751-3-9	0.59	0.31	0.16	0.43
751-4-9	0.59	0.41	0.22	0.38
752-43-9	0.59	0.28	0.16	0.43
755-78-9	0.59	0.28	0.16	0.43
755-79-9	0.59	0.28	0.16	0.43
755-93-9	0.59	0.28	0.16	0.43
755-129-9	0.28	0.00	0.19	0.09
756-10-9	0.59	0.28	0.16	0.43
756-16-9	0.59	0.28	0.16	0.43
756-4-9	0.69	0.38	0.19	0.50
791-10-9	0.69	0.38	0.19	0.50
791-11-9	0.69	0.38	0.19	0.50
791-5-9	0.69	0.38	0.19	0.50
791-6-9	0.69	0.38	0.19	0.50
791-7-9	0.69	0.38	0.19	0.50
791-8-9	0.69	0.38	0.19	0.50
791-9-9	0.69	0.38	0.19	0.50
795-15-9	0.69	0.38	0.19	0.50
795-16-9	0.69	0.38	0.19	0.50
795-20-9	0.69	0.38	0.19	0.50
795-21-9	0.69	0.38	0.19	0.50
795-23-9	0.69	0.38	0.19	0.50
795-29-9	0.69	0.38	0.19	0.50
795-30-9	0.38	0.06	0.50	0.19
795-33-9	0.82	0.51	0.19	0.63
796-15-9	0.69	0.38	0.19	0.50
796-17-9	0.69	0.38	0.19	0.50
796-18-9	0.69	0.38	0.19	0.50
796-19-9	0.69	0.38	0.19	0.50
796-4-9	0.72	0.50	0.14	0.58

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
821-2-9	0.69	0.41	0.19	0.50
821-3-9	0.69	0.38	0.19	0.50
821-4-9	0.69	0.38	0.19	0.50
821-5-9	0.69	0.38	0.19	0.50
821-6-9	0.69	0.38	0.19	0.50
821-7-9	0.69	0.38	0.19	0.50
821-9-9	0.69	0.38	0.19	0.50
823-1-9	0.72	0.50	0.14	0.58
823-2-9	0.69	0.38	0.19	0.50
825-10-9	0.69	0.38	0.19	0.50
825-11-9	0.69	0.38	0.19	0.50
825-12-9	0.69	0.38	0.19	0.50
825-14-9	0.69	0.38	0.19	0.50
825-7-9	0.69	0.38	0.19	0.50
826-10-9	0.69	0.38	0.19	0.50
826-8-9	0.69	0.38	0.19	0.50
826-9-9	0.69	0.38	0.19	0.50
841-1-9	0.94	0.63	0.19	0.75
843-2-9	0.94	0.63	0.19	0.75
845-3-9	0.94	0.63	0.19	0.75
846-5-9	0.69	0.38	0.19	0.50
871-59-3	0.59	0.28	0.16	0.43
875-100-3	0.59	0.21	0.16	0.43
875-105-3	0.59	0.28	0.16	0.43
875-91-3	0.59	0.28	0.16	0.43
875-92-3	0.59	0.28	0.16	0.43
876-64-3	0.59	0.28	0.16	0.43
892-2-9	0.60	0.33	0.09	0.51
892-3-9	0.60	0.29	0.09	0.51
895-3-9	0.60	0.33	0.09	0.51
895-6-9	0.60	0.29	0.09	0.51
896-4-9	0.60	0.29	0.09	0.51

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KA-19-102	0.59	0.25	0.16	0.43
KA-19-143	0.59	0.31	0.16	0.43
KA-19-143-M06	0.59	0.31	0.16	0.43
KA-19-155	0.59	0.25	0.16	0.43
KA-19-162	0.59	0.31	0.16	0.43
KA-19-163	0.59	0.31	0.16	0.43
KA-19-193	0.60	0.25	0.16	0.43
KA-19-195-M06	0.69	0.38	0.19	0.50
KA-19-198-M06	0.59	0.31	0.16	0.43
KA-19-213	0.69	0.38	0.19	0.50
KA-19-213-M06	0.69	0.38	0.19	0.50
KA-19-216	0.59	0.25	0.16	0.43
KA-19-216-M06	0.59	0.25	0.16	0.43
KA-19-68	0.98	0.22	0.11	0.87
KA-19-83	0.59	0.31	0.16	0.43
KA-39-100-M06	0.69	0.38	0.19	0.50
KA-39-102-M06	0.59	0.31	0.16	0.43
KA-39-44	0.48	0.30	0.41	0.11
KA-39-82	0.59	0.31	0.16	0.43
KA-39-83	0.59	0.31	0.16	0.43
KA-39-85	0.59	0.31	0.16	0.43
KA-39-94-M06	0.59	0.31	0.16	0.43
KA-59-185	0.69	0.38	0.19	0.50
KA-59-185-MC7	0.69	0.38	0.19	0.50
KA-59-186	0.69	0.38	0.19	0.50
KA-59-187	0.69	0.38	0.19	0.50
KA-59-188	0.59	0.31	0.16	0.43
KA-59-189	0.59	0.31	0.16	0.43
KA-59-230	0.59	0.25	0.16	0.43
KA-59-236	0.59	0.25	0.16	0.43
KA-59-251	0.59	0.25	0.16	0.43
KA-59-260	0.59	0.41	0.28	0.38

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KA-59-277	0.59	0.31	0.16	0.43
KA-59-292	0.59	0.25	0.16	0.43
KA-59-304	0.59	0.31	0.16	0.43
KA-59-313	0.59	0.31	0.16	0.43
KA-59-316	0.69	0.38	0.19	0.50
KA-59-317	0.69	0.38	0.19	0.50
KA-59-324	0.69	0.38	0.19	0.50
KA-59-353-M06	0.69	0.38	0.19	0.50
KA-59-391-M06	0.69	0.38	0.19	0.50
KA-59-392-M06	0.59	0.31	0.16	0.43
KA-59-393-M06	0.59	0.31	0.16	0.43
KA-59-437-M06	0.59	0.31	0.16	0.43
KA-59-438-M06	0.59	0.31	0.16	0.43
KA-59-439-M06	0.59	0.28	0.16	0.43
KA-59-57	0.62	0.40	0.11	0.47
KC-19-121	0.58	0.39	0.11	0.47
KC-19-122	0.58	0.39	0.11	0.47
KC-19-129	0.59	0.41	0.16	0.47
KC-19-129-M06	0.59	0.41	0.16	0.47
KC-19-161	0.77	0.22	0.25	0.51
KC-19-169	0.59	0.31	0.16	0.43
KC-19-170	0.59	0.31	0.16	0.43
KC-19-177	0.64	0.42	0.19	0.46
KC-19-177-M06	0.64	0.42	0.19	0.46
KC-19-226	0.64	0.36	0.19	0.46
KC-19-254	0.59	0.31	0.16	0.43
KC-19-255	0.59	0.31	0.16	0.43
KC-19-256	0.59	0.31	0.16	0.43
KC-19-261	0.59	0.31	0.19	0.40
KC-19-262	0.59	0.31	0.16	0.43
KC-19-307-M06	0.59	0.31	0.16	0.43
KC-19-308-M06	0.59	0.31	0.16	0.43

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KC-19-327-M06	0.59	0.31	0.16	0.43
KC-19-328-M06	0.59	0.31	0.16	0.43
KC-19-329-M06	0.59	0.31	0.16	0.43
KC-39-108	0.59	0.31	0.16	0.43
KC-39-109	0.59	0.31	0.19	0.40
KC-39-110	0.59	0.31	0.16	0.43
KC-39-111	0.59	0.31	0.16	0.43
KC-39-140-M06	0.59	0.31	0.16	0.43
KC-39-142-M06	0.59	0.31	0.16	0.43
KC-39-29	0.62	0.40	0.11	0.47
KC-39-36	0.48	0.30	0.41	0.11
KC-39-45	0.62	0.40	0.11	0.47
KC-39-81	0.59	0.31	0.16	0.43
KC-59-104	0.62	0.40	0.11	0.47
KC-59-128	0.62	0.40	0.11	0.47
KC-59-152	0.28	0.00	0.19	0.09
KC-59-218	0.62	0.40	0.11	0.47
KC-59-259	0.59	0.31	0.16	0.43
KC-59-261	0.59	0.31	0.16	0.43
KC-59-262	0.59	0.31	0.16	0.43
KC-59-263	0.59	0.31	0.16	0.43
KC-59-265	0.59	0.31	0.16	0.43
KC-59-267	0.59	0.31	0.16	0.43
KC-59-281	0.59	0.41	0.22	0.38
KC-59-287	0.59	0.41	0.22	0.38
KC-59-291	0.58	0.39	0.47	0.11
KC-59-383	0.59	0.31	0.16	0.43
KC-59-411	0.59	0.31	0.16	0.43
KC-59-425-M06	0.59	0.25	0.16	0.43
KC-59-444	0.59	0.31	0.19	0.40
KC-59-445	0.69	0.38	0.19	0.50
KC-59-446	0.59	0.31	0.16	0.43

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KC-59-447	0.59	0.31	0.16	0.43
KC-59-448	0.59	0.31	0.16	0.43
KC-59-557-M06	0.56	0.31	0.13	0.44
KC-59-585-M06	0.59	0.41	0.22	0.38
KC-59-604-M06	0.59	0.31	0.16	0.43
KC-59-605-M06	0.59	0.31	0.16	0.43
KC-59-609	0.69	0.38	0.19	0.50
KC-59-609-M06	0.69	0.38	0.19	0.50
KC-59-660-M06	0.59	0.41	0.22	0.38
KC-59-669-M06	0.59	0.31	0.16	0.43
KD-19-104	0.65	0.22	0.16	0.49
KD-19-104-M06	0.69	0.38	0.19	0.50
KD-19-105-M06	0.69	0.38	0.19	0.50
KD-19-107-M06	0.59	0.31	0.16	0.43
KD-19-55	0.69	0.41	0.19	0.50
KD-19-66	0.69	0.38	0.19	0.50
KD-19-67	0.69	0.41	0.19	0.50
KD-19-68	0.69	0.41	0.19	0.50
KD-19-69	0.69	0.41	0.19	0.50
KD-19-90	0.69	0.28	0.19	0.50
KD-19-94	0.69	0.38	0.19	0.50
KD-19-95	0.69	0.41	0.19	0.50
KD-39-27	0.69	0.38	0.19	0.50
KD-39-28	0.69	0.41	0.19	0.50
KD-39-37	0.69	0.38	0.19	0.50
KD-39-42	0.69	0.38	0.19	0.50
KD-59-110	0.69	0.38	0.19	0.50
KD-59-120	0.69	0.38	0.19	0.50
KD-59-125	0.69	0.41	0.19	0.50
KD-59-126	0.69	0.41	0.19	0.50
KD-59-128	0.66	0.44	0.16	0.49
KD-59-129	0.69	0.41	0.19	0.50

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KD-59-161	0.69	0.41	0.19	0.50
KD-59-163	0.69	0.38	0.19	0.50
KD-59-164	0.69	0.38	0.19	0.50
KD-59-165	0.99	0.67	0.19	0.80
KD-59-166	0.59	0.31	0.16	0.43
KD-59-180-M06	0.69	0.38	0.19	0.50
KD-59-184-M06	0.59	0.31	0.16	0.43
KD-59-185	0.59	0.31	0.16	0.43
KD-59-185-M06	0.59	0.31	0.16	0.43
KD-59-186	0.69	0.31	0.19	0.50
KD-59-186-M06	0.69	0.38	0.19	0.50
KD-59-187-M06	0.69	0.31	0.19	0.50
KD-59-193-M06	0.69	0.38	0.19	0.50
KD-59-199-M06	0.69	0.41	0.19	0.50
KD-59-201	0.69	0.41	0.19	0.50
KD-59-201-M06	0.69	0.41	0.19	0.50
KD-59-202	0.69	0.41	0.19	0.50
KD-59-202-M06	0.69	0.41	0.19	0.50
KD-59-52	0.53	0.19	0.16	0.38
KD-59-58	0.53	0.31	0.16	0.38
KD-59-63	0.66	0.44	0.49	0.16
KD-59-64	0.66	0.22	0.50	0.16
KG-19-15-M06	0.69	0.38	0.19	0.50
KG-59-28	0.69	0.38	0.19	0.50
KG-59-31-M06	0.69	0.41	0.19	0.50
KG-59-32-M06	0.69	0.41	0.19	0.50
KG-59-33-M06	0.69	0.41	0.19	0.50
KG-59-34-M06	0.69	0.38	0.19	0.50
KH-19-18	0.94	0.63	0.19	0.75
KH-39-21	0.94	0.63	0.19	0.75
KH-39-22	0.94	0.63	0.19	0.75
KH-39-25-M06	0.89	0.58	0.19	0.70

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KH-59-102-M06	0.94	0.63	0.19	0.75
KH-59-103-M06	0.94	0.63	0.19	0.75
KH-59-104-M06	0.94	0.63	0.19	0.75
KH-59-63	0.94	0.63	0.19	0.75
KH-59-64	0.94	0.63	0.19	0.75
KH-59-65	0.94	0.63	0.19	0.75
KH-59-66	0.94	0.63	0.19	0.75
KH-59-69	0.78	0.22	0.16	0.12
KH-59-99-M06	0.59	0.31	0.16	0.43
KM-19-08	0.49	0.30	0.08	0.41
KM-39-07	0.81	0.59	0.09	0.71
KM-59-18	0.45	0.27	0.08	0.38
KM-59-31	0.45	0.27	0.08	0.38
KM-59-36	0.72	0.50	0.14	0.58
KM-59-41	0.55	0.34	0.09	0.46
KN-19-115	0.69	0.41	0.19	0.50
KN-19-117	0.69	0.41	0.19	0.50
KN-19-118	0.69	0.38	0.19	0.50
KN-19-125	0.69	0.34	0.19	0.50
KN-19-145	0.69	0.28	0.19	0.50
KN-19-149	0.69	0.28	0.19	0.50
KN-19-151	0.69	0.34	0.19	0.50
KN-19-162	0.69	0.38	0.19	0.50
KN-19-195-M06	0.69	0.38	0.19	0.50
KN-19-196-M06	0.69	0.38	0.19	0.50
KN-19-198-M06	0.69	0.38	0.19	0.50
KN-19-199-M06	0.59	0.31	0.16	0.43
KN-19-205-M06	0.69	0.41	0.19	0.50
KN-19-206-M06	0.72	0.50	0.14	0.58
KN-19-207-M06	0.69	0.41	0.19	0.50
KN-19-208-M06	0.69	0.38	0.19	0.50
KN-19-209-M06	0.72	0.50	0.14	0.58

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KN-19-331-M06	0.59	0.31	0.16	0.13
KN-39-114-M06	0.69	0.38	0.19	0.50
KN-39-121-M06	0.72	0.50	0.14	0.58
KN-39-122-M06	0.72	0.50	0.14	0.58
KN-39-71	0.69	0.41	0.19	0.50
KN-39-72	0.69	0.41	0.19	0.50
KN-39-73	0.72	0.50	0.14	0.58
KN-39-87	0.69	0.41	0.19	0.50
KN-39-93	0.69	0.38	0.19	0.50
KN-59-120	0.69	0.50	0.16	0.53
KN-59-159	0.69	0.50	0.16	0.53
KN-59-183	0.69	0.34	0.19	0.50
KN-59-183-M06	0.69	0.35	0.19	0.50
KN-59-185	0.69	0.41	0.19	0.50
KN-59-186	0.69	0.41	0.19	0.50
KN-59-190	0.72	0.44	0.22	0.50
KN-59-201-M06	0.69	0.41	0.19	0.50
KN-59-220	0.69	0.38	0.19	0.50
KN-59-220-M07	0.72	0.50	0.14	0.58
KN-59-239	0.69	0.28	0.19	0.50
KN-59-242-M06	0.69	0.34	0.19	0.50
KN-59-247	0.69	0.47	0.19	0.50
KN-59-261	0.69	0.38	0.19	0.50
KN-59-262	0.69	0.38	0.19	0.50
KN-59-263	0.69	0.38	0.19	0.50
KN-59-264	0.69	0.38	0.19	0.50
KN-59-264-M06	0.69	0.38	0.19	0.50
KN-59-313-M06	0.69	0.34	0.19	0.50
KN-59-329-M06	0.69	0.38	0.19	0.50
KN-59-330-M06	0.69	0.38	0.19	0.50
KN-59-331-M06	0.59	0.31	0.16	0.43
KN-59-332-M06	0.69	0.38	0.19	0.50

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 11 CABLE PREPARATION DIMENSIONS (Continued)

Connector Part Number	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KN-59-361-M06	0.72	0.50	0.14	0.58
KN-59-367-M06	0.72	0.50	0.14	0.58
KN-59-368-M06	0.72	0.50	0.14	0.58
KN-59-369-M06	0.69	0.41	0.19	0.50
KS-89-108	1.31	1.03	0.00	0.50
KS-89-164	1.31	1.03	0.00	0.50
KS-89-55	0.90	0.30	0.40	0.50
KU-59-03	1.19	1.00	0.63	0.56

B. Heat Shrinkable Sleeve Configurations

Table 12
HEAT SHRINKABLE SLEEVES FOR SPECIFIED COAX CONNECTORS AND COAX CABLES

Connector	Coax Cable	Heat Shrinkable Sleeve			
		Layer	Diameter (inch)	Length (inch)	
				Target	Tolerance
125-88-9	BMS13-65 Type 0F	First	3/16	3.60	±0.06
		Second	1/4	4.20	±0.06
		Third	3/8	4.30	±0.06
	S280W503-2	First	3/16	3.60	±0.06
		Second	1/4	4.20	±0.06
		Third	3/8	4.30	±0.06
125-91-9	BMS13-65 Type 0H	First	1/4	3.10	±0.06
		Second	3/8	3.70	±0.06
		Third	1/2	3.80	±0.06
		Fourth	3/4	4.30	±0.06
	S280W503-4	First	1/4	3.10	±0.06
		Second	3/8	3.70	±0.06
		Third	1/2	3.80	±0.06
		Fourth	3/4	4.30	±0.06

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 12 HEAT SHRINKABLE SLEEVES FOR SPECIFIED COAX CONNECTORS AND COAX CABLES
(Continued)

Connector	Coax Cable	Heat Shrinkable Sleeve			
		Layer	Diameter (inch)	Length (inch)	
				Target	Tolerance
125-95-9	BMS13-65 Type 0G	First	3/16	3.70	±0.06
		Second	1/4	4.20	±0.06
		Third	3/8	4.40	±0.06
	S280W503-3	First	3/16	3.70	±0.06
		Second	1/4	4.20	±0.06
		Third	3/8	4.40	±0.06
126-58-9	BMS13-65 Type 0F	First	3/16	2.90	±0.06
		Second	1/4	3.50	±0.06
		Third	3/8	4.30	±0.06
	S280W503-2	First	3/16	2.90	±0.06
		Second	1/4	3.50	±0.06
		Third	3/8	4.30	±0.06
126-71-9	BMS13-65 Type 0G	First	3/16	2.90	±0.06
		Second	1/4	3.50	±0.06
		Third	3/8	4.30	±0.06
	S280W503-3	First	3/16	2.90	±0.06
		Second	1/4	3.50	±0.06
		Third	3/8	4.30	±0.06
126-85-9	BMS13-65 Type OH	First	1/4	2.00	±0.06
		Second	3/8	1.75	±0.06
		Third	3/8	1.50	±0.06
		Fourth	1/2	1.25	±0.06
2430-2-16	BMS13-65 Type 0G	First	1/4	2.00	±0.06
		Second	3/8	1.75	±0.06
		Third	3/8	1.50	±0.06
		Fourth	1/2	1.25	±0.06

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 12 HEAT SHRINKABLE SLEEVES FOR SPECIFIED COAX CONNECTORS AND COAX CABLES
(Continued)

Connector	Coax Cable	Heat Shrinkable Sleeve			
		Layer	Diameter (inch)	Length (inch)	
				Target	Tolerance
2985-3-()	BMS13-65 Type 0F	First	3/16	3.30	±0.06
		Second	1/4	4.00	±0.06
		Third	1/4	3.90	±0.06
		Fourth	3/8	3.90	±0.06
		Fifth	1/2	4.30	±0.06
	S280W503-2	First	3/16	3.30	±0.06
		Second	1/4	4.00	±0.06
		Third	1/4	3.90	±0.06
		Fourth	3/8	3.90	±0.06
		Fifth	1/2	4.30	±0.06
796-17-9	BMS13-65 Type 0G	First	1/4	2.00	±0.06
		Second	3/8	1.75	±0.06
		Third	3/8	1.50	±0.06
		Fourth	1/2	1.25	±0.06
KA-59-438-M06	RG-223	First	3/16	3.70	±0.06
		Second	1/4	4.20	±0.06
		Third	3/8	4.40	±0.06
KA-59-439-M06	72016	First	3/16	2.90	±0.06
		Second	1/4	3.50	±0.06
		Third	3/8	4.30	±0.06

C. Cable Preparation

For the general conditions that are applicable for the preparation of coax cable, refer to Subject 20-51-00.

- (1) Make a selection of a heat shrinkable sleeve from Table 4.
- (2) Put the specified number of heat shrinkable sleeves on the cable. Refer to Table 12.
- (3) If the connector and coax cable are not specified in Table 12, put a 1.5 inch length of heat shrinkable sleeve on the cable.

Make sure that the sleeve has the smallest diameter that can be moved easily on the cable.

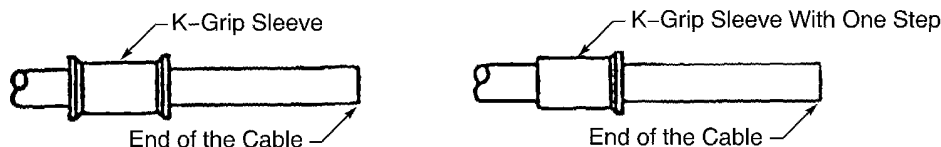
- (4) Cut the end of the cable to make it perpendicular to the longitudinal axis of the cable.
- (5) Put the K-Grip sleeve on the cable. Refer to Figure 4.

If the K-Grip sleeve has one step, make sure that the end with the step is pointed forward to the end of the cable.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



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POSITION OF THE K-GRIP SLEEVE

Figure 4

- (6) If the cable dielectric is a metal, semi-rigid material, prepare the cable without trim jigs. Refer to Paragraph 5.A.
- (7) If the cable dielectric is not a metal, semi-rigid material:
 - (a) Make a selection of a cable jacket trim jig and a dielectric trim jig from Table 5.

NOTE: Preparation of the cable without a trim jig is a satisfactory alternative. Refer to Paragraph 5.A.

NOTE: If trim jigs are not specified for the connector, the cable must be prepared without trim jigs. Refer to Paragraph 5.A.
 - (b) Prepare the cable with the trim jigs.

To prepare the cable with:

 - A cable jacket trim jig with two slots, refer to Paragraph 5.B.
 - A cable jacket trim jig with three slots, refer to Paragraph 5.C.

D. Center Contact Assembly - Crimp Type Contacts

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Find the center contact tool code. Refer to Table 7.
- (2) Make a selection of a contact crimp tool from Table 8.

Make sure that the tool is applicable for the tool code.
- (3) Put the conductor in the crimp barrel of the center contact. Refer to Figure 5.

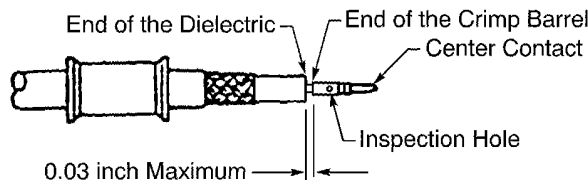
Make sure that:

 - All of the strands of the conductor are in the crimp barrel of the contact
 - The conductor can be seen in the inspection hole of the contact
 - The distance from the end of the dielectric to the rear end of the crimp barrel is not more than 0.03 inch.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



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POSITION OF THE CENTER CONTACT ON THE CONDUCTOR

Figure 5

- (4) Crimp the contact.
Make sure that the crimp is between the inspection hole and the rear end of the crimp barrel.
- (5) Examine the contact assembly for these types of damage:
 - The finish has damage
 - The crimp barrel of the contact has a crack.

NOTE: If the contact has damage, it must be replaced.

E. Center Contact Assembly - Solder Type Contacts

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Make a selection of a Temperature Grade C solder. Refer to Subject 20-00-11.

CAUTION: DO NOT USE A TEMPERATURE GRADE D SOLDER. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CABLE CAN OCCUR.

- (2) Put the conductor in the solder barrel of the contact. Refer to Figure 6.

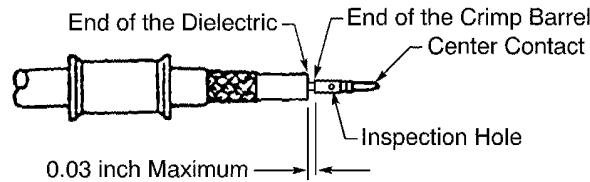
Make sure that:

- All of the strands of the conductor are in the solder barrel of the contact
- The conductor can be seen in the inspection hole of the contact
- The distance from the end of the dielectric to the rear end of the solder barrel is not more than 0.03 inch.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



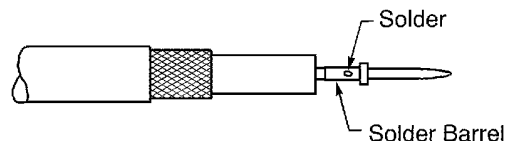
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POSITION OF THE CENTER CONTACT ON THE CONDUCTOR

Figure 6

- (3) Apply a small quantity of solder in the inspection hole of the contact. Refer to Figure 7.

CAUTION: DO NOT APPLY TOO MUCH HEAT TO THE CONTACT. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CONTACT, THE CONNECTOR OR THE CABLE CAN OCCUR.



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SOLDER CONTACT ASSEMBLY

Figure 7

- (4) Remove all of the solder and the flux from the outer surface of the contact.
(5) Examine the contact for damage to the finish.

NOTE: If the contact has damage, the contact must be replaced.

- (6) If a solder access cover is supplied with the contact, install the cover.

F. Connector Shell Installation

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

- (1) Find the K-Grip sleeve tool code. Refer to Table 7.
(2) Make a selection of the K-Grip sleeve crimp tool from Table 9.
Make sure that the tool is applicable for the tool code.
(3) Move the strands of the shield apart.
(4) Put the connector shell on the end of the cable. Refer to Figure 8.

20-51-15



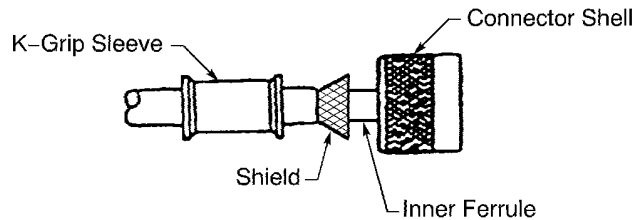
707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Make sure that:

- If the cable has one shield, the inner ferrule is between the dielectric and the shield
- If the cable has an inner shield and an outer shield, the inner ferrule is between the inner shield and the outer shield
- If the cable has an inner shield and an outer shield, no strands of the outer shield are between the inner ferrule and the dielectric.



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POSITION OF THE CONNECTOR SHELL ON THE CABLE

Figure 8

- (5) If the inner ferrule does not move on the inner shield, cut the inner shield back until the ferrule can move on the shield.
- (6) Push the connector shell rearward until the center contact is fully installed in the shell.

Refer to:

- Figure 9 for the position of the connector shell on the cable
- Figure 10 for the position of the socket contact in the plug connector
- Figure 11 for the position of the pin contact in the jack connector.

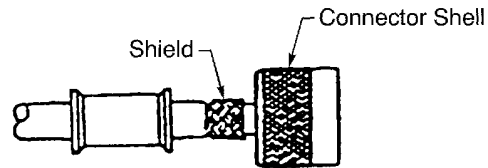
Make sure that:

- The distance the forward end of the socket contact extends out from the end of the insulator is not more than 0.02 inch
- The distance from the forward end of the socket contact to the end of the insulator is not more than 0.02 inch
- The distance from the forward end of the pin contact to the end of the insulator is not more than 0.04 inch.

20-51-15

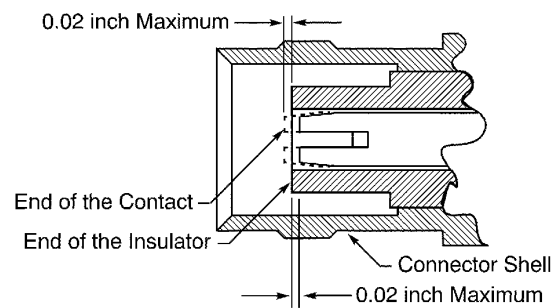


707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



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POSITION OF THE CONNECTOR SHELL ON THE CABLE
Figure 9



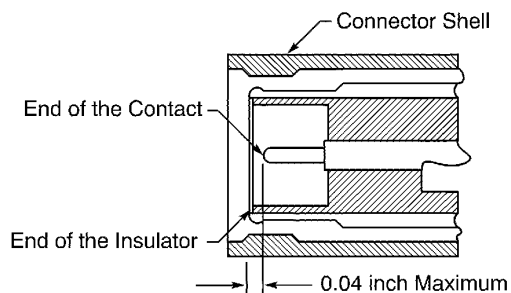
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POSITION OF THE SOCKET CONTACT IN THE JACK CONNECTOR
Figure 10

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



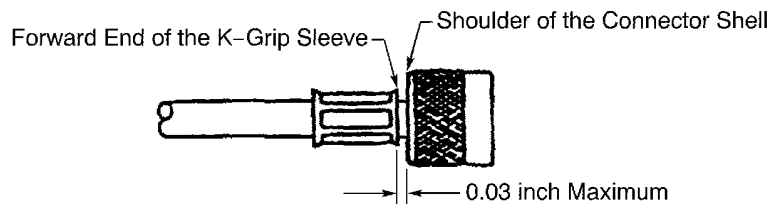
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POSITION OF THE PIN CONTACT IN THE PLUG CONNECTOR

Figure 11

- (7) Hold the connector shell and lightly pull the cable to make sure that the contact is locked in the connector.
- (8) Push the K-Grip sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.
- (9) Crimp the K-Grip sleeve. Refer to Figure 12.

Make sure that the distance from the forward end of the K-Grip sleeve to the shoulder of the connector shell is not more than 0.03 inch.



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POSITION OF THE K-GRIP SLEEVE

Figure 12

- (10) Examine the K-Grip sleeve.
Make sure that:
 - The dimples on each side of the crimp area do not have cracks

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

- The base metal of the sleeve in the crimp area cannot be seen.

G. Insulation Installation

If the connector and the coax cable are not specified in Table 13, refer to Paragraph 6.A. for the standard insulation configuration.

Table 13
SELECTION OF A HEAT SHRINKABLE SLEEVE INSTALLATION PROCEDURE

Connector	Coax Cable	Installation Procedure
125-88-9	BMS13-65 Type 0F	Paragraph 6.B.
	S280W503-2	Paragraph 6.B.
125-91-9	BMS13-65 Type 0H	Paragraph 6.C.
	S280W503-4	Paragraph 6.C.
125-95-9	BMS13-65 Type 0G	Paragraph 6.B.
	S280W503-3	Paragraph 6.B.
126-58-9	BMS13-65 Type 0F	Paragraph 6.D.
	S280W503-2	Paragraph 6.D.
126-71-9	BMS13-65 Type 0G	Paragraph 6.D.
	S280W503-3	Paragraph 6.D.
2430-2-16	BMS13-65 Type 0G	Paragraph 6.F.
2985-3-()	BMS13-65 Type 0F	Paragraph 6.E.
	S280W503-2	Paragraph 6.E.
796-17-9	BMS13-65 Type 0G	Paragraph 6.F.
KA-59-438-M06	RG-223	Paragraph 6.B.
KA-59-439-M06	72016	Paragraph 6.D.

4. CONNECTOR ASSEMBLY - RIGHT ANGLE CONNECTORS WITH SOLDER TYPE CONTACTS

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

A. Cable Preparation Dimensions

Table 14
CABLE PREPARATION DIMENSIONS

Connector	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KA-59-73	0.58	0.39	0.11	0.47
KC-59-222	0.62	0.40	0.11	0.47

20-51-15

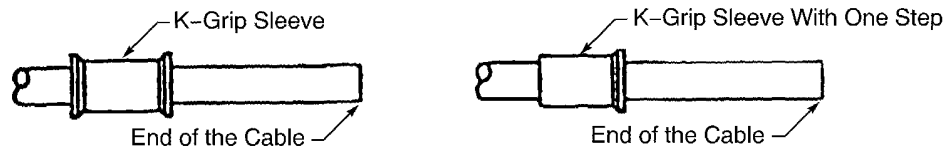
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STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 14 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Length Dimension (inch) (Refer to Figure 3)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
KM-59-20	0.61	0.42	0.08	0.54

B. Cable Preparation

- (1) Make a selection of a heat shrinkable sleeve from Table 4.
- (2) Put a 1.5 inch length of heat shrinkable sleeve on the cable.
Make sure the sleeve has the smallest diameter that can be moved easily on the cable.
- (3) Cut the end of the cable to make it perpendicular to the longitudinal axis of the cable.
- (4) Put the K-Grip sleeve on the cable. Refer to Figure 13.
If the K-Grip sleeve has one step, make sure that the end with the step is pointed forward to the end of the cable.



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POSITION OF THE K-GRIP SLEEVE

Figure 13

- (5) If the cable dielectric is a metal, semi-rigid material, prepare the cable without trim jigs. Refer to Paragraph 5.A.
- (6) If the cable dielectric is not a metal, semi-rigid material:
 - (a) Make a selection of a cable jacket trim jig and a dielectric trim jig from Table 5.
NOTE: Preparation of the cable without a trim jig is a satisfactory alternative. Refer to Paragraph 5.A.
NOTE: If trim jigs are not specified for the connector, the cable must be prepared without trim jigs. Refer to Paragraph 5.A.
 - (b) Prepare the cable with the trim jigs.
To prepare the cable with:
 - A cable jacket trim jig with two slots, refer to Paragraph 5.B.
 - A cable jacket trim jig with three slots, refer to Paragraph 5.C.

20-51-15

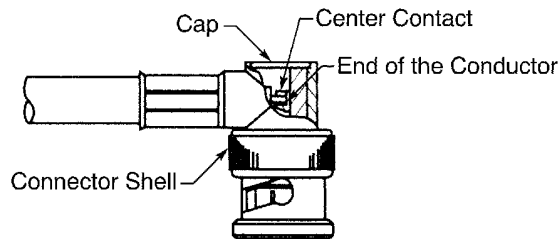


707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

C. Connector Shell Installation



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CONNECTOR SHELL INSTALLATION

Figure 14

Refer to Figure 14.

- (1) Make a selection of the K-Grip sleeve crimp tool from Table 9.

Make sure that the tool is applicable for the tool code.

- (2) Put the connector shell on the end of the cable.

Make sure that:

- If the cable has one shield, the inner ferrule is between the dielectric and the shield
- If the cable has an inner shield and an outer shield, the inner ferrule is between the inner shield and the outer shield
- If the cable has an inner shield and an outer shield, no strands of the outer shield are between the inner ferrule and the dielectric
- The end of the conductor is in the slot on the rear end of the contact.

- (3) If the inner ferrule does not move on the inner shield, cut the inner shield back until the ferrule can move on the shield.

- (4) Push the K-Grip sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.

- (5) Crimp the K-Grip sleeve.

Make sure that the distance between the forward end of the K-Grip sleeve and the shoulder of the connector shell is not more than 0.03 inch.

- (6) Examine the K-Grip sleeve.

Make sure that:

- The dimples on each side of the crimp area do not have cracks
- The base metal of the sleeve in the crimp area cannot be seen.

- (7) Install the heat shrinkable sleeve. Refer to Paragraph 6.A.

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

D. Center Contact Assembly

- (1) Make a selection of a Temperature Grade C solder. Refer to Subject 20-00-11.

CAUTION: DO NOT USE A TEMPERATURE GRADE D SOLDER. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CABLE CAN OCCUR.

- (2) Put the center conductor into the slot on the rear end of the center contact.
- (3) Apply a small quantity of solder to the end of the conductor and the end of the contact.

CAUTION: DO NOT APPLY TOO MUCH HEAT TO THE CONTACT. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CONTACT, THE CONNECTOR OR THE CABLE CAN OCCUR.

- (4) Hold the connector shell and lightly pull the cable to make sure that the solder joint is satisfactory.
- (5) Put the access cap on the connector shell.
- (6) Apply a small amount of solder around the edge of the cap.

CAUTION: DO NOT APPLY TOO MUCH HEAT TO THE CAP. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CAP, THE CONNECTOR OR THE CABLE CAN OCCUR.

5. COAX CABLE PREPARATION

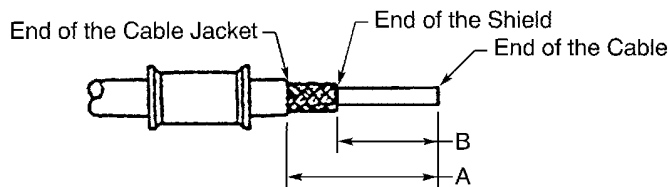
A. Cable Preparation - No Trim Jigs

NOTE: If the cable has two shields, the shields are prepared as one shield.

- (1) Remove the necessary length of the cable jacket to make the distance from the end of the cable jacket to the end of the cable equal to dimension A.

Refer to Figure 15 and Table 11.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



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CABLE JACKET REMOVAL

Figure 15

- (2) Remove the necessary length of shield to make the distance from the end of the cable jacket to the end of the shield equal to dimension B.

Refer to Figure 15 and Table 11.

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

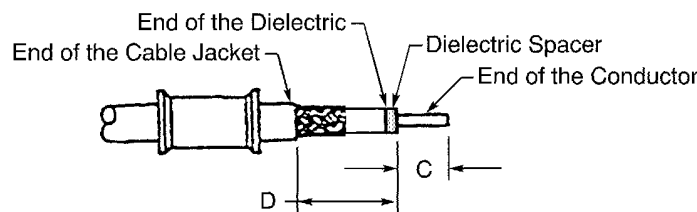
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

CAUTION: DO NOT CAUSE DAMAGE TO THE DIELECTRIC. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

- (3) For a cable dielectric that is a metal, semi-rigid material:
- (a) Remove the necessary length of the dielectric to make the distance from the end of the cable jacket to the end of the dielectric equal to dimension D minus the width of the dielectric spacer.

Refer to Figure 16 and Table 11.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



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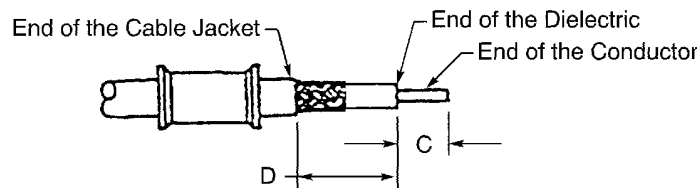
DIELECTRIC REMOVAL

Figure 16

- (b) Put the dielectric spacer on the end of the dielectric.
- (4) For a cable dielectric that is not a metal, semi-rigid material, remove the necessary length of the dielectric to make the distance from the end of the cable jacket to the end of the dielectric equal to dimension D.

Refer to Figure 17 and Table 11.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



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DIELECTRIC REMOVAL

Figure 17

- (5) Remove the necessary length of the conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C.

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Refer to Figure 17 and Table 11.

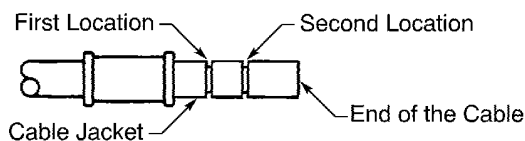
B. Cable Preparation - Cable Jacket Trim Jig with Two Slots

- (1) Put the trim jig on the end of the cable.

Make sure that the end of the trim jig is against the end of the cable.

- (2) Turn the cable in the jig, and at the same time, apply light pressure on the cable at the location of the blades. Refer to Figure 18.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

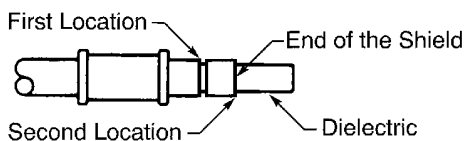


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LOCATIONS OF THE CUTS ON THE CABLE JACKET

Figure 18

- (3) Remove the length of the cable jacket from the second location to the end of the cable. Refer to Figure 19.



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CABLE JACKET REMOVAL

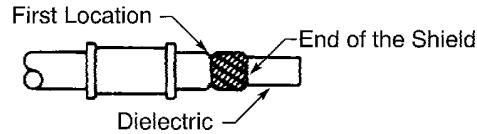
Figure 19

- (4) Remove the length of the shield from the second location to the end of the cable. Refer to Figure 19.
- (5) Remove the length of cable jacket from the first location to the end of the shield. Refer to Figure 20.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



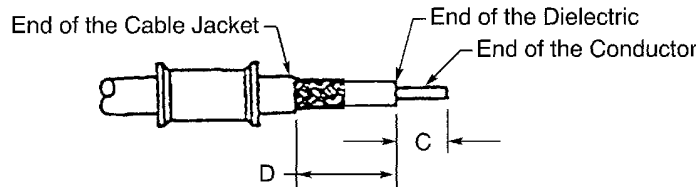
2445976 S00061546054_V1

REMAINING CABLE JACKET REMOVAL

Figure 20

- (6) Put the dielectric trim jig on the end of the cable.
- (7) Remove the length of the dielectric that extends farther than the end of the trim jig.
Make sure that the distance from the end of the cable jacket to the end of the dielectric is equal to dimension D. Refer to Figure 21 and Table 11.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2447574 S00061546051_V1

DIELECTRIC REMOVAL

Figure 21

- (8) Remove the necessary length of conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C. Refer to Figure 21 and Table 11.

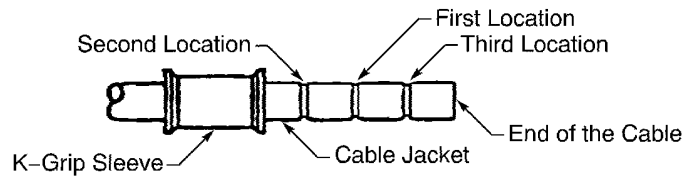
C. Cable Preparation - Cable Jacket Trim Jig with Three Slots

- (1) Put the trim jig on the end of the cable.
Make sure that the end of the trim jig is against the end of the cable.
- (2) Turn the cable in the jig, and at the same time, apply light pressure on the cable at the area of the blades. Refer to Figure 22.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



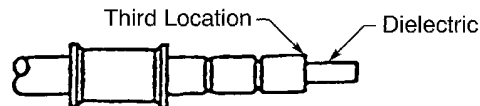
2445967 S00061546055_V1

LOCATION OF THE CUTS ON THE CABLE

Figure 22

CAUTION: DO NOT CAUSE DAMAGE TO THE INNER SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

- (3) Remove the length of the cable jacket from the third location to the end of the cable. Refer to Figure 23.



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CABLE JACKET REMOVAL

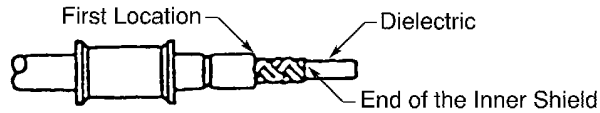
Figure 23

- (4) Remove the length of the outer and inner shields from the third location to the end of the cable. Refer to Figure 23.
- (5) Remove the length of the jacket from the first location to the end of the inner shield. Refer to Figure 24.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



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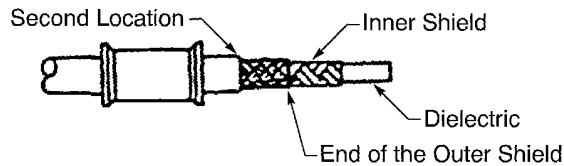
CABLE JACKET REMOVAL

Figure 24

- (6) Remove the length of the outer shield from the first location to the end of the cable. Refer to Figure 24.

CAUTION: DO NOT CAUSE DAMAGE TO THE INNER SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

- (7) Remove the cable jacket from the second location to the end of the outer shield. Refer to Figure 25.



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REMAINING CABLE JACKET REMOVAL

Figure 25

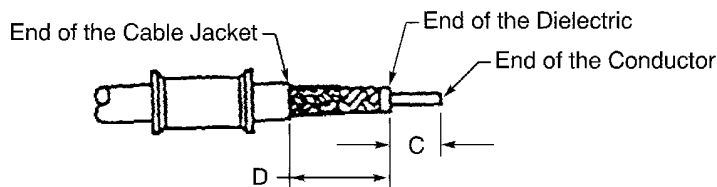
- (8) Put the dielectric trim jig on the end of the cable.
- (9) Remove the length of the dielectric that extends farther than the end of the trim jig. Make sure that the distance from the end of the cable jacket to the end of the dielectric is equal to dimension D. Refer to Figure 26 and Table 11.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



2445971 S00061546060_V1

DIELECTRIC REMOVAL

Figure 26

- (10) Remove the necessary length of conductor to make the distance from the end of the dielectric to the end of the conductor equal to dimension C. Refer to Figure 26 and Table 11.

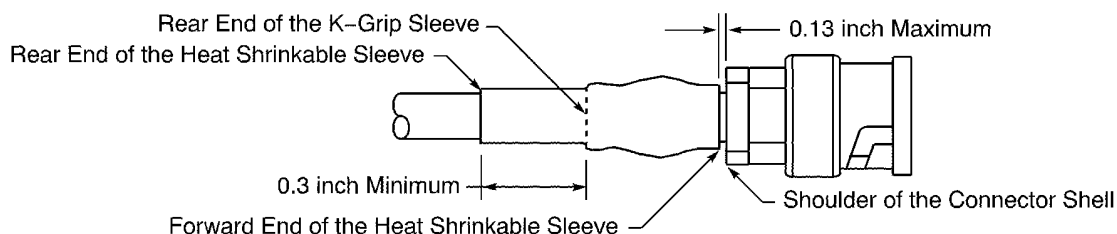
6. INSULATION INSTALLATION CONFIGURATIONS

A. Heat Shrinkable Sleeve - Standard Configuration

- (1) Push the sleeve forward until the end of the sleeve is against the shoulder of the connector shell. Refer to Figure 27.

Make sure that:

- The distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.13 inch
- The distance from the rear end of the K-Grip sleeve to the rear end of the sleeve is not less than 0.3 inch
- The sleeve does not make an interference with the installation of the connector.



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POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 27

- (2) Shrink the sleeve into its position. Refer to Subject 20-10-14.

20-51-15



707, 727-787

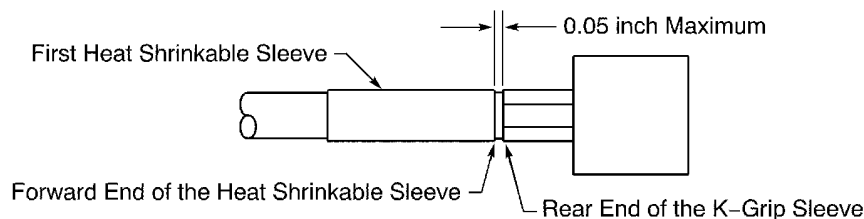
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

B. Heat Shrinkable Sleeves - 125-88-9, 125-95-9 and KA-59-438-M06 Connectors

- (1) Make a selection of a solvent from Table 4.
- (2) Clean these areas:
 - The K-Grip Sleeve
 - The area of the connector shell with ribs
 - 6 inches of the cable from the rear end of the K-Grip Sleeve.
- (3) Push the first sleeve forward until the forward end of the sleeve is against the rear end of the K-Grip sleeve. Refer to Figure 28.

Make sure that the distance from the forward end of the sleeve to the rear end of the K-Grip sleeve is not more than 0.05 inch.



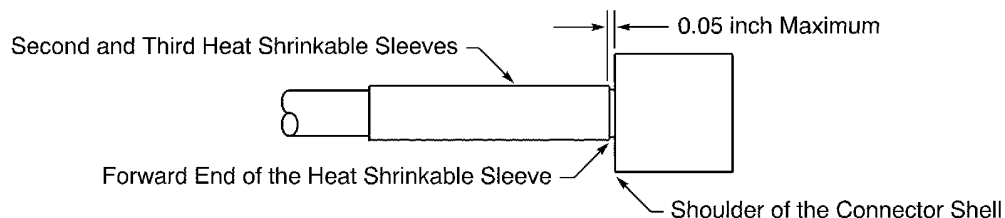
2447579 S00061546062_V1

POSITION OF THE FIRST HEAT SHRINKABLE SLEEVE

Figure 28

- (4) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (5) Push the second sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell. Refer to Figure 29.

Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.05 inch.



2447580 S00061546063_V1

POSITION OF THE SECOND AND THIRD HEAT SHRINKABLE SLEEVES

Figure 29

- (6) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (7) Push the third sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell. Refer to Figure 29.

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

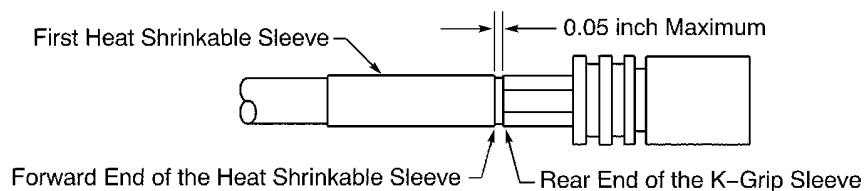
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.05 inch.

- (8) Shrink the sleeve into its position. Refer to Subject 20-10-14.

C. Heat Shrinkable Sleeves - 125-91-9 Connector

- (1) Make a selection of a solvent from Table 4.
- (2) Clean these areas:
 - The K-Grip Sleeve
 - The area of the connector shell with ribs
 - 6 inches of the cable from the rear end of the K-Grip Sleeve.
- (3) Push the first sleeve forward until the forward end of the sleeve is against the rear end of the K-Grip sleeve. Refer to Figure 30.

Make sure that the distance from the forward end of the sleeve to the rear end of the K-Grip sleeve is not more than 0.05 inch.



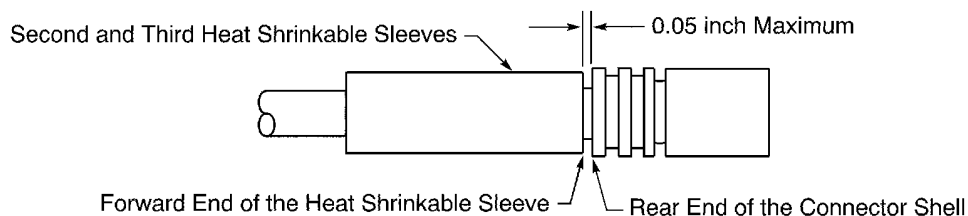
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POSITION OF THE FIRST HEAT SHRINKABLE SLEEVE

Figure 30

- (4) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (5) Push the second sleeve forward until the forward end of the sleeve is against the rear end of the connector shell. Refer to Figure 31.

Make sure that the distance from the forward end of the sleeve to the rear end of the connector shell is not more than 0.05 inch.



2447588 S00061546065_V1

POSITION OF THE SECOND AND THIRD HEAT SHRINKABLE SLEEVES

Figure 31

20-51-15

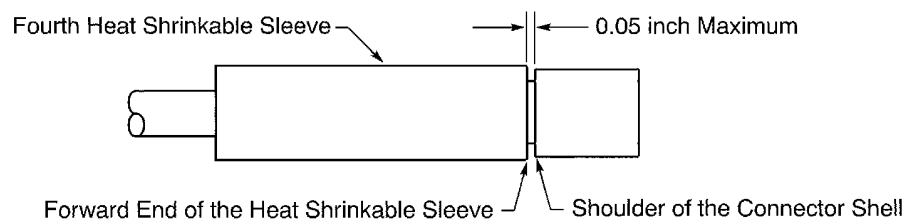


707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

- (6) Push the third sleeve forward until the forward end of the sleeve is against the rear end of the connector shell. Refer to Figure 31.
Make sure that the distance from the forward end of the sleeve to the rear end of the connector shell is not more than 0.05 inch.
- (7) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (8) Push the fourth sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell. Refer to Figure 32.
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.05 inch.



2447589 S00061546066_V1

POSITION OF THE HEAT SHRINKABLE SLEEVE

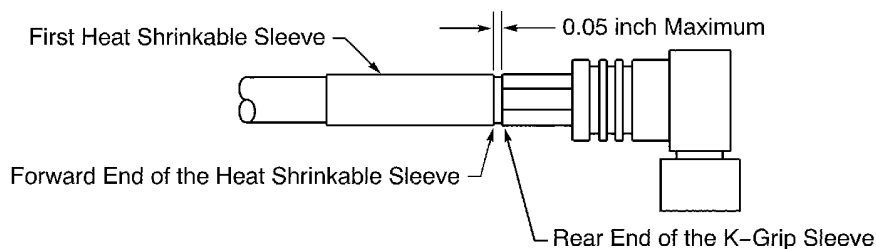
Figure 32

- (9) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- D. Heat Shrinkable Sleeves - 126-58-9, 126-71-9, 126-85-9 and KA-59-439-M06 Connectors**
- (1) Make a selection of a solvent from Table 4.
 - (2) Clean these areas:
 - The K-Grip Sleeve
 - The area of the connector shell with ribs
 - 6 inches of the cable from the rear end of the K-Grip Sleeve.
 - (3) Push the first sleeve forward until the forward end of the sleeve is against the rear end of the K-Grip sleeve. Refer to Figure 33.
Make sure that the distance from the forward end of the sleeve to the rear end of the K-Grip sleeve is not more than 0.05 inch.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



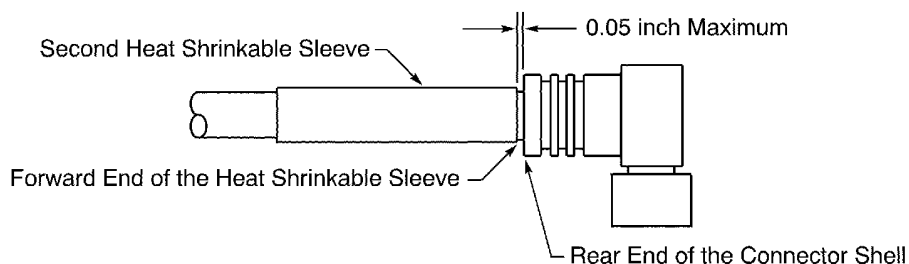
2447581 S00061546067_V1

POSITION OF THE FIRST HEAT SHRINKABLE SLEEVE

Figure 33

- (4) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (5) Push the second sleeve forward until the forward end of the sleeve against the rear end of the connector shell. Refer to Figure 34.

Make sure that the distance from the forward end of the sleeve to the rear end of the connector shell is not more than 0.05 inch.



2447582 S00061546068_V1

POSITION OF THE SECOND HEAT SHRINKABLE SLEEVE

Figure 34

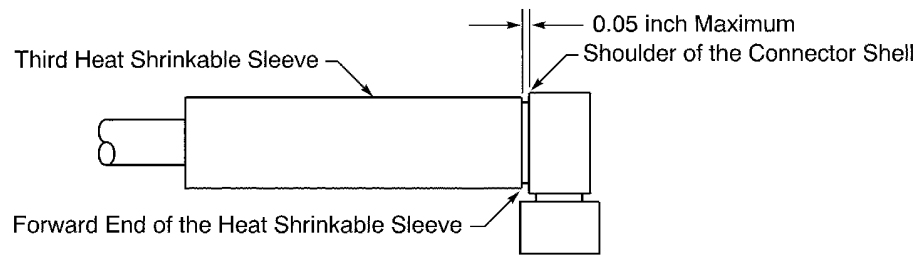
- (6) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (7) Push the third sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell. Refer to Figure 35.

Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.05 inch.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS



2447583 S00061546069_V1

POSITION OF THE THIRD HEAT SHRINKABLE SLEEVE

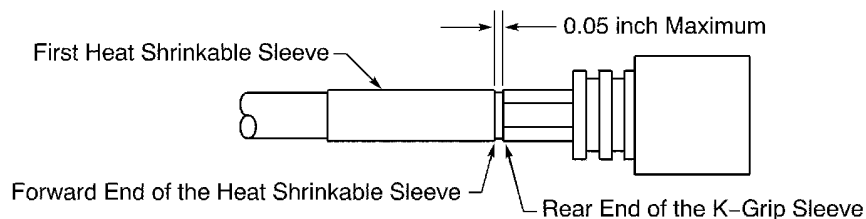
Figure 35

- (8) Shrink the sleeve into its position. Refer to Subject 20-10-14.

E. Heat Shrinkable Sleeves - 2985-3-() Connectors

- (1) Make a selection of a solvent from Table 4.
- (2) Clean these areas:
- The K-Grip Sleeve
 - The area of the connector shell with ribs
 - 6 inches of the cable from the rear end of the K-Grip Sleeve.
- (3) Push the first sleeve forward until the forward end of the sleeve is against the rear end of the K-Grip sleeve. Refer to Figure 36.

Make sure that the distance from the forward end of the sleeve to the rear end of the K-Grip sleeve is not more than 0.05 inch.



2447584 S00061546070_V1

POSITION OF THE FIRST HEAT SHRINKABLE SLEEVE

Figure 36

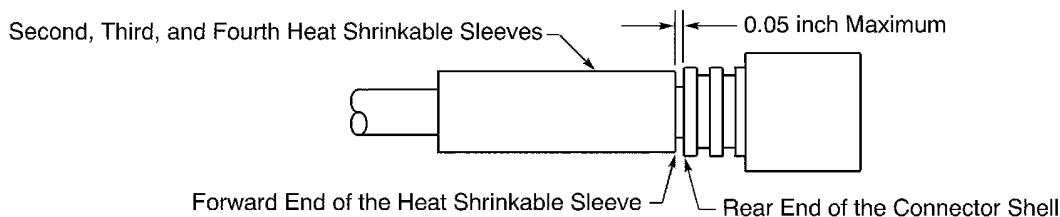
- (4) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (5) Push the second sleeve forward until the forward end of the sleeve against the rear end of the connector shell. Refer to Figure 37.

Make sure that the distance from the forward end of the sleeve to the rear end of the connector shell is not more than 0.05 inch.

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

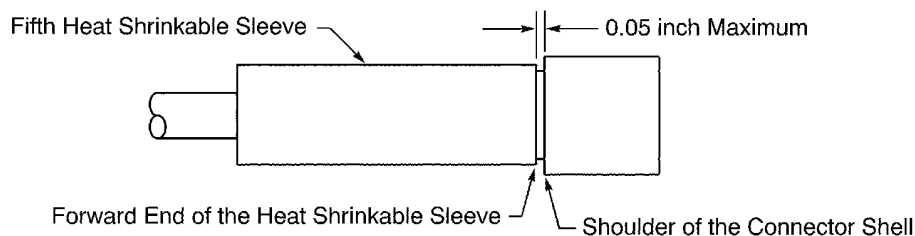


2447585 S00061546071_V1

POSITION OF THE SECOND, THIRD AND FOURTH HEAT SHRINKABLE SLEEVES

Figure 37

- (6) Push the third sleeve forward until the forward end of the sleeve is against the rear end of the connector shell. Refer to Figure 37.
Make sure that the distance from the forward end of the sleeve to the rear end of the connector shell is not more than 0.05 inch.
- (7) Push the fourth sleeve forward until the forward end of the sleeve is against the rear end of the connector shell. Refer to Figure 37.
Make sure that the distance from the forward end of the sleeve to the rear end of the connector shell is not more than 0.05 inch.
- (8) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (9) Push the fifth sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell. Refer to Figure 38.
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.05 inch.



2447586 S00061546072_V1

POSITION OF THE FIFTH HEAT SHRINKABLE SLEEVE

Figure 38

- (10) Shrink the sleeve into its position. Refer to Subject 20-10-14.

20-51-15

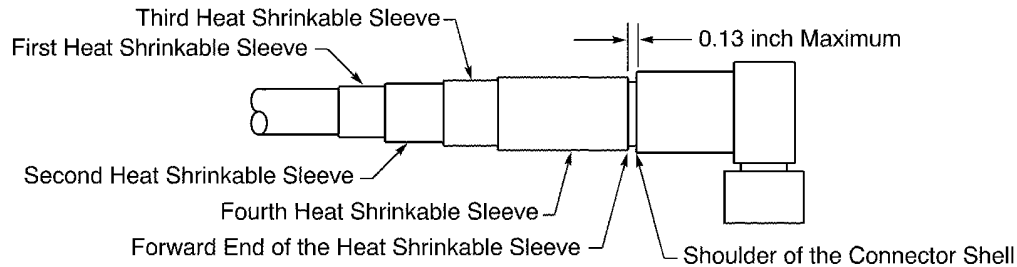


707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

F. Heat Shrinkable Sleeves - 2430-2-16 and 796-17-9 Connectors



2447677 S00061546073_V1

POSITION OF THE HEAT SHRINKABLE SLEEVES

Figure 39

Refer to Figure 39.

- (1) Push the first sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.13 inch.
- (2) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (3) Push the second sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.13 inch.
- (4) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (5) Push the third sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.13 inch.
- (6) Shrink the sleeve into its position. Refer to Subject 20-10-14.
- (7) Push the fourth sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.
Make sure that the distance from the forward end of the sleeve to the shoulder of the connector shell is not more than 0.13 inch.

7. CONNECTOR INSTALLATION

A. Connection of N, TNC, and SC Series Plugs and Jacks

Table 15
CONNECTOR INSTALLATION TOOLS

Tool	Part Number	Supplier
Torque Wrench	-	Any source

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 15 CONNECTOR INSTALLATION TOOLS (Continued)

Tool	Part Number	Supplier
Wrench	76-101	Balmar
	ST2580-570	Boeing
	TG-70	Glenair

Table 16
PLUG CONNECTOR TORQUE VALUES

Connector	Torque Value (inch-pounds)	
	Minimum	Maximum
1201-()-()	6	10
1203-()-()	6	10
1205-()-()	6	10
1206-()-()	6	10
121-()-()	8	12
122-()-()	8	12
123-()-()	8	12
125-()-()	8	12
126-()-()	8	12
2435-()-()	8	12
2975-()-()	6	10
2985-()-()	6	10
821-()-()	6	10
825-()-()	6	10
BACC64BT	15	17
BACC64BW	15	17
KA-59-353-M06	8	12

- (1) Make a selection of a torque wrench from Table 15.
- (2) Make a selection of a wrench from Table 15.
- (3) Fully engage the threads of the plug and the jack.
- (4) Tighten the plug to the specified torque value. Refer to Table 16.

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

8. APPROVED TOOL SUPPLIERS

A. Coax Cable Trim Jig Tools

Table 17
TRIM JIG TOOL SUPPLIERS

Trim Jig	Supplier
KTB-10	Kings Electronics
KTB-2	Kings Electronics
KTD-108	Kings Electronics
KTD-122	Kings Electronics
KTD-123	Kings Electronics
KTD-124	Kings Electronics
KTD-133	Kings Electronics
KTD-137	Kings Electronics
KTD-138	Kings Electronics
KTD-145	Kings Electronics
KTD-150	Kings Electronics
KTD-154	Kings Electronics
KTD-159	Kings Electronics
KTD-161	Kings Electronics
KTD-166	Kings Electronics
KTD-172	Kings Electronics
KTD-184	Kings Electronics
KTD-208	Kings Electronics
KTD-216	Kings Electronics
KTD-218	Kings Electronics
KTD-225	Kings Electronics
KTD-233	Kings Electronics
KTD-25	Kings Electronics
KTD-255	Kings Electronics
KTD-26	Kings Electronics
KTD-268	Kings Electronics
KTD-28	Kings Electronics
KTD-35	Kings Electronics
KTD-38	Kings Electronics
KTD-402	Kings Electronics
KTD-403	Kings Electronics
KTD-404	Kings Electronics

20-51-15



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR CONNECTORS

Table 17 TRIM JIG TOOL SUPPLIERS (Continued)

Trim Jig	Supplier
KTD-405	Kings Electronics
KTD-43	Kings Electronics
KTD-437	Kings Electronics
KTD-50	Kings Electronics
KTD-51	Kings Electronics
KTD-98	Kings Electronics
KTJ-100	Kings Electronics
KTJ-102	Kings Electronics
KTJ-110	Kings Electronics
KTJ-113	Kings Electronics
KTJ-114	Kings Electronics
KTJ-117	Kings Electronics
KTJ-131	Kings Electronics
KTJ-137	Kings Electronics
KTJ-138	Kings Electronics
KTJ-144	Kings Electronics
KTJ-149	Kings Electronics
KTJ-150	Kings Electronics
KTJ-153	Kings Electronics
KTJ-154	Kings Electronics
KTJ-155	Kings Electronics
KTJ-160	Kings Electronics
KTJ-162	Kings Electronics
KTJ-174	Kings Electronics
KTJ-187	Kings Electronics
KTJ-190	Kings Electronics
KTJ-200	Kings Electronics
KTJ-222	Kings Electronics
KTJ-223	Kings Electronics
KTJ-224	Kings Electronics
KTJ-225	Kings Electronics
KTJ-38	Kings Electronics
KTJ-41	Kings Electronics
KTJ-57	Kings Electronics
KTJ-58	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 17 TRIM JIG TOOL SUPPLIERS (Continued)

Trim Jig	Supplier
KTJ-60	Kings Electronics
KTJ-65	Kings Electronics
KTJ-67	Kings Electronics
KTJ-68	Kings Electronics
KTJ-79	Kings Electronics
KTJ-83	Kings Electronics
KTJ-84	Kings Electronics
KTJ-92	Kings Electronics

B. Crimp Tool Suppliers

Table 18
CRIMP TOOL SUPPLIERS

Crimp Tool	Supplier
227-1221-25	Amphenol
227-1221-57	Amphenol
227-1351-3	Amphenol
227-1351-4	Amphenol
227-944	Amphenol
227-956-4	Amphenol
612642	Buchanan
612648	Buchanan
612673	Buchanan
612675	Buchanan
612734	Buchanan
612739	Buchanan
612778	Buchanan
612807	Buchanan
683-51454-3	Thomas&Betts
683-51470-1	Thomas&Betts
CT-32	Schleuniger
HX23	Daniels
HX4	Daniels
KTH-1000	Kings Electronics
KTH-1061	Kings Electronics
KTH-1062	Kings Electronics
KTH-1078	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 18 CRIMP TOOL SUPPLIERS (Continued)

Crimp Tool	Supplier
KTH-1079	Kings Electronics
KTH-2001	Kings Electronics
KTH-2002	Kings Electronics
KTH-2003	Kings Electronics
KTH-2004	Kings Electronics
KTH-2007	Kings Electronics
KTH-2008	Kings Electronics
KTH-2011	Kings Electronics
KTH-2021	Kings Electronics
KTH-2022	Kings Electronics
KTH-2023	Kings Electronics
KTH-2042	Kings Electronics
KTH-2061	Kings Electronics
KTH-2062	Kings Electronics
KTH-2067	Kings Electronics
KTH-2081	Kings Electronics
KTH-2087	Kings Electronics
KTH-2101	Kings Electronics
KTH-2102	Kings Electronics
KTH-2103	Kings Electronics
KTH-2105	Kings Electronics
KTH-2106	Kings Electronics
KTH-2111	Kings Electronics
KTH-2127	Kings Electronics
KTH-2128	Kings Electronics
KTH-2138	Kings Electronics
KTH-2161	Kings Electronics
KTH-2177	Kings Electronics
KTH-2207	Kings Electronics
KTH-2211	Kings Electronics
KTH-2212	Kings Electronics
KTH-2213	Kings Electronics
KTH-2214	Kings Electronics
KTH-2216	Kings Electronics
KTH-2220	Kings Electronics

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 18 CRIMP TOOL SUPPLIERS (Continued)

Crimp Tool	Supplier
KTH-2229	Kings Electronics
KTH-2230	Kings Electronics
KTH-2231	Kings Electronics
KTH-2232	Kings Electronics
KTH-2235	Kings Electronics
KTH-2242	Kings Electronics
KTM-1000	Kings Electronics
KTM-1099	Kings Electronics
KTM-3000	Kings Electronics
KTM-4000	Kings Electronics
M22520/5-01	QPL
M22520/5-03	QPL
M22520/5-05	QPL
M22520/5-08	QPL
M22520/5-19	QPL
M22520/5-23	QPL
M22520/5-25	QPL
M22520/5-35	QPL
M22520/5-41	QPL
M22520/5-57	QPL
ST2352-5-1	Boeing
ST2352-5-2	Boeing
ST2352-5-Y	Boeing
ST2966M	Boeing
ST2966M-1	Boeing
ST2966M-13	Boeing
ST2966M-16	Boeing
ST2966M-6	Boeing
ST2966M-8	Boeing
WT-200	Thomas&Betts
Y119	Daniels
Y142	Daniels
Y1731	Daniels
Y197	Daniels
Y322	Daniels

20-51-15



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) WEATHERPROOF K-GRIP JUNIOR
CONNECTORS

Table 18 CRIMP TOOL SUPPLIERS (Continued)

Crimp Tool	Supplier
Y572	Daniels
Y679	Daniels

20-51-15

D6-54446

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Page 102
Oct 15/2015



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers and Description	2
	B. Necessary Materials	3
2.	<u>CONNECTOR ASSEMBLY</u>	3
	A. Cable Preparation Dimensions	3
	B. Cable Preparation	4
	C. Preparation of the Times SF-226 Coax Cable for assembly of the KN-59-72 Connector	7
	D. Center Contact Assembly	9
	E. Connector Shell Installation	10

20-51-16

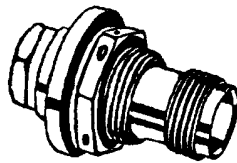


707, 727-787
STANDARD WIRING PRACTICES MANUAL

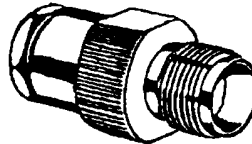
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

1. PART NUMBERS AND DESCRIPTION

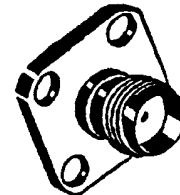
A. Connector Part Numbers and Description



Bulkhead Jack



In-Line Jack

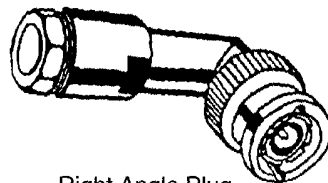


Panel Jack

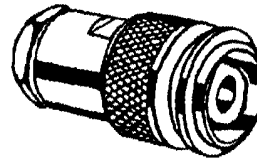
2445956 S00061545994_V1

CONVENTIONAL COAX PLUG CONNECTORS

Figure 1



Right Angle Plug



Straight Plug

2447682 S00061545995_V1

CONVENTIONAL COAX JACK CONNECTORS

Figure 2

Table 1

COAX CONNECTOR PART NUMBERS

Part Number	Series	Configuration	Supplier
KA-19-181	TNC	Panel Jack	Kings Electronics
KA-59-21	TNC	Right Angle Plug	Kings Electronics
KC-19-110	BNC	Bulkhead Jack	Kings Electronics
KC-39-75	BNC	In-Line Jack	Kings Electronics
KC-59-66	BNC	Right Angle Plug	Kings Electronics
KD-59-03	C	Straight Plug	Kings Electronics
KD-59-04	C	Straight Plug	Kings Electronics
KD-59-08	C	Straight Plug	Kings Electronics
KD-59-130	C	Straight Plug	Kings Electronics
KD-59-56	C	Straight Plug	Kings Electronics
KN-59-298	N	Right Angle Plug	Kings Electronics

20-51-16



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

Table 1 COAX CONNECTOR PART NUMBERS (Continued)

Part Number	Series	Configuration	Supplier
KN-59-51	N	Straight Plug	Kings Electronics
KN-59-72	N	Straight Plug	Kings Electronics

Table 2
ALTERNATIVE COAX CONNECTORS

Specified Connector	Alternative Connector	
	Part Number	Assembly Procedure
KC-39-75	KC-39-108	Subject 20-51-15
KD-59-03	KD-59-164	Subject 20-51-15
KD-59-04	KD-59-164	Subject 20-51-15
KD-59-130	KD-59-161	Subject 20-51-15
KN-59-51	KN-59-261	Subject 20-51-15

B. Necessary Materials

Table 3
NECESSARY MATERIALS

Material	Part Number or Specification	Supplier
Primer	Product 7471, Primer T	Loctite
Sleeve, Heat Shrinkable	MIL-LT	Raychem
Solvent	Isopropyl Alcohol	Any Source
Thread Lock Compound	222	Loctite
	Product 081 Grade D	Loctite

2. CONNECTOR ASSEMBLY

A. Cable Preparation Dimensions

Table 4
CABLE PREPARATION DIMENSIONS

Connector	Length Dimension (inch)		
	A ±0.02	B ±0.02	C ±0.02
KA-19-181	0.40	0.11	0.10
KA-59-21	0.38	0.18	0.06
KC-19-110	0.41	0.13	0.16
KC-39-75	0.34	0.11	0.11
KC-59-66	0.38	0.18	0.06

20-51-16



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

Table 4 CABLE PREPARATION DIMENSIONS (Continued)

Connector	Length Dimension (inch)		
	A ±0.02	B ±0.02	C ±0.02
KD-59-03	0.38	0.05	0.22
KD-59-04	0.25	0.05	0.20
KD-59-08	0.38	0.12	0.16
KD-59-130	0.38	0.12	0.16
KD-59-56	0.38	0.07	0.16
KN-59-298	0.31	0.05	0.19
KN-59-51	0.44	0.10	0.16
KN-59-72	0.38	0.09	0.13

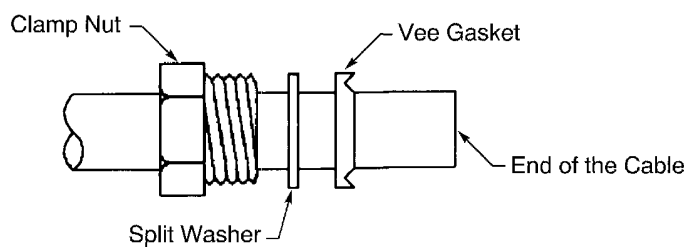
B. Cable Preparation

For the general conditions that are applicable for the preparation of coax cable, refer to Subject 20-51-00.

For the preparation of Times SF-226 cable, refer to Paragraph 2.C.

- (1) Cut the end of the cable to make it perpendicular to the longitudinal axis.
- (2) In this sequence, put these components on the cable:
 - The clamp nut
 - The split washer
 - The vee gasket.

Refer to Figure 3.



2450272 S00061546075_V1

POSITION OF THE NUT, THE WASHER, AND THE GASKET ON THE CABLE

Figure 3

- (3) Remove the necessary length of the cable jacket to make the distance from the end of the jacket to the end of the cable equal to dimension A.

Refer to Figure 4 and Table 4.

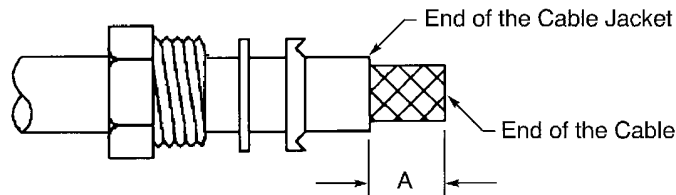
20-51-16



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

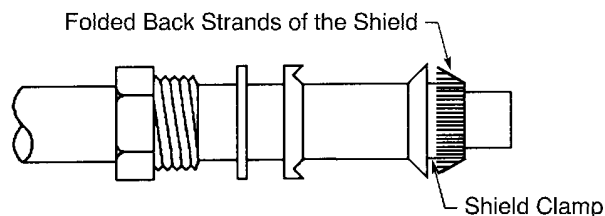


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CABLE JACKET REMOVAL

Figure 4

- (4) Put the shield clamp on the cable.
Make sure that the inner shoulder of the clamp is against the end of the cable jacket.
- (5) Move the strands of the shield apart.
- (6) Fold the strands of the shield back on the shield clamp. Refer to Figure 5.
Make sure that the strands of the shield:
 - Are parallel to the longitudinal axis of the cable
 - Are symmetrical around the circumference of the clamp
 - Do not make an overlap with each other.



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POSITION OF THE SHIELD ON THE SHIELD CLAMP

Figure 5

- (7) Remove the necessary length of shield to make the distance from the end of the shield to the forward end of the shield clamp flange equal to 0.03 inch maximum.
- (8) Remove the necessary length of dielectric to make the distance from the forward edge of the shield to the end of the dielectric equal to dimension B.
Refer to Figure 6 and Table 4.

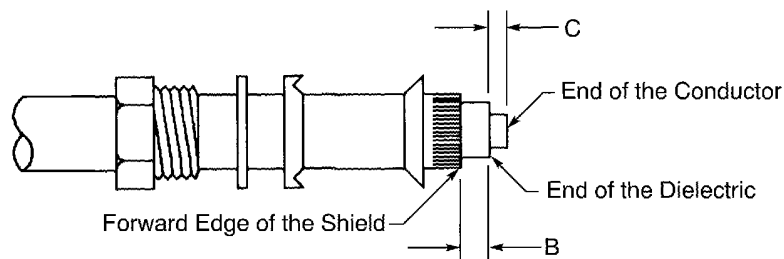
CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

20-51-16



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS



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DIELECTRIC REMOVAL

Figure 6

- (9) If these components are supplied with the connector, put them on the end of the cable in this sequence:
- The dielectric spacer
 - The cable position insulator.
- (10) Remove the necessary length of the center conductor to make the distance from the forward end of the dielectric to the end of the conductor equal to dimension C.

Refer to Figure 6 and Table 4.

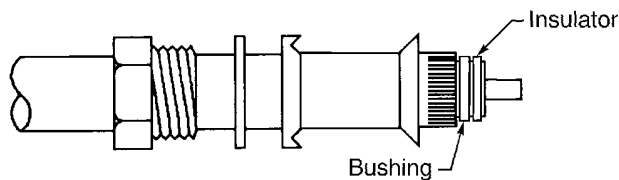
NOTE: If a dielectric spacer and an insulator are installed, the distance from the end of the center conductor to the end of the insulator must be equal to dimension C.

- (11) If these components are supplied with the connector, put them on the cable in this sequence:
- The retainer bushing
 - The insulator.

Refer to Figure 7.

Make sure that:

- The bushing is against the shield
- The shield clamp is against the bushing.



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POSITION OF THE BUSHING AND THE INSULATOR ON THE CABLE

Figure 7

20-51-16

707, 727-787 STANDARD WIRING PRACTICES MANUAL

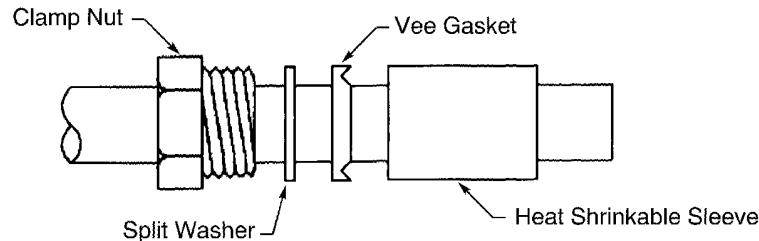
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

C. Preparation of the Times SF-226 Coax Cable for assembly of the KN-59-72 Connector

For the general conditions that are applicable for the preparation of coax cable, refer to Subject 20-51-00.

- (1) Make a selection of a 1/2 inch diameter heat shrinkable sleeve from Table 3.
NOTE: An equivalent sleeve is a satisfactory alternative. Refer to Subject 20-00-11.
- (2) Cut the end of the cable to make it perpendicular to the longitudinal axis of the cable.
- (3) In this sequence, put these components on the cable:
 - The clamp nut
 - The split washer
 - The vee gasket
 - A 1.00 inch ± 0.06 inch length of the heat shrinkable sleeve.

Refer to Figure 8.



2446013 S00061546080_V1

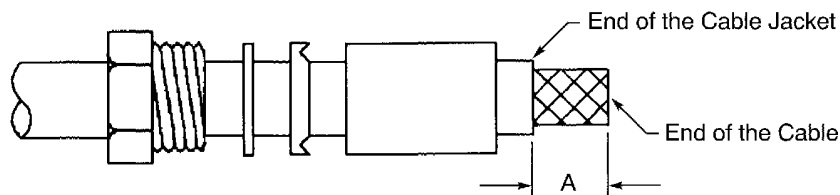
POSITION OF THE NUT, THE WASHER, THE GASKET, AND THE SLEEVE ON THE CABLE

Figure 8

- (4) Remove the necessary length of the cable jacket to make the distance from the end of the cable jacket to the end of the cable equal to dimension A.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. DAMAGE TO THE SHIELD CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

Refer to Figure 9 and Table 4.



2446014 S00061546082_V1

CABLE JACKET REMOVAL

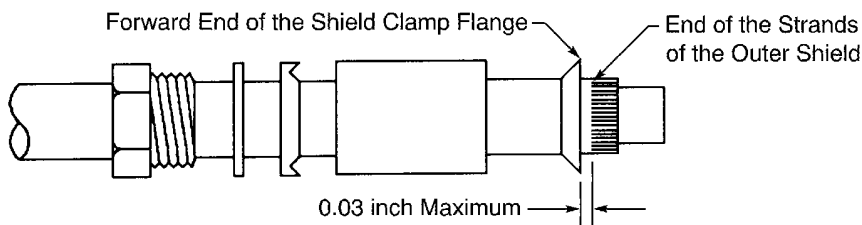
Figure 9

20-51-16

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

- (5) Put the shield clamp on the end of the cable.
Make sure that the clamp is against the end of the cable jacket
- (6) Move the strands of the outer shield apart.
Make sure the strands are parallel to the longitudinal axis of the cable.
- (7) Fold the strands of the outer shield back on the shield clamp.
Make sure that the strands of the shield:
 - Are parallel to the longitudinal axis of the cable
 - Are symmetrical around the circumference of the clamp
 - Do not make an overlap with each other.
- (8) Remove the necessary length of shield to make the distance from the end of the shield to the forward end of the shield clamp flange equal to 0.03 inch maximum. Refer to Figure 10.



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SHIELD REMOVAL

Figure 10

- (9) Remove the foil tape from the end of the cable to the forward end of the shield clamp.

CAUTION: DO NOT CUT OR BREAK THE STRANDS OF THE SHIELD. IF A STRAND OF THE SHIELD IS BROKEN, THE CABLE PREPARATION MUST BE DONE AGAIN.
- (10) Move the strands of the inner shield apart.
- (11) Fold the strands of the inner shield back on the shield clamp.
Make sure that the strands of the shield:
 - Are parallel to the longitudinal axis of the cable
 - Are symmetrical around the circumference of the clamp
 - Do not make an overlap with a each other.
- (12) Remove the necessary length of the strands to align the ends with the end of the strands of the outer shield. Refer to Figure 10.
- (13) Remove the necessary length of the dielectric to make the distance from the forward edge of the shield to the end of the dielectric equal to dimension B.

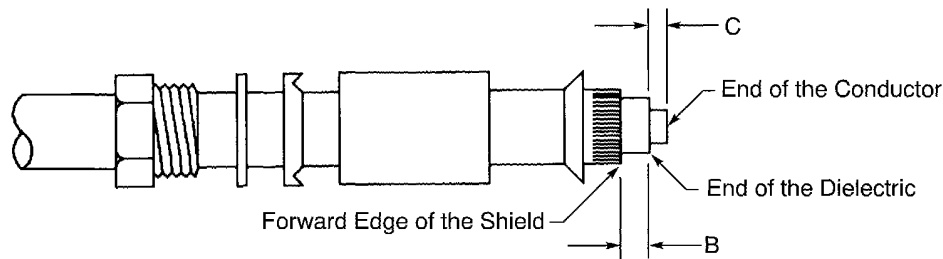
CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. DAMAGE TO THE CONDUCTOR CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.
Refer to Figure 11 and Table 4.

20-51-16



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS



2446016 S00061546086_V1

DIELECTRIC REMOVAL

Figure 11

- (14) Remove the necessary length of the center conductor to make the distance from the forward end of the dielectric to the end of the conductor equal to dimension C.

Refer to Figure 11 and Table 4.

D. Center Contact Assembly

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Make a selection of a Temperature Grade C solder. Refer to Subject 20-00-11.

CAUTION: DO NOT USE A TEMPERATURE GRADE D SOLDER. IF TOO MUCH HEAT IS APPLIED, DAMAGE TO THE CABLE CAN OCCUR.

- (2) Tin the center conductor.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (3) Put the center conductor in the solder barrel of the center contact.

Make sure that:

- All of the strands of the conductor are in the solder barrel
- The conductor can be seen in the inspection hole
- The distance from the end of the dielectric to the rear end of the solder barrel is not more than 0.03 inch.

- (4) Apply a small quantity of solder in the inspection hole of the contact.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN OCCUR.

- (5) Remove all of the solder and the flux from the outer surface of the contact.

- (6) Examine the contact for damage to the finish.

NOTE: If the contact has damage, it must be replaced.

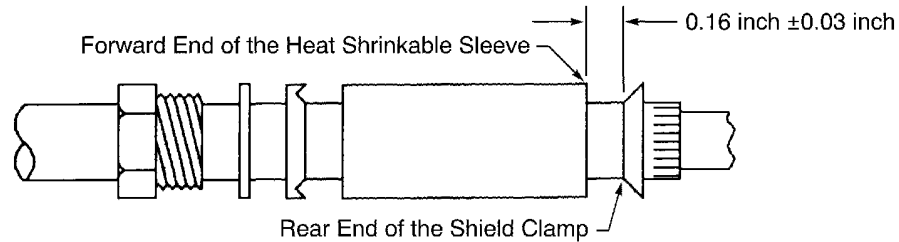
- (7) If a solder access cover is supplied with the contact, install the cover.

20-51-16

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

- (8) If the connector is supplied with a front insulator, put it on the center contact.
- (9) If a heat shrinkable sleeve is on the cable:
 - (a) Push the sleeve forward until the distance from the forward end of the sleeve to the rear of end of the shield clamp is equal to 0.16 inch \pm 0.03 inch. Refer to Figure 12.



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POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 12

- (b) Shrink the sleeve into its position. Refer to Subject 20-10-14.

E. Connector Shell Installation

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

**Table 5
CLAMP NUT TORQUE VALUES**

Connector	Torque Value (inch-pounds)	
	Minimum	Maximum
KA-19-181	28	32
KA-59-21	90	100
KC-19-110	40	50
KC-39-75	40	50
KC-59-66	40	50
KD-59-03	90	100
KD-59-04	90	100
KD-59-04	28	32
KD-59-130	40	50
KD-59-56	40	50
KN-59-298	90	100
KN-59-51	40	50
KN-59-72	90	100

- (1) Make a selection of a solvent from Table 3.

20-51-16



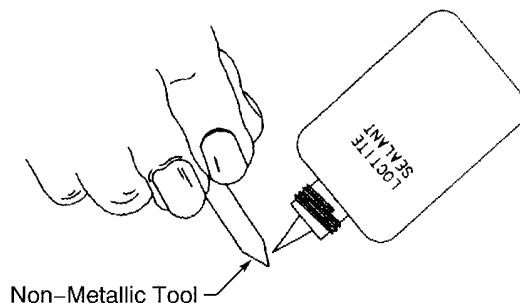
707, 727-787
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ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS

- (2) Make a selection of a primer from Table 3.
- (3) Make a selection of thread lock compound from Table 3.
- (4) Examine the threads on the rear of the connector shell for contamination or thread lock compound.
- (5) If the threads have material on them, clean the threads:
 - (a) Fully engage the threads the clamp nut and the threads of the connector.
 - (b) Remove the clamp nut from the connector shell.
- (6) Clean the clamp nut with a wiper and solvent.
- (7) Dry the nut with a clean wiper.
- (8) Apply the primer with a spray on the threads of the nut.
- (9) Let the primer to dry for 10 minutes minimum at room temperature.
- (10) Apply a layer of thread lock compound on the threads of the clamp nut.

CAUTION: THE THREAD LOCK COMPOUND DOES NOT MAKE A BOND IF THE COMPONENTS ARE ASSEMBLED MORE THAN 30 MINUTES AFTER THE COMPOUND IS APPLIED.

- (a) Put a small quantity of the compound on the tip of a non-metallic, pointed tool. Refer to Figure 13.



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LOCATION OF THE THREAD LOCK COMPOUND ON THE TOOL

Figure 13

- (b) Apply a thin, smooth layer of the compound on one or two full threads of the nut. Refer to Figure 14.

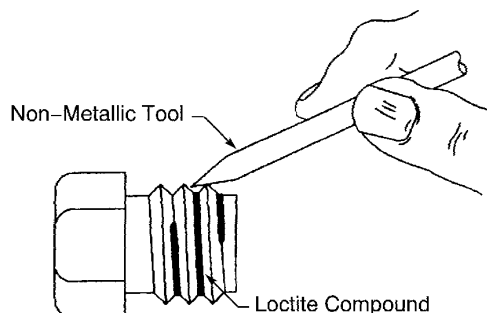
CAUTION: THREAD LOCK COMPOUND IS AN INSULATOR. TOO MUCH THREAD LOCK COMPOUND CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CONNECTOR.

20-51-16



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) CONVENTIONAL COAX CONNECTORS



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LOCATION OF THE THREAD LOCK COMPOUND ON THE THREADS OF THE CLAMP NUT

Figure 14

- (c) If too much thread lock compound is applied, remove the unwanted compound from the nut.
- (11) Push the vee gasket forward until it is against the rear end of the shield clamp.
 - (12) Push the split washer forward until it is against the vee gasket.
 - (13) Put a layer of the thread lock compound on the first two threads of the clamp nut.
 - (14) Push the clamp nut forward until it is against the washer.
 - (15) Put the contact assembly in the rear end of the connector shell.
Make sure that the shield clamp is aligned correctly against the rear end of the connector shell.
 - (16) Fully engage the threads of the clamp nut and the threads of the connector shell.
 - (17) Tighten the clamp nut to the specified torque value. Refer to Table 5.

20-51-16



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers and Description	2
	B. Necessary Materials	2
2.	<u>COAX CONNECTOR ASSEMBLY TOOLS</u>	2
	A. Coax Connector Crimp Tools	2
3.	<u>CONNECTOR SEPARATION</u>	4
	A. Separation of the Plug and the Jack	4
4.	<u>CONNECTOR ASSEMBLY</u>	5
	A. Cable Preparation	5
	B. Center Contact Assembly	6
	C. K-Grip Assembly	7
	D. Installation of the Outer Body	9
5.	<u>CONNECTOR INSTALLATION</u>	9
	A. Connection of the Plug and the Jack	9
6.	<u>APPROVED TOOL SUPPLIERS</u>	10
	A. Crimp Tools	10

20-51-17



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

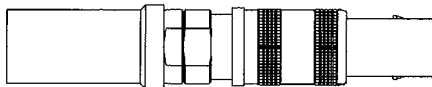
ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers and Description

**Table 1
CONNECTOR PART NUMBERS**

Part Number	Series	Configuration	Supplier
1075-13-9	K-LOC	Straight Plug	Kings Electronics



2447664 S00061546089_V1

**K-LOC COAX PLUG
Figure 1**

B. Necessary Materials

**Table 2
NECESSARY MATERIALS**

Material	Part Number or Specification	Supplier
Sleeve, Heat Shrinkable	DWP-125	Raychem

2. COAX CONNECTOR ASSEMBLY TOOLS

A. Coax Connector Crimp Tools

**Table 3
COAX CONNECTOR CRIMP TOOL CODES**

Connector	Tool Code	
	Center Contact	K-Grip Sleeve
1075-13-9	051H	213HLS

20-51-17



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

Table 4
COAX CONNECTOR CRIMP TOOL TYPES

Crimp Tool Basic Unit	Type
CT-32	Pneumatic
KTH-1000	Hand
KTM-1000	Electric
KTM-3000	Pneumatic
KTM-4000	Pneumatic

Table 5
COAX CONNECTOR CRIMP TOOLS

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
051H	CT-32	-	KTH-2022	0.051
			KTH-2087	0.051
			KTH-2232	0.051
			KTH-2242	0.051
	KTH-1000	-	KTH-2022	0.051
			KTH-2087	0.051
			KTH-2232	0.051
			KTH-2242	0.051
	KTM-1000	KTM-1099	KTH-2022	0.051
			KTH-2087	0.051
			KTH-2232	0.051
			KTH-2242	0.051
	KTM-3000	-	KTH-2022	0.051
			KTH-2087	0.051
			KTH-2232	0.051
			KTH-2242	0.051
	KTM-4000	-	KTH-2022	0.051
			KTH-2087	0.051
			KTH-2232	0.051
			KTH-2242	0.051

20-51-17



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

Table 5 COAX CONNECTOR CRIMP TOOLS (Continued)

Tool Code	Crimp Tool			
	Basic Unit	Master Jaws	Die	
			Part Number	Opening (inch)
213HLS	CT-32	-	KTH-2103	0.213
			KTH-2161	0.213
			KTH-2207	0.213
			KTH-2211	0.213
			KTH-2232	0.213
	KTH-1000	-	KTH-2103	0.213
			KTH-2161	0.213
			KTH-2207	0.213
			KTH-2211	0.213
			KTH-2232	0.213
	KTM-1000	KTM-1099	KTH-2103	0.213
			KTH-2161	0.213
			KTH-2207	0.213
			KTH-2211	0.213
			KTH-2232	0.213
	KTM-3000	-	KTH-2103	0.213
			KTH-2161	0.213
			KTH-2207	0.213
			KTH-2211	0.213
			KTH-2232	0.213
	KTM-4000	-	KTH-2103	0.213
			KTH-2161	0.213
			KTH-2207	0.213
			KTH-2211	0.213
			KTH-2232	0.213

3. CONNECTOR SEPARATION

A. Separation of the Plug and the Jack

- (1) Pull the outer ring of the plug rearward.
- (2) Pull the plug away from the jack.

20-51-17



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

4. CONNECTOR ASSEMBLY

A. Cable Preparation

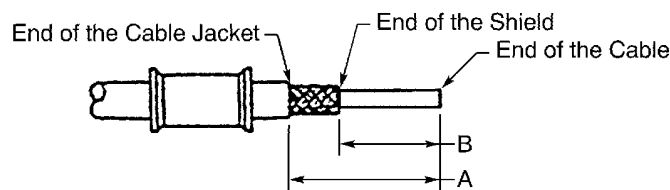
For the general conditions that are applicable for the preparation of coax cable, refer to Subject 20-51-00.

NOTE: If the cable has two shields, the shields are prepared as one shield.

Table 6
CABLE PREPARATION DIMENSIONS

Connector	Length (inch)			
	A ±0.02	B ±0.02	C ±0.02	D ±0.02
1075-13-9	0.94	0.63	0.19	0.75

- (1) Make a selection of a heat shrinkable sleeve from Table 2.
Make sure the sleeve is the smallest diameter that can be moved easily on the cable.
- (2) Put a 1.5 inch length of heat shrinkable sleeve on the cable.
- (3) Cut the end of the cable to make it perpendicular to the longitudinal axis of the cable.
- (4) Put the K-Grip sleeve on the cable.
- (5) Prepare the cable jacket and shield. Refer to Figure 2 and Table 6.



2447573 S00061546049_V1

CABLE JACKET AND SHIELD REMOVAL

Figure 2

- (a) Remove the necessary length of the cable jacket to make the distance from the end of the jacket to the end of the cable equal to dimension A.

CAUTION: DO NOT CAUSE DAMAGE TO THE SHIELD. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

- (b) Remove the necessary length of shield to make the distance from the end of the cable jacket to the end of the shield equal to dimension B.

CAUTION: DO NOT CAUSE DAMAGE TO THE DIELECTRIC. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.

20-51-17



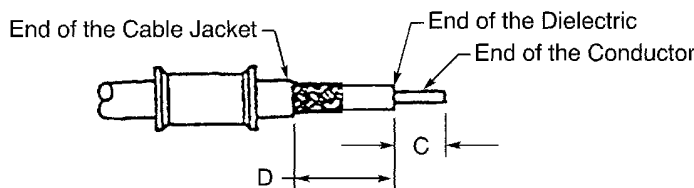
707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

- (6) If the coax cable has a semi-solid dielectric, put the cable position insulator that is supplied with the connector on the center conductor.
- (7) Remove the necessary length of the dielectric to make the distance from the end of the dielectric to the end of the center conductor equal to dimension C. Refer to Figure 3 and Table 6.

Make sure that the distance from the end of the cable jacket to the end of the dielectric is equal to dimension D.

CAUTION: DO NOT CAUSE DAMAGE TO THE CONDUCTOR. UNSATISFACTORY PERFORMANCE OF THE CABLE CAN OCCUR.



2447574 S00061546051_V1

DIELECTRIC REMOVAL

Figure 3

B. Center Contact Assembly

For the general conditions that are applicable for the assembly of coax contacts, refer to Subject 20-51-00.

- (1) Find the center contact tool code. Refer to Table 3.
- (2) Make a selection of a contact crimp tool from Table 5.
Make sure the tool is applicable for the tool code.
- (3) Put the conductor in the crimp barrel of the center contact. Refer to Figure 4.

Make sure that:

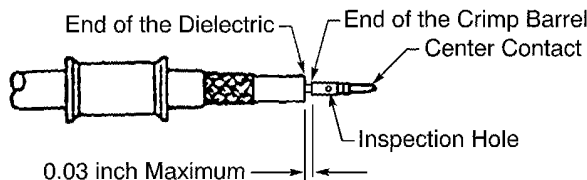
- All of the strands of the conductor are in the crimp barrel of the contact
- The conductor can be seen in the inspection hole of the contact
- The distance from the end of the dielectric to the rear end of the crimp barrel is not more than 0.03 inch.

20-51-17



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS



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POSITION OF THE CONTACT ON THE CONDUCTOR

Figure 4

- (4) Crimp the contact.
Make sure that the crimp is between the inspection hole and the rear end of the crimp barrel.
- (5) Examine the contact assembly for these types of damage:
 - The base metal of the contact can be seen
 - The crimp barrel of the contact has a crack.

NOTE: If the contact has damage, the contact must be replaced.

C. K-Grip Assembly

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

- (1) Find the K-Grip sleeve tool code. Refer to Table 3.
- (2) Make a selection of the K-Grip sleeve crimp tool from Table 5.
Make sure the tool is applicable for the tool code.
- (3) Put the connector shell on the end of the cable. Refer to Figure 5.
For a cable with one shield, make sure that:
 - The inner ferrule is between the dielectric and the shield
 - No strands of the shield are between the inner ferrule and the dielectric.

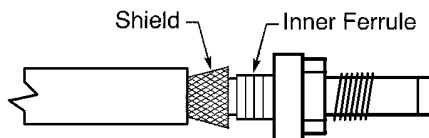
For a cable with an inner flat shield and an outer round shield, make sure that the inner ferrule is between the inner shield and the outer shield.

20-51-17



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

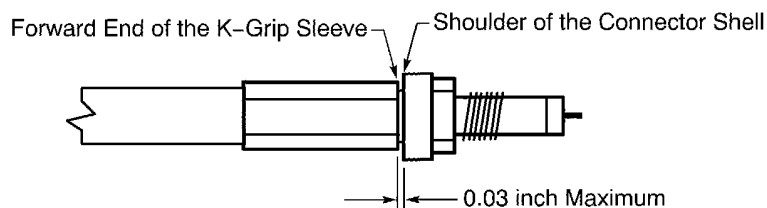


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POSITION OF THE CONNECTOR SHELL ON THE CABLE

Figure 5

- (4) Push the K-Grip assembly rearward until the contact is fully installed in the connector shell.
 - (5) Push the K-Grip sleeve forward until the forward end of the sleeve is against the shoulder of the connector shell.
 - (6) Crimp the K-Grip sleeve. Refer to Figure 6.
- Make sure that the distance between the forward end of the K-Grip sleeve and the shoulder of the connector shell is not more than 0.03 inch.



2447662 S00061546091_V1

POSITION OF THE K-GRIP SLEEVE

Figure 6

- (7) Examine the K-Grip sleeve.
Make sure that:
 - The dimples on each side of the crimp area do not have cracks
 - The base metal of the sleeve in the crimp area cannot be seen.

20-51-17

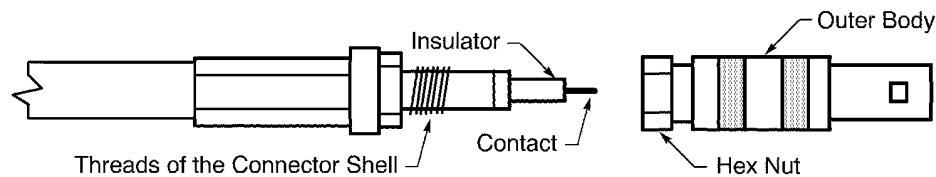
707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

D. Installation of the Outer Body

For the general conditions that are applicable for the assembly of coax connectors, refer to Subject 20-51-00.

- (1) Put the insulator on the center contact. Refer to Figure 7.

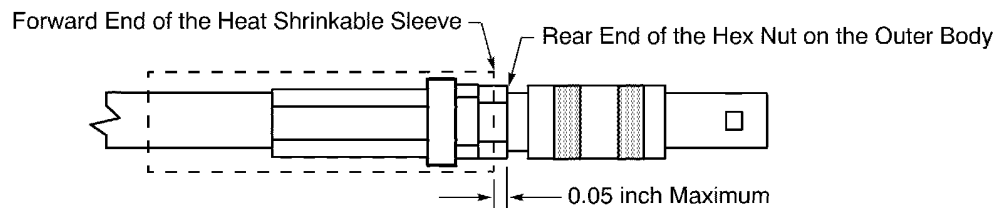


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POSITION OF THE INSULATOR ON THE CENTER CONTACT

Figure 7

- (2) Fully engage the threads of the outer body with the threads of the connector shell.
- (3) Tighten the outer body with the hand.
- (4) Tighten the outer body approximately 1/16 of a turn more with a wrench.
- (5) Push the heat shrinkable sleeve forward until the forward end of the sleeve is a not more than 0.05 inch from the rear end of the hex nut on the outer body. Refer to Figure 8.



2447602 S00061546093_V1

POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 8

- (6) Shrink the sleeve into its position. Refer to Subject 20-10-14.

5. CONNECTOR INSTALLATION

A. Connection of the Plug and the Jack

- (1) Pull the outer ring of the plug rearward.
- (2) Push the jack into the plug.
- (3) Release the outer ring of the plug.
- (4) Pull the jack lightly to make sure the plug is locked in the jack.

20-51-17



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF KINGS (WINCHESTER ELECTRONICS) K-LOC COAX CONNECTORS

6. APPROVED TOOL SUPPLIERS

A. Crimp Tools

Table 7
CRIMP TOOL SUPPLIERS

Crimp Tool	Supplier
CT-32	Schleuniger
KTH-1000	Kings Electronics
KTH-2022	Kings Electronics
KTH-2087	Kings Electronics
KTH-2103	Kings Electronics
KTH-2161	Kings Electronics
KTH-2207	Kings Electronics
KTH-2211	Kings Electronics
KTH-2232	Kings Electronics
KTH-2242	Kings Electronics
KTM-1000	Kings Electronics
KTM-1099	Kings Electronics
KTM-3000	Kings Electronics
KTM-4000	Kings Electronics

20-51-17



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF TRIAX CABLE CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers	2
	B. Connector Description	2
2.	<u>CONNECTOR ASSEMBLY</u>	3
	A. Cable Preparation	3
	B. Contact Assembly	4
	C. Connector Assembly	5

20-51-20

707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF TRIAX CABLE CONNECTORS

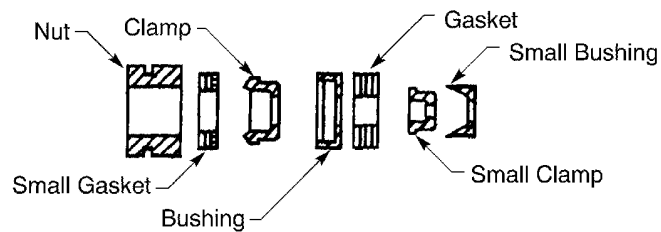
1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
CONNECTOR PART NUMBERS

Part Number	Supplier
31-30383-1	Amphenol
30382-1	Dage
30383-1	Dage

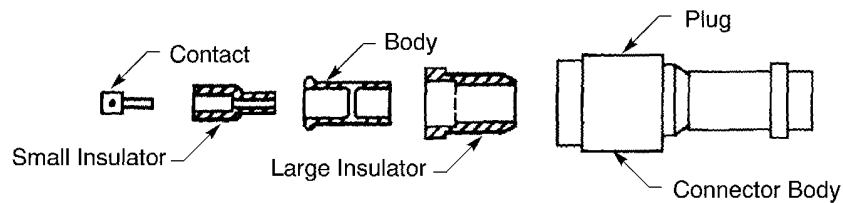
B. Connector Description



2445977 S00061546095_V1

TRIAX CONNECTOR CABLE COMPONENTS

Figure 1



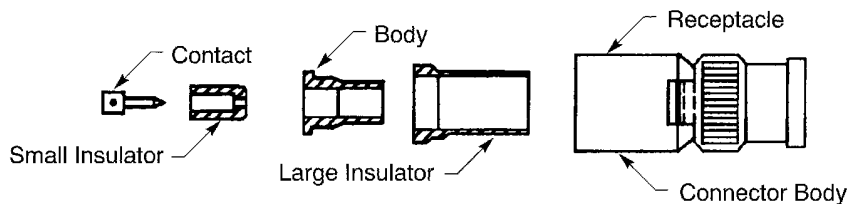
2445978 S00061546096_V1

TRIAX PLUG CONNECTOR

Figure 2



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF TRIAX CABLE CONNECTORS



2445979 S00061546097_V1

TRIAx RECEPTACLE CONNECTOR

Figure 3

2. CONNECTOR ASSEMBLY

A. Cable Preparation

- (1) Cut the cable so that the end of the cable is perpendicular to the longitudinal axis of the cable.
- (2) Remove 1 inch $\pm 1/16$ inch of the outer jacket from the end of the cable.

CAUTION: DO NOT CUT THE SHIELD OF THE CABLE. DAMAGE TO THE SHIELD CAN CAUSE UNSATISFACTORY PERFORMANCE.

- (3) Move the strands of the shield apart.
- (4) Cut the cable so that the distance from the end of the outer jacket to the end of the cable is $7/8$ inch $\pm 1/32$ inch.

CAUTION: DO NOT CUT THE STRANDS OF THE SHIELD.

- (5) Put the strands of the shield flat against the cable so that they are parallel to the longitudinal axis of the cable.

Make sure that the end of the strands are beyond the end of the cable.

- (6) In this order, put these components on the cable:
 - The nut
 - The small gasket.

Refer to Figure 1.

NOTE: If it is necessary, the ends of the strands of the shield can be twisted together.

Make sure that the components are over all of the strands of the shield

- (7) Put the clamp on the cable so that the inner shoulder of the clamp is tight against end of the jacket.
- (8) Remove the necessary length of the shield so that the distance from the end of the shield to the end of the clamp is $5/32$ inch $\pm 1/32$ inch.
- (9) Fold the strands of the shield back over the clamp so that they are flat and symmetrical against the cable.
- (10) In this order, put these components on the cable:

20-51-20



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF TRIAX CABLE CONNECTORS

- The bushing
- The gasket

Refer to Figure 1.

- (11) Remove the necessary length of the inner jacket so that the distance from the gasket to the end of the jacket is 3/64 inch +0 inch, -1/32 inch.
- (12) Move the strands of the inner shield apart.

CAUTION: DO NOT CUT THE SHIELD OF THE CABLE. DAMAGE TO THE SHIELD CAN CAUSE UNSATISFACTORY PERFORMANCE.

- (13) Remove a 1/8 inch $\pm 1/16$ inch length from the end of the cable.

CAUTION: DO NOT CUT THE STRANDS OF THE SHIELD.

- (14) Remove the necessary length of the inner jacket so that the forward edge of the inner jacket is aligned with the forward edge of the gasket.
- (15) Put the strands of the inner shield flat against the cable so that they are parallel to the longitudinal axis of the cable.

Make sure that the end of the strands are beyond the end of the cable.

- (16) Put the small clamp over the strands of the inner shield so that the shoulder of the clamp is tight against the end of the inner jacket.

NOTE: If it is necessary, the ends of the strands of the shield can be twisted together.

- (17) Fold the strands of the inner shield back over the clamp so that they are flat and symmetrical.
- (18) Remove the necessary length of the strands of the inner shield so that the distance from the end of the strands to the rear edge of the clamp is 1/32 inch $\pm 1/64$ inch.
- (19) Put the small bushing on the cable so that the bushing is against the clamp.
- (20) Remove the necessary length of the dielectric so that the distance from the clamp to the end of the dielectric is 3/16 inch $\pm 1/32$ inch.

CAUTION: DO NOT CUT OR CAUSE ANY DAMAGE TO THE CONDUCTOR. DAMAGE TO THE CONDUCTOR CAN CAUSE UNSATISFACTORY PERFORMANCE.

- (21) Remove the necessary length of the inner conductor so that the distance from the end of the dielectric to the end of the conductor is 5/64 inch $\pm 1/64$ inch.

B. Contact Assembly

- (1) Put the contact on the inner conductor.
- (2) Solder the contact.

CAUTION: DO NOT PUT MORE THAN THE NECESSARY QUANTITY OF SOLDER ON THE CONTACT AND CONDUCTOR. UNWANTED SOLDER ON THE INNER CONTACT CAN PREVENT THE INSERTION OF THE CONTACT INTO THE INSULATOR.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER.

20-51-20



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF TRIAX CABLE CONNECTORS

C. Connector Assembly

Refer to:

- Figure 2 for the plug connector
- Figure 3 for the receptacle connector.

- (1) Put the small insulator onto the contact assembly.
- (2) Put the body onto the contact assembly.
- (3) Put the large insulator onto the contact assembly.
- (4) Put the connector body onto the contact assembly.
- (5) Engage the threads of the nut and the connector body.

Make sure that the groove in the small gasket is aligned with the sharp edge of the clamp. Refer to Figure 1.

- (6) Torque the nut to 45 inch-pounds.



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMP (TYCO) 2-329083-1 COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
B. Coax Cable Part Numbers	2
2. <u>CONNECTOR ASSEMBLY</u>	2
A. Cable Preparation	2
B. Connector Assembly	3

20-51-21



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) 2-329083-1 COAX CONNECTORS

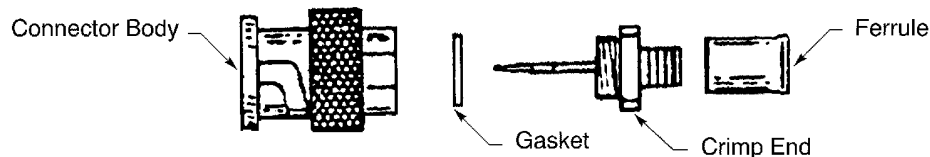
This Subject gives the procedures to assemble the AMP 2-329083-1 coax connector with the specified coax cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Type	Supplier
2-329083-1	BNC Plug	AMP



2445960 S00061546103_V1

AMP 2-329083-1 BNC CONNECTOR
Figure 1

B. Coax Cable Part Numbers

Table 2
COAX CABLE PART NUMBERS

Part Number	Specification	Supplier
M17/29-RG59	MIL-C-17/29	QPL
M17/30-RG62	MIL-C-17/30	QPL
M17/58-RG140	MIL-C-17/58	QPL
M17/97-RG210	MIL-C-17/97	QPL

2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

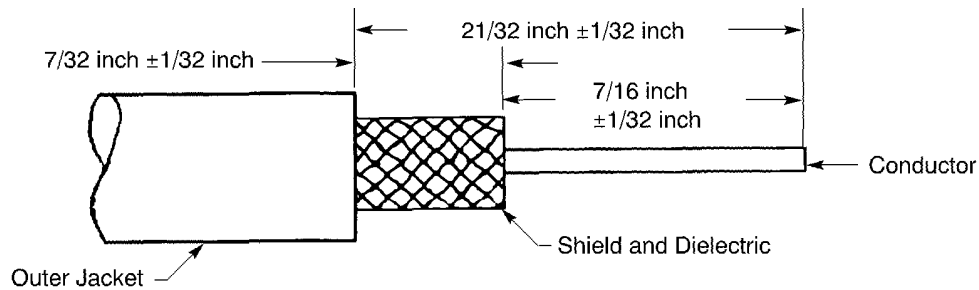
A. Cable Preparation

- (1) Put the ferrule on the cable.
- (2) Prepare the cable. Refer to Figure 2.

20-51-21



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMP (TYCO) 2-329083-1 COAX CONNECTORS



2445961 S00061546104_V1

CABLE TRIM DIMENSIONS

Figure 2

- (a) Remove $21/32$ inches $\pm 1/32$ inch of the outer jacket of the cable.
- (b) Remove $7/16$ inch $\pm 1/32$ inch of the shield and dielectric.
- (3) Move the strands of the shield apart a small amount.

B. Connector Assembly

Table 3
CONNECTOR CRIMP TOOLS

Basic Tool		Die	
Part Number	Supplier	Part Number	Supplier
69141-1	AMP	-	AMP
69710	AMP	69224-1	AMP

- (1) Make a selection of a crimp tool from Table 3.
- (2) Push the prepared cable into the crimp end of the connector.
NOTE: The crimp end can be twisted a small amount to make it easier.
- (3) Push the crimp end under the expanded end of the shield.
NOTE: The crimp end can be twisted a small amount to make sure that the dielectric goes into the crimp end as far as possible.
- (4) Push the ferrule over the shield until the ferrule is against the shoulder of the crimp end of the connector.
- (5) Crimp the ferrule.
- (6) Put the gasket on the crimp end of the connector.
- (7) Engage the threads of the connector body and the crimp end.
- (8) Tighten connector body and crimp end of the connector with wrenches.

20-51-21



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers	2
	B. Coaxiclamp Splice Part Numbers	3
	C. Coax Cable Part Numbers	3
2.	<u>CONNECTOR ASSEMBLY</u>	4
	A. Necessary Tools for Connector Assembly	4
	B. Cable Preparation	5
	C. Assembly of the Connector Body	8
	D. Assembly of the Center Contact	10
3.	<u>RG231 COAX CABLE REPAIR</u>	10
	A. Conditions for Repair	10
	B. Necessary Tools	10
	C. Cable Preparation	12
	D. Splice Assembly	14

20-51-26



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

This Subject gives the procedures to:

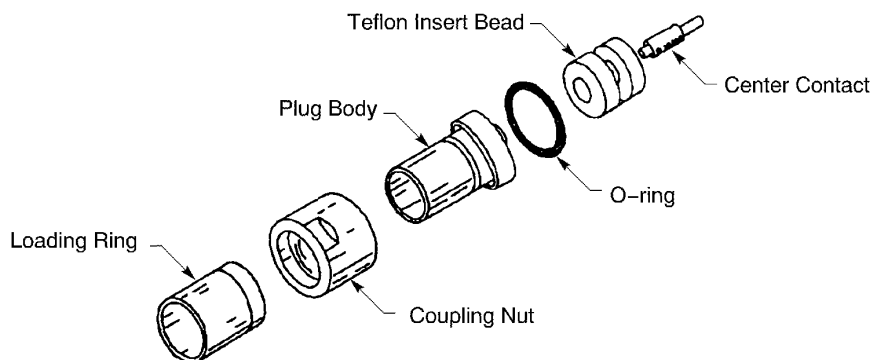
- Assemble the Coaxiclamp connector with the specified coax cable
- Repair the RG231 coax cable with a Coaxiclamp splice.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Connector Type	Supplier
331719	Plug	AMP
331843	Jack	AMP



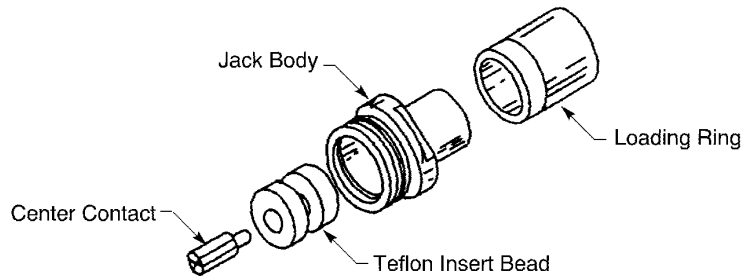
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AMP 331719 COAXICLAMP PLUG
Figure 1

20-51-26



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES



2445981 S00061546107_V1

AMP 331843 COAXICLAMP JACK
Figure 2

B. Coaxiclamp Splice Part Numbers

Table 2
COAXICLAMP SPLICE PART NUMBERS

Part Number	Supplier
331713	AMP

C. Coax Cable Part Numbers

Table 3
COAX CABLE PART NUMBERS

Part Number	Specification	Supplier
RG231/U	MIL-C-23806	QPL

20-51-26



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

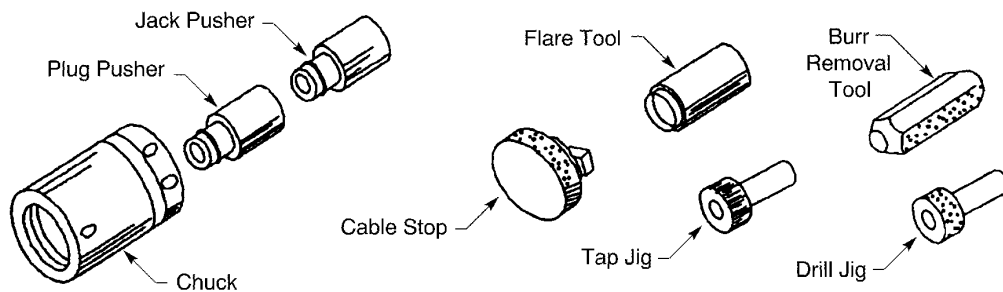
2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. Necessary Tools for Connector Assembly

Table 4
NECESSARY TOOLS

Tool	Part Number	Supplier
Applicator Kit	69468	AMP
Drill Jig	ST2218A	Boeing
Hydraulic Tool	69467	AMP
Hydraulic Tool With Flex Hose	69467-1	AMP



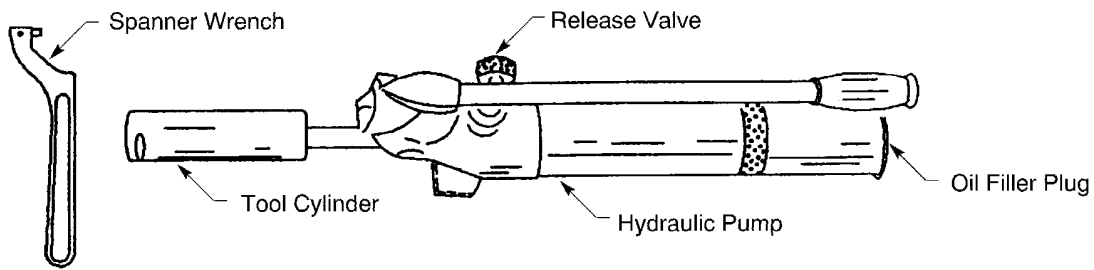
2445982 S00061546108_V1

CONTENTS OF THE AMP 69468 APPLICATOR KIT
Figure 3

20-51-26

STANDARD WIRING PRACTICES MANUAL

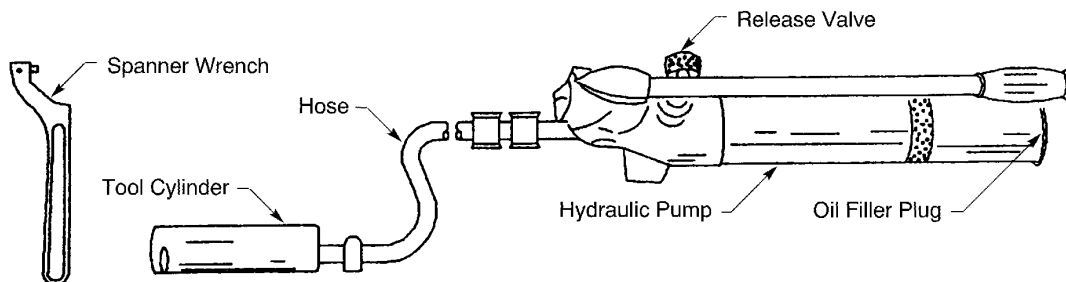
ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES



2445983 S00061546109_V1

AMP 69467 HYDRAULIC TOOL

Figure 4



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AMP 96467-1 HYDRAULIC TOOL WITH A FLEXIBLE HOSE

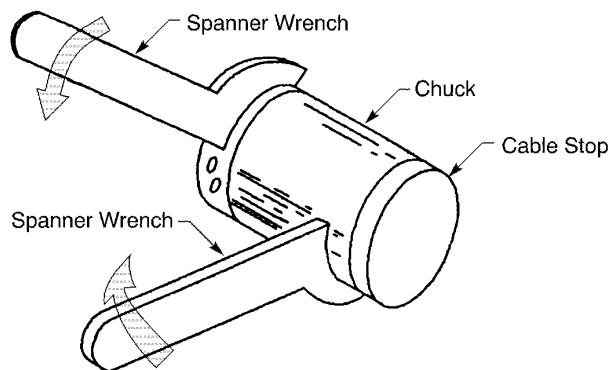
Figure 5

B. Cable Preparation

- (1) Cut the cable so that the end is perpendicular to the longitudinal axis of the cable.
- (2) Remove any burrs on the end of the cable.
- (3) Put the cable stop on the end of the chuck. Refer to Table 4 and Figure 3.
- (4) Put the chuck on the cable so that the end of the cable is against the cable stop.
- (5) Tighten the chuck with a pair of spanner wrenches. Refer to Figure 6.



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES



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POSITION OF THE SPANNER WRENCHES ON THE CHUCK

Figure 6

- (6) Remove the cable stop from end of the chuck.
- (7) If the coax cable has solid center conductor:
 - (a) Put the drill jig over the center conductor so that the end of the cable is against the jig.
NOTE: A satisfactory alternative for the AMP drill jig is given in Table 4.
 - (b) Drill the center of the conductor 0.25 inch to 0.40 inch with a 0.110 inch diameter drill bit.
 - (c) Remove the drill jig.
- (8) Put the tap jig on the cable so that:
 - The jig is over the center conductor
 - The end of the cable is against the jig.

Refer to Figure 7.

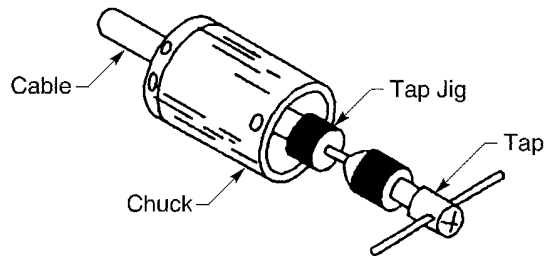
20-51-26



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

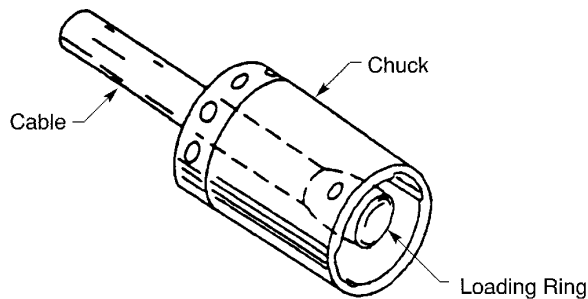


2445985 S00061546112_V1

POSITION OF THE TAP JIG AND THE TAP ON THE CENTER CONDUCTOR

Figure 7

- (9) Put a 5-44 tap on the tap jig. Refer to Figure 7.
- (10) Turn the tap 8 turns to make a minimum of 7 threads in the center conductor.
- (11) Remove the tap and the tap jig from the cable.
- (12) Remove any burrs on the new threads of the conductor.
- (13) Put the loading ring on the cable. Refer to Figure 8.
Make sure that the large end of the ring is on the end of the cable.



2445986 S00061546113_V1

POSITION OF THE LOADING RING

Figure 8

- (14) Make a selection of a hydraulic tool from Table 4.
Refer to:
 - Figure 4 for the hydraulic tool without a flexible hose

20-51-26

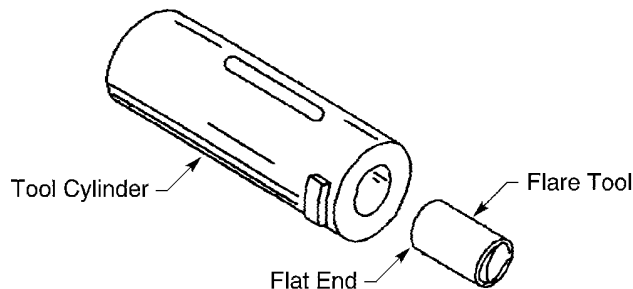


707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

- Figure 5 for the hydraulic tool with a flexible hose.

(15) Put the flat end of the flare tool into the hydraulic tool cylinder. Refer to Figure 9.



2445987 S00061546114_V1

POSITION OF THE FLARE TOOL IN THE TOOL CYLINDER

Figure 9

- (16) Put the tool cylinder into the chuck.
- (17) Turn the cylinder approximately 1/4 of a turn to lock it in the chuck.
- (18) Close the release valve on the hydraulic tool.
- (19) Pump the handle of the hydraulic tool until:
- The flare tool is against the bottom of the chuck
 - The pressure is released.
- (20) Open the release valve.
- (21) Remove tool cylinder from the chuck.

C. Assembly of the Connector Body

- (1) Put the applicable pusher in the connector body. Refer to Figure 3.

CAUTION: THE CONNECTOR BODY MUST BE PUSHED ONTO THE CABLE WITH THE CORRECT PUSHER.

NOTE: The plug pusher has a shoulder.

- (2) For the plug, put these components on the body:
- The O-ring
 - The pusher
 - The coupling nut.

Refer to Figure 10.

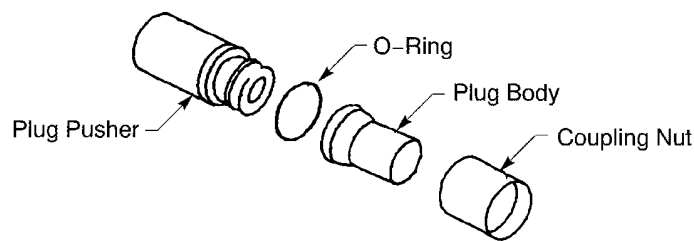
20-51-26



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

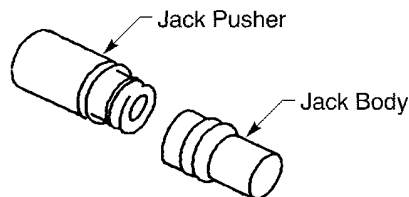


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ASSEMBLY OF THE BODY OF THE PLUG CONNECTOR

Figure 10

- (3) For the jack, put the connector body on the pusher. Refer to Figure 11.

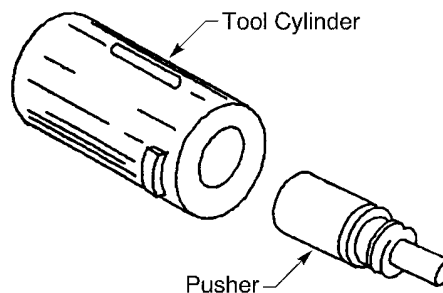


2445989 S00061546117_V1

ASSEMBLY OF THE BODY OF THE JACK CONNECTOR

Figure 11

- (4) Put the pusher in the tool cylinder. Refer to Figure 12.



2445990 S00061546118_V1

POSITION OF THE PUSHER IN THE TOOL CYLINDER

Figure 12

- (5) Turn the cylinder approximately 1/4 of a turn to lock it in the chuck.
(6) Close the release valve on the hydraulic tool.
(7) Pump the handle until:
- The pusher is against the bottom of the chuck

20-51-26



707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

- The pressure is released.
- (8) Open the release valve.
- (9) Remove the tool cylinder from the chuck.
- (10) Remove the pusher from the connector body.
- (11) Remove the chuck with the spanner wrenches.
- (12) Remove the pusher from the chuck.

D. Assembly of the Center Contact

- (1) Engage the threads of the contact with the center conductor.
- (2) Tighten the contact on the center conductor.
- (3) Put the Teflon insert bead on the center contact.
- (4) Pus the contact into the connector body until the insert bead and the contact are against the connector body.
- (5) Put the coupling nut on the connector.
- (6) Hold the clamp nut so that it does not move.

CAUTION: DAMAGE TO THE SWAGED CONNECTION CAN OCCUR IF THE CLAMP MOVES WHILE IT IS TIGHTENED.

- (7) Turn the plug or the jack with the torque wrench.
- (8) Torque the coupling nut 90 inch-pounds \pm 5 inch-pounds.

3. RG231 COAX CABLE REPAIR

Refer to Subject 20-51-00 for the general conditions that are applicable for the preparation of coax cables.

A. Conditions for Repair

The cable must be replaced or repaired if the cable has:

- Any damage that goes through the jacket
- A dent or a depression that is greater than 3 inches in length
- A dent or a depression that is greater than 1/32 inch in depth.

B. Necessary Tools

**Table 5
NECESSARY TOOLS**

Tool	Part Number	Supplier
Applicator Kit	69658	AMP
Ratchet Tool	69634	AMP

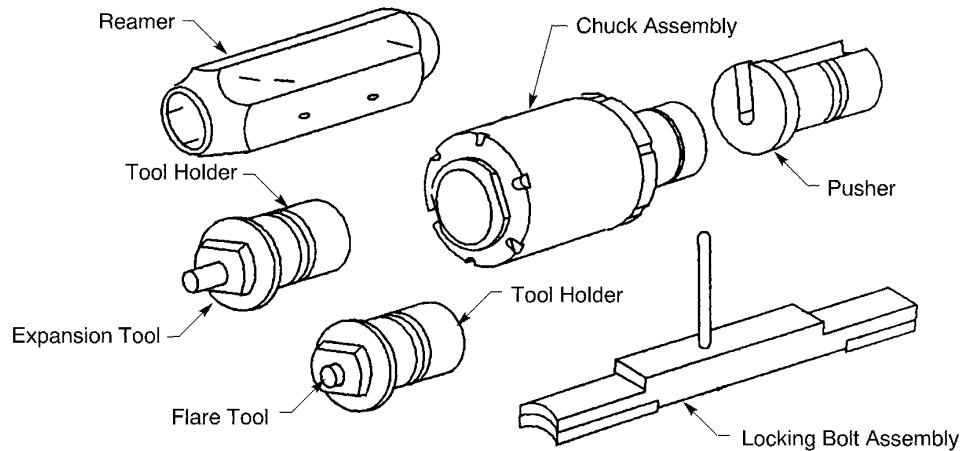
Refer to:

- Figure 13 for the applicator kit
- Figure 14 for the ratchet tool.

20-51-26

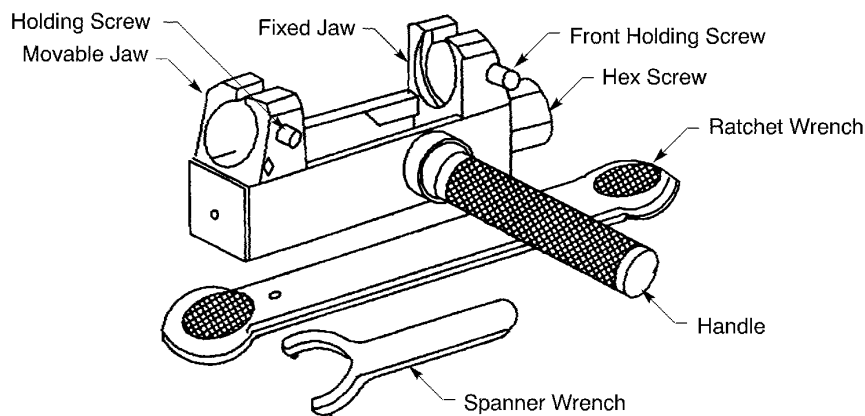


707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES



2445991 S00061546120_V1

CONTENTS OF THE AMP 69658 APPLICATOR KIT
Figure 13



2445992 S00061546121_V1

AMP 69634 RATCHET TOOL
Figure 14

NOTE: The handle and the holding screw can be assembled on either side of the ratchet tool.

20-51-26



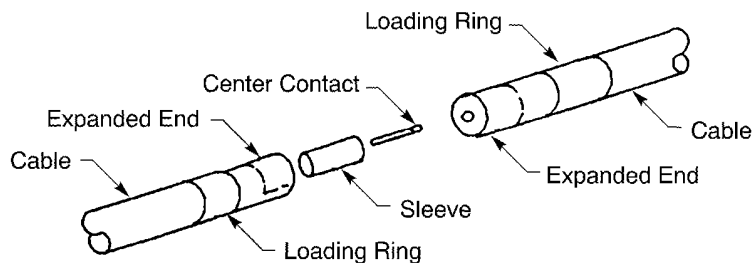
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

C. Cable Preparation

- (1) Make a selection of a splice from Table 2.
- (2) Cut each cable segment to make the end perpendicular to the longitudinal axis.
- (3) Remove any burrs from the end of each cable.
- (4) For the end of each cable:
 - (a) Put a loading ring on the cable. Refer to Figure 15.

Make sure that the large end of the ring is toward the end of the cable.

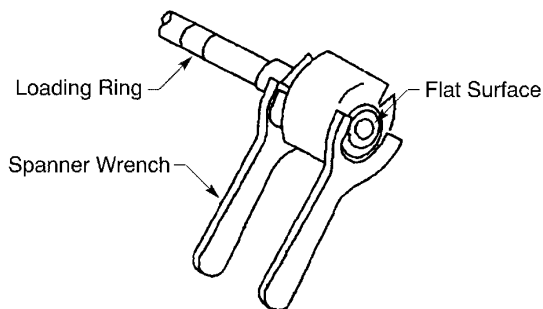


2445993 S00061546122_V1

POSITION OF THE LOADING RING ON THE CABLE

Figure 15

- (b) Put the chuck on the cable. Refer to Figure 16.
- Make sure that the flat surface of the chuck is aligned with the end of the cable.



2445994 S00061546123_V1

POSITION OF THE CHUCK ON THE CABLE

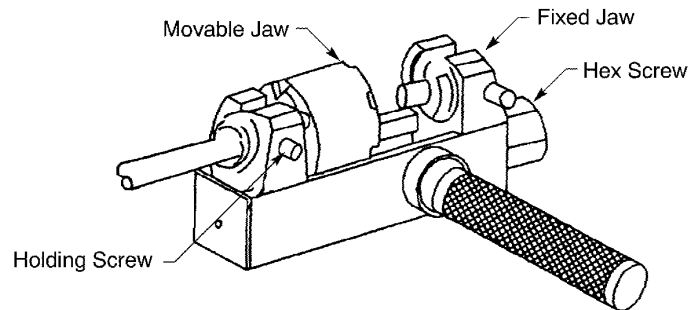
Figure 16

20-51-26

707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

- (c) Tighten the chuck on the cable with a pair of spanner wrenches.
- (d) Put the chuck in the movable jaw of the ratchet tool. Refer to Figure 17.



2445995 S00061546124_V1

POSITION OF THE CHUCK IN THE RATCHET TOOL

Figure 17

- (e) Tighten the holding screw so that the chuck is held in position.
- (f) Put the flare tool on the tool holder.
- (g) Put the tool holder in the fixed jaw of the ratchet tool.
- (h) Turn the hex screw clockwise until the end of the cable is against the flare tool.
- (i) Turn hex screw counterclockwise until the tool holder can be removed.
- (j) Put the expander tool on the tool holder.
- (k) Put the tool holder into the fixed jaw of the ratchet tool.
- (l) Turn the hex screw clockwise until the cable is against the bottom of the expander tool.
Make sure that the expander tool goes under the outer jacket of the cable.
- (m) Turn hex screw counterclockwise until the tool holder can be removed.
- (n) Remove the chuck from the ratchet tool.

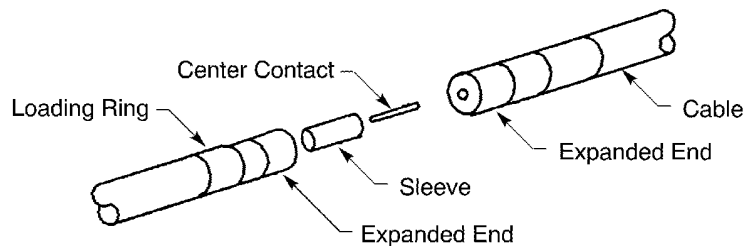


707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

D. Splice Assembly

- (1) Assemble the center contact. Refer to Figure 18.



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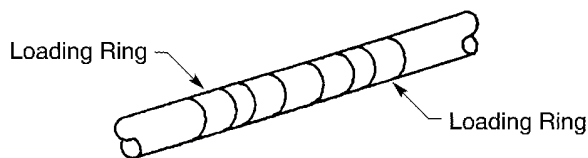
CENTER CONTACT ASSEMBLY
Figure 18

- (a) Put the center contact in the one end of the cable.
(b) Put the sleeve on the contact.
(c) Put the two ends of the cable together.

Make sure that:

- The sleeve is under the jacket on the end of each cable
- The dielectrics of each cable are against each other.

Refer to Figure 19.



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POSITION OF THE TWO ENDS OF THE CABLE
Figure 19

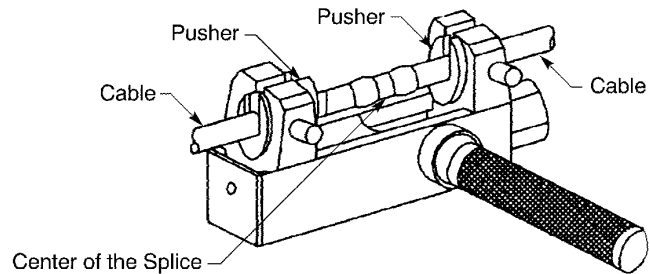
- (2) Put a pusher in each end of the ratchet tool.
(3) Push loading ring toward the end of each cable.
(4) Put the cable in the ratchet tool so that:
- The center of the splice is aligned with the center of the tool.
 - Each cable is in the groove of the applicable pusher.

Refer to Figure 20.

20-51-26



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

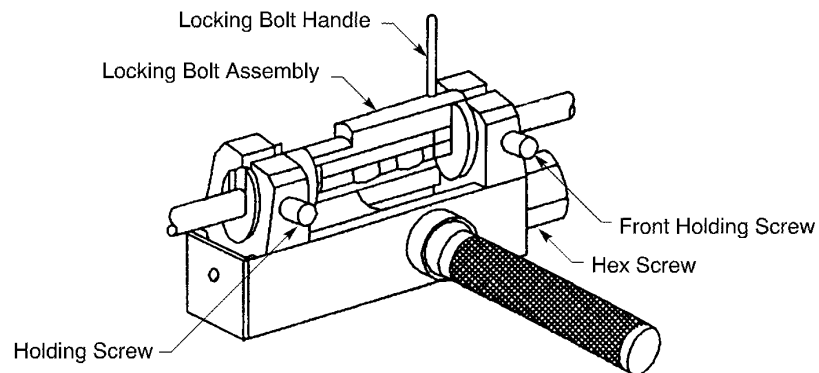


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POSITION OF THE SPLICE IN THE RATCHET TOOL

Figure 20

- (5) Put the locking bolt assembly in the ratchet tool. Refer to Figure 21.



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POSITION OF THE LOCKING BOLT ASSEMBLY IN THE RATCHET TOOL

Figure 21

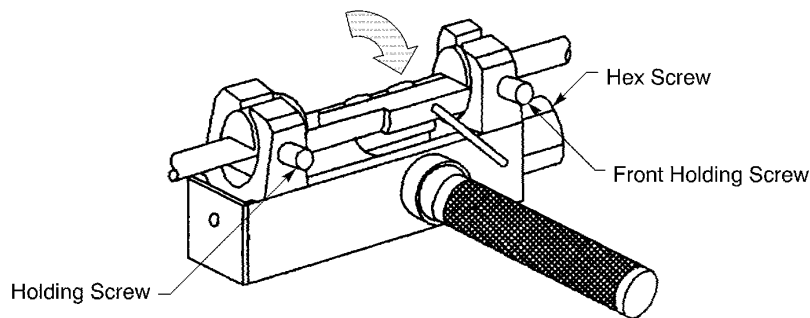
20-51-26



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMP (TYCO) COAXICLAMP CONNECTORS AND SPLICES

- (6) Turn the handle of the locking bolt so that each pusher is in the locked position. Refer to Figure 22.



2446000 S00061546129_V1

LOCKED POSITION OF THE PUSHERS

Figure 22

- (7) Tighten each holding screw so that the locking bolt stays in position.
- (8) To push the loading rings over the expanded ends of the cable, turn the hex screw clockwise with a ratchet wrench until the pushers are against the locking bolt assembly.
- (9) Loosen each holding screw.
- (10) Turn the locking bolt handle until it is in the vertical position. Refer to Figure 21.
- (11) Remove the locking bolt assembly.
- (12) Remove the cable from the ratchet tool.

20-51-26



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF BURNDY RSCDEX-() COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers	2
	B. Coax Contact Part Numbers	3
	C. Coax Cable Part Numbers	3
2.	<u>CONNECTOR DISASSEMBLY</u>	4
	A. Coax Contact Removal	4
3.	<u>CONNECTOR ASSEMBLY</u>	4
	A. Cable Preparation for the Assembly of Plug Connector	4
	B. Cable Preparation for the Assembly of a Receptacle Connector	5
	C. Coax Contact Assembly	5
	D. Coax Contact Insertion	6

20-51-31



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY RSCDEX-() COAX CONNECTORS

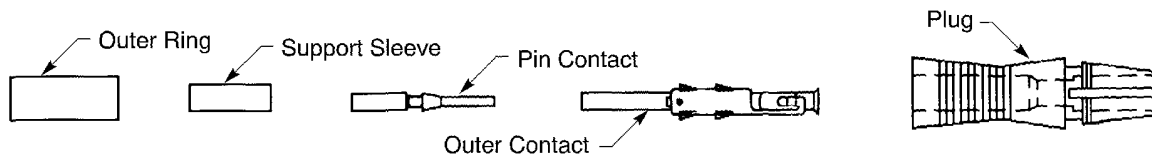
This Subject gives the procedures to assemble the Burndy RSCDEX-() coax connectors with the specified cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

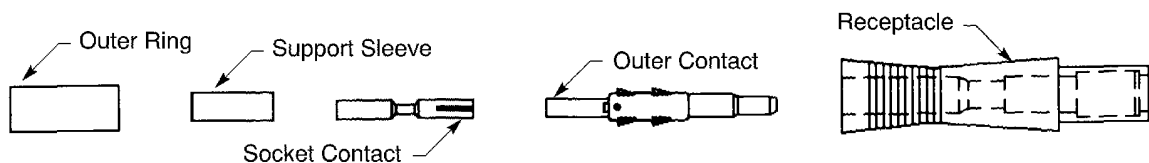
Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Configuration	Supplier
RSCDEX-2	Plug	Burndy
RSMDEX-1	Receptacle	Burndy



2445962 S00061546131_V1

BURNDY RSCDEX-2 PLUG CONNECTOR
Figure 1



2445963 S00061546132_V1

BURNDY RSMDEX-1 RECEPTACLE CONNECTOR
Figure 2

20-51-31



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY RSCDEX-() COAX CONNECTORS

B. Coax Contact Part Numbers

Table 2
COAX CONTACT KIT PART NUMBERS

Connector	Kit		
	Part Number	Description	Supplier
RSCDEX-2	RCDXK-1	Coax Pin Contact Kit	Burndy
RSMDEX-1	RMDXK-1	Coax Socket Contact Kit	Burndy
RSMDEX-1	RMDXK-10	Coax Socket Contact Kit	Burndy

Table 3
COAX CONTACT KIT CONTENTS

Kit	Contents		
	Part Number	Description	Supplier
RCDXK-1	RCDX60-2	Outer Contact	Burndy
	RCDXB055-1	Support Sleeve	Burndy
	RMD26L-1	Pin Contact	Burndy
	YOC-074	Outer Ring	Burndy
RMDXK-1	RFD26L-1	Socket Contact	Burndy
	RMDX60-2	Outer Contact	Burndy
	RMDXB055-1	Support Sleeve	Burndy
	YOC-074	Outer Ring	Burndy
RMDXK-10	RFD26-1	Socket Contact	Burndy
	RMDX60-2	Outer Contact	Burndy
	RMDXB055-3	Support Sleeve	Burndy
	YOC-074	Outer Ring	Burndy

C. Coax Cable Part Numbers

Table 4
COAX CABLE PART NUMBERS

Part Number	Supplier
5026A1018	Raychem
5026D1018	Raychem

20-51-31



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY RSCDEX-() COAX CONNECTORS

2. CONNECTOR DISASSEMBLY

A. Coax Contact Removal

Table 5
COAX CONTACT REMOVAL TOOLS

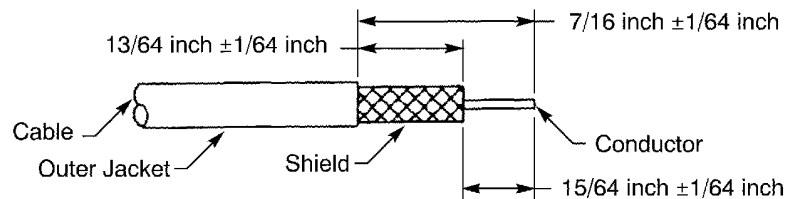
Removal Tool	Supplier
RX20-25	Burndy
RXK20-25	Burndy

- (1) Make a selection of a coax contact removal tool from Table 5.
- (2) Push the tool into the contact cavity of the plug or the receptacle.
- (3) Pull the contact assembly and the tool from the contact cavity.

3. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. Cable Preparation for the Assembly of Plug Connector



2445964 S00061546133_V1

CABLE PREPARATION FOR A PLUG ASSEMBLY
Figure 3

Refer to Figure 3.

- (1) Cut the end of the cable perpendicular to the longitudinal axis of the cable.
- (2) Remove 7/16 inch \pm 1/64 inch of the outer jacket from the end of the cable.

CAUTION: DO NOT CAUSE ANY DAMAGE TO THE SHIELD. DAMAGE TO THE SHIELD CAN CAUSE UNSATISFACTORY RELIABILITY OF THE CABLE OR UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

- (3) Remove 15/64 inch \pm 1/64 inch of the shield and the dielectric from the end of the cable.

CAUTION: DO NOT CAUSE ANY DAMAGE TO THE CONDUCTOR. DAMAGE TO THE CONDUCTOR CAN CAUSE UNSATISFACTORY RELIABILITY OF THE CABLE OR UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

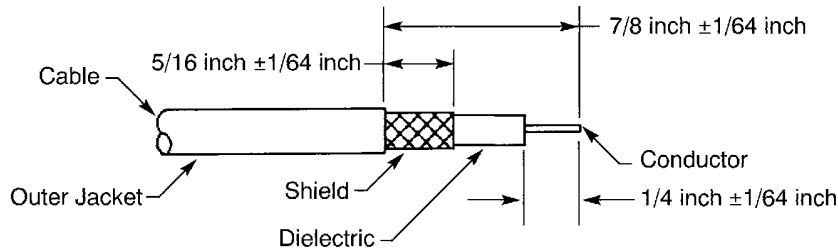
20-51-31



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY RSCDEX-() COAX CONNECTORS

B. Cable Preparation for the Assembly of a Receptacle Connector



2445965 S00061546136_V1

CABLE PREPARATION FOR A RECEPTACLE ASSEMBLY
Figure 4

Refer to Figure 4.

- (1) Cut the end of the cable perpendicular to the longitudinal axis of the cable.
- (2) Remove 7/8 inch \pm 1/64 inch of the outer jacket from the end of the cable.

CAUTION: DO NOT CAUSE ANY DAMAGE TO THE SHIELD. DAMAGE TO THE SHIELD CAN CAUSE UNSATISFACTORY RELIABILITY OF THE CABLE OR UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

- (3) Remove the necessary length of the shield.

Make sure that the distance from the end of the outer jacket to the end of the shield is 5/16 inch \pm 1/64 inch.

CAUTION: DO NOT CAUSE ANY DAMAGE TO THE DIELECTRIC. DAMAGE TO THE DIELECTRIC CAN CAUSE UNSATISFACTORY RELIABILITY OF THE CABLE OR UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

- (4) Remove the necessary length of the dielectric.

Make sure that the distance from the end of the dielectric to the end of the cable is 1/4 inch \pm 1/64 inch.

CAUTION: DO NOT CAUSE ANY DAMAGE TO THE CONDUCTOR. DAMAGE TO THE CONDUCTOR CAN CAUSE UNSATISFACTORY RELIABILITY OF THE CABLE OR UNSATISFACTORY PERFORMANCE OF THE SYSTEM.

C. Coax Contact Assembly

Table 6
COAX CONTACT CRIMP TOOLS

Basic Unit		Locator		Die	
Part Number	Supplier	Part Number	Supplier	Part Number	Supplier
M10S-1	Burndy	SL-46	Burndy	S-26	Burndy

20-51-31



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY RSCDEX-() COAX CONNECTORS

Table 7
OUTER RING CRIMP TOOLS

Basic Unit		Locator		Die	
Part Number	Supplier	Part Number	Supplier	Part Number	Supplier
M10S-1	Burndy	SL-47	Burndy	S-22	Burndy

- (1) Make a selection of a coax contact crimp tool from Table 6.
- (2) Make a selection of an outer ring crimp tool from Table 7.
- (3) Put the outer ring on the cable.

Refer to:

- Figure 1 for the plug connector
- Figure 2 for the receptacle connector.

- (4) Put the support sleeve on the cable.
Make sure that the sleeve is between the dielectric and the shield.
- (5) Put the pin or socket contact on the conductor.
- (6) Crimp the contact.
- (7) Put the outer contact on the cable.

Make sure that:

- The barrel of the outer contact is between the shield and the body of the pin or socket contact
- The pin or socket contact is locked in the body of the outer contact
- The outer contact holds the pin or socket contact in position.

- (8) Push the outer ring forward until it stops.
- (9) Crimp the outer ring.

D. Coax Contact Insertion

- (1) Put the wired contact into the rear end of the connector.
Make sure the contact is fully inserted in the connector.

20-51-31



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF SOURIAU/BURNDY HYFEN BANTAM M22T() COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers	2
	B. Coax Contact Assembly Part Numbers	2
	C. Coax Cable Part Numbers	3
2.	<u>CONNECTOR DISASSEMBLY</u>	3
	A. Contact Removal	3
3.	<u>CONNECTOR ASSEMBLY</u>	3
	A. Contact Assembly	3
	B. Contact Insertion	5
	C. Connector Assembly	5

20-51-32



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF SOURIAU/BURNDY HYFEN BANTAM M22T() COAX CONNECTORS

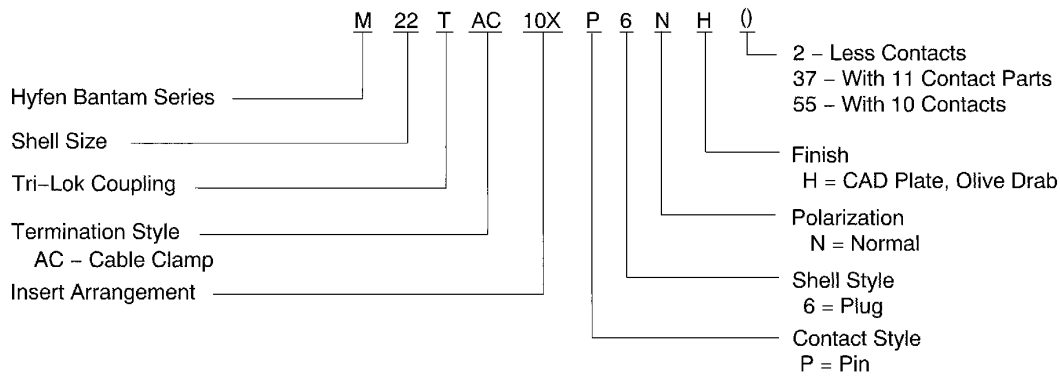
This Subject gives the procedures to assemble Souriau/Burndy Hyfen Bantam M22T() coax connectors with the specified coax cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
CONNECTOR PART NUMBERS

Part Number	Supplier
M22T()	Souriau/Burndy



2446001 S00061546139_V1

SOURIAU/BURNDY HYPHEN BANTAM M22T() COAX CONNECTOR PART NUMBER STRUCTURE

Figure 1

B. Coax Contact Assembly Part Numbers

Table 2
COAX CONTACT ASSEMBLY PART NUMBERS

Part Number	Description	Supplier
RFM26W1D28	Center Contact	Burndy
RMMX110-1D28	Contact Body	Burndy
Y0C110	Hyring Ferrule	Burndy

20-51-32



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF SOURIAU/BURNDY HYFEN BANTAM M22T() COAX CONNECTORS

C. Coax Cable Part Numbers

Table 3
COAX CABLE PART NUMBERS

Part Number	Specification	Supplier
M17/70-RG195	MIL-C-17/70	QPL

2. CONNECTOR DISASSEMBLY

A. Contact Removal

NOTE: The contact assembly:

- Is released from the front of the connector
- Cannot be repaired.

Table 4
COAX CONTACT REMOVAL TOOLS

Removal Tool	Supplier
RX8-1	Burndy

- (1) Remove the cable clamp hardware.
- (2) Make a selection of a coax contact removal tool from Table 4.
- (3) Put the tip of the removal tool over the front of the contact.
- (4) Carefully push the tool into the connector body until the contact is pushed out the rear of the connector.
- (5) If it is necessary to replace the contact:
 - (a) Cut the contact off the wire.
 - (b) Discard the contact.

3. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. Contact Assembly

Table 5
COAX CONTACT CRIMP TOOLS

Basic Unit		Die		
Part Number	Supplier	Part Number	Size	Supplier
M8ND	Burndy	N22RVMT-10	Small	Burndy

20-51-32



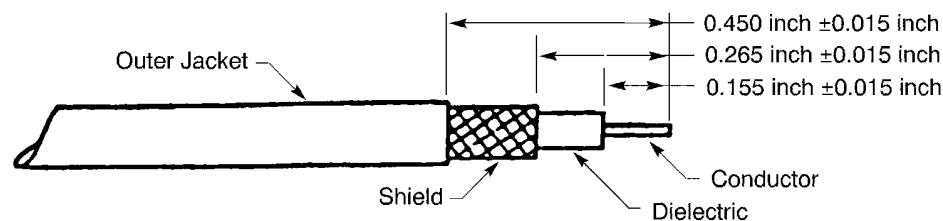
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF SOURIAU/BURNDY HYFEN BANTAM M22T() COAX CONNECTORS

Table 6
FERRULE CRIMP TOOLS

Basic Unit		Die		
Part Number	Supplier	Part Number	Size	Supplier
M8ND	Burndy	N22RVMT-10	Large	Burndy

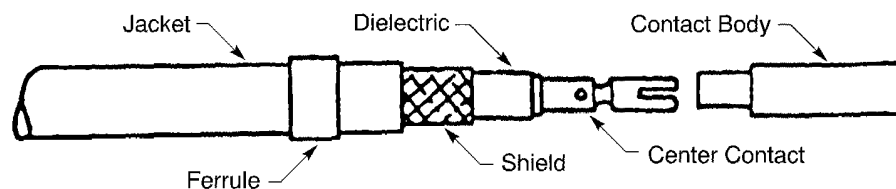
- (1) Make a selection of a contact crimp tool from Table 5.
- (2) Make a selection of a ferrule crimp tool from Table 6.
- (3) Prepare the cable. Refer to Figure 2.



2446002 S00061546140_V1

CABLE PREPARATION
Figure 2

- (a) Remove 0.450 inch \pm 0.015 inch of the outer jacket from the end of the cable.
- (b) Remove 0.265 inch \pm 0.015 inch of the shield from the end of the cable.
- (c) Remove 0.155 inch \pm 0.015 inch of the dielectric from the end of the cable.
- (4) Put the center conductor into the wire barrel of the center contact.
- (5) Crimp the contact. Refer to Figure 3.



2446003 S00061546141_V1

POSITION OF THE CENTER CONTACT
Figure 3

- (6) Put the ferrule on the cable.
- (7) Push the contact body:
 - Under the shield

20-51-32



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF SOURIAU/BURNDY HYFEN BANTAM M22T() COAX CONNECTORS

- Over the center contact until it makes a click.

- (8) Push the ferrule over the shield until the forward edge of the ferrule is against the contact body.
- (9) Crimp the ferrule.

B. Contact Insertion

NOTE: It is not necessary to install contacts into contact cavities that are not used.

- (1) Manually push the wired contact into the contact cavity.
Make sure that the contact is fully inserted.

C. Connector Assembly

- (1) Put the cable clamp on the rear of the connector.



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF BURNDY G6F12-88() COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
B. Coax Contact Part Numbers	2
2. <u>CONNECTOR DISASSEMBLY</u>	2
A. Contact Removal	2
3. <u>CONNECTOR ASSEMBLY</u>	3
A. Contact Assembly	3
B. Contact Insertion	4
4. <u>APPROVED TOOL SUPPLIERS</u>	4
A. Coax Contact Crimp Tools	4

20-51-33



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY G6F12-88() COAX CONNECTORS

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Configuration	Supplier
G6G12-88PNH	Plug	Burndy
G6G12-88SNH	Receptacle	Burndy

B. Coax Contact Part Numbers

Table 2
COAX CONTACT PART NUMBERS

Part Number	Contact Type	Supplier
RCDX60-32D28	Socket	Burndy
RMDX60-32D28	Pin	Burndy

2. CONNECTOR DISASSEMBLY

A. Contact Removal

Table 3
COAX CONTACT REMOVAL TOOLS

Contact	Removal Tool
RMDX60-32D28	RX16D11-D1
RCDX60-32D28	RX16D11-D1

CAUTION: TO AVOID ANY DAMAGE TO THE CONNECTOR GROMMET, EACH CONTACT MUST BE FULLY REMOVED ONE AT A TIME.

- (1) Make a selection of a removal tool from Table 3.

CAUTION: DO NOT USE A PAIR OF PLIERS TO REMOVE A CONTACT. DAMAGE TO THE CONTACT CAN OCCUR.

- (2) Remove the grommet compression nut or strain relief clamp.

CAUTION: DO NOT TRY TO REMOVE THE GROMMET FROM THE CONNECTOR. THE GROMMET IS BONDED TO THE SHELL.

- (3) Put the plunger of the tool in the fully retracted position.

CAUTION: IF THE PLUNGER IS NOT IN THE FULLY RETRACTED POSITION, DAMAGE CAN OCCUR TO THE CONNECTOR OR THE CONTACTS, OR BOTH.

- (4) Put the end of the removal tool on the engaging end of the contact.
(5) Push the tool into the contact cavity until it stops.

20-51-33



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY G6F12-88() COAX CONNECTORS

- (6) Hold the tool in position and lightly turn it back and forth to make sure that it is correctly engaged in the retention clip.
- (7) Push the plunger in to eject the contact from the contact cavity.
- (8) Manually remove the contact from the grommet.

3. **CONNECTOR ASSEMBLY**

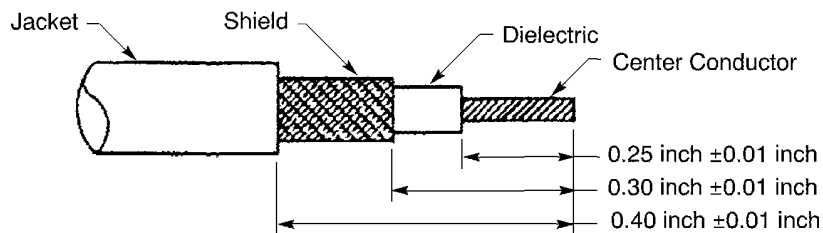
Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. **Contact Assembly**

Table 4
COAX CONTACT CRIMP TOOLS

Contact	Crimp Tool		
	Basic Unit	Die Set	Stop Bushing
RMDX60-32D28	M10S-1	S-80	SL-105
RCDX60-32D28	M10S-1	S-80	SL-105

- (1) Make a selection of a coax contact crimp tool from Table 4.
- (2) Prepare the cable. Refer to Figure 1.



2446178 S00061546147_V1

COAX CABLE PREPARATION
Figure 1

- (a) Remove 0.40 inch \pm 0.01 inch of the outer jacket from the end of the cable.
- (b) Remove 0.30 inch \pm 0.01 inch of the shield from the end of the cable.
- (c) Remove 0.25 inch \pm 0.01 inch of the dielectric from the end of the cable.
- (3) Put the center conductor in the wire barrel of the contact.
- (4) Crimp the contact.

20-51-33



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BURNDY G6F12-88() COAX CONNECTORS

B. Contact Insertion

- (1) Put each wired contact into the correct contact cavity by hand.

4. APPROVED TOOL SUPPLIERS

A. Coax Contact Crimp Tools

Table 5
CRIMP TOOL SUPPLIERS

Crimp Tool	Supplier
M10S-1	Burndy
RX16D11-D1	Burndy
S-80	Burndy
SL-105	Burndy

20-51-33



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMPHENOL 82-175 COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
B. Adapter Kit Part Numbers	2
C. Coax Cable Part Numbers	2
2. <u>CONNECTOR ASSEMBLY</u>	2
A. Contact Assembly	2
B. Connector Assembly	4

20-51-41



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMPHENOL 82-175 COAX CONNECTORS

This Subject gives the procedures to assemble the Amphenol 82-175 coax connectors with the specified coax cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Supplier
82-175	Amphenol

B. Adapter Kit Part Numbers

Table 2
ADAPTER KIT PART NUMBERS

Part Number	Description	Supplier
82-887	Adapter Kit	Amphenol

C. Coax Cable Part Numbers

Table 3
COAX CABLE PART NUMBERS

Part Number	Description	Supplier
421-593	CUJAC	Amphenol
G87T325CU	Coaxitube	Precision Tube Company

2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

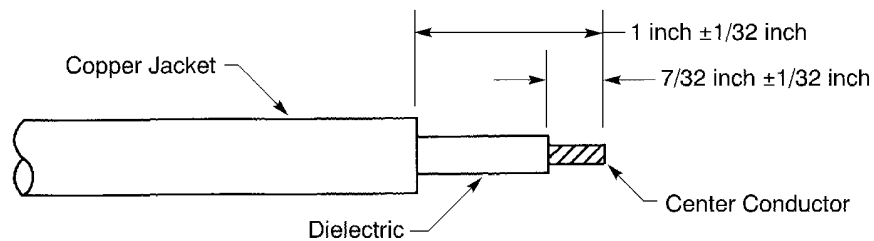
A. Contact Assembly

- (1) Remove these components from the coax connector package:
 - The jack body
 - The center contact.
- (2) Discard the remaining components.
- (3) Prepare the cable. Refer to Figure 1.

20-51-41



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMPHENOL 82-175 COAX CONNECTORS



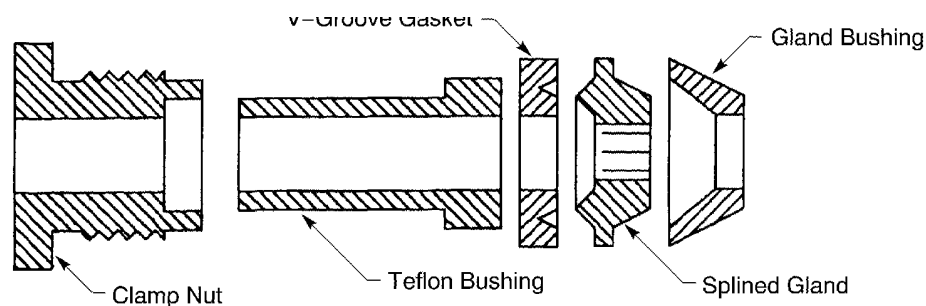
2446004 S00061546149_V1

CABLE PREPARATION

Figure 1

- (a) Cut the end of the cable.
Make sure that the end is perpendicular to the longitudinal axis.
 - (b) Lightly make a mark on the copper jacket 1 inch $\pm 1/32$ inch from the end of the cable with a tube cutter.
 - (c) Bend the cable at the mark approximately 30 degrees in each direction until the length of the copper jacket breaks at the mark.
 - (d) Remove $7/32$ inch $\pm 1/32$ inch of the dielectric from the end cable.
- (4) In order, put these components from the adapter kit on the cable:
- The clamp nut
 - The teflon bushing
 - The V-groove gasket
 - The splined gland
 - The gland bushing.

Refer to Figure 2.



2446005 S00061546150_V1

POSITION OF THE ADAPTER KIT COMPONENTS ON THE CABLE

Figure 2

- (5) Put the center contact on the center conductor.
Make sure that the end of the contact is a minimum of $1/32$ inch from the end of the dielectric.
- (6) Solder the contact.

20-51-41



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMPHENOL 82-175 COAX CONNECTORS

B. Connector Assembly

(1) Push the end of the cable into the jack body until it stops.

(2) In order, push these components into the jack body:

- The clamp nut
- The teflon bushing
- The V-groove gasket
- The splined gland
- The gland bushing.

Make sure that the components are aligned with each other.

(3) Torque the clamp nut 100 inch-pounds \pm 10 inch-pounds.

(4) Make an inspection of the center contact in relation to the dielectric.

Make sure that the forward end of the center contact is a maximum of 1/32 inch from the end of the dielectric.

20-51-41



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMPHENOL 82-3292 COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
B. Coax Cable Part Numbers	2
2. <u>CONNECTOR ASSEMBLY</u>	2
A. Cable Preparation	2
B. Connector Assembly	4
3. <u>APPROVED TOOL SUPPLIERS</u>	6
A. Crimp Tools	6

20-51-42



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMPHENOL 82-3292 COAX CONNECTORS

This Subject gives the procedure to assemble the Amphenol 82-3292 coax connectors with the specified coax cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Supplier
82-3292	Amphenol

B. Coax Cable Part Numbers

Table 2
COAX CABLE PART NUMBERS

Part Number	Supplier
BA14349	ITT Surprenant

2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for assembly of coax connectors.

A. Cable Preparation

Table 3
COAX CABLE TRIM DIMENSIONS

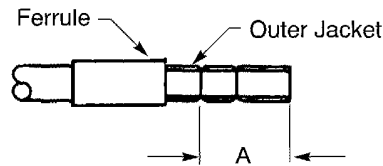
Dimension	Target (inch)	Tolerance (inch)
A	0.687	0.02
B	0.390	0.02
C	0.187	0.02
D	0.500	0.02

- (1) Cut the end of the cable.
Make sure that the end is perpendicular to the longitudinal axis of the cable.
- (2) If a ferrule is supplied, put the ferrule on the cable.
Make sure that the end with the smaller outside diameter is pointed away from the end of the cable.
- (3) Remove the necessary length of the outer jacket to make the distance from the end of the jacket to the end of the cable equal to dimension A.
Refer to Table 3 and Figure 1.

20-51-42



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMPHENOL 82-3292 COAX CONNECTORS



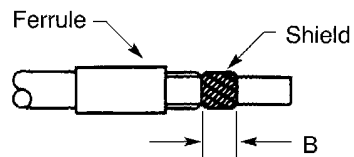
2446006 S00061546152_V1

OUTER JACKET REMOVAL LENGTH

Figure 1

- (4) Remove the necessary length of the shield to make the distance from the end of the shield to the end of the outer jacket equal to dimension B.

Refer to Table 3 and Figure 2.



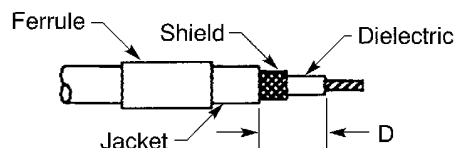
2446007 S00061546153_V1

LENGTH OF THE SHIELD

Figure 2

- (5) Remove the necessary length of the dielectric to make the distance from the end of the dielectric to the end outer jacket equal to dimension D.

Refer to Table 3 and Figure 3.



2446008 S00061546154_V1

DIELECTRIC REMOVAL LENGTH

Figure 3

20-51-42

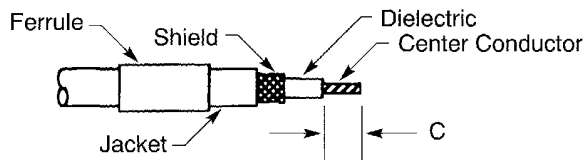


707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF AMPHENOL 82-3292 COAX CONNECTORS

- (6) Remove the necessary length of the center conductor to make the distance from the end of the conductor to the end of the dielectric equal to dimension C.

Refer to Table 3 and Figure 4.



2446009 S00061546155_V1

LENGTH OF THE CENTER CONDUCTOR

Figure 4

B. Connector Assembly

Table 4
COAX CONTACT CRIMP TOOLS

Basic Unit	Die		
	Part Number	Cavity	Dimension (inch)
227-944	-	B	0.100
M22520/5-01	227-1221-57	B	0.100

Table 5
FERRULE CRIMP TOOLS

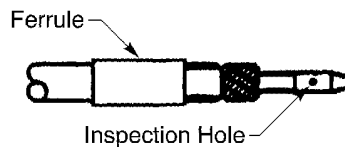
Basic Unit	Die		
	Part Number	Cavity	Dimension (inch)
227-944	-	A	0.213
M22520/5-01	227-1221-57	A	0.213

- (1) Make a selection of a crimp tool from Table 4.
- (2) Make a selection of a ferrule crimp tool from Table 5.
- (3) In this sequence, put these components on the cable:
 - The outer ferrule
 - The cable position insulator
 - The seal ring.
- (4) Put the contact on the center conductor. Refer to Figure 5.

20-51-42



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMPHENOL 82-3292 COAX CONNECTORS

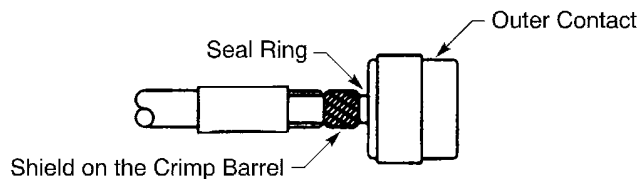


2446010 S00061546156_V1

POSITION OF THE CENTER CONDUCTOR ON THE CABLE

Figure 5

- (5) Crimp the contact.
Make sure that strands of the center conductor can be seen in the inspection hole.
- (6) Push the crimp barrel of the outer contact rearward between the dielectric and the shield until it stops. Refer to Figure 6.
Make sure that the outer contact is locked in position.



2446011 S00061546157_V1

POSITION OF THE OUTER CONTACT

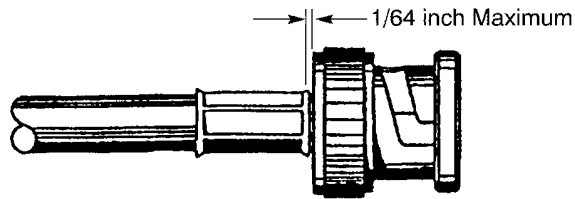
Figure 6

- (7) Make the shield smooth and symmetrical around the rear end of the crimp barrel.
- (8) Move the ferrule forward over the shield. Refer to Figure 7.
Make sure that:
- The seal ring is under the ferrule
 - The seal ring is against the shoulder of the outer contact
 - The distance from the end of the ferrule to the shoulder of the outer contact is not more than 1/64 inch.

20-51-42



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF AMPHENOL 82-3292 COAX CONNECTORS



2446012 S00061546158_V1

POSITION OF THE FERRULE AGAINST THE OUTER CONTACT
Figure 7

(9) Crimp the ferrule.

3. APPROVED TOOL SUPPLIERS

A. Crimp Tools

Table 6
CRIMP TOOL SUPPLIERS

Crimp Tool	Supplier
227-1221-57	Amphenol
227-944	Amphenol
M22520/5-01	QPL

20-51-42



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
B. Coax Cable Part Numbers	2
2. <u>CONNECTOR ASSEMBLY</u>	2
A. Cable Preparation	2
B. Inner Contact Assembly	6
C. Connector Body Assembly	7

20-51-51



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS

This subject gives the procedure to assemble the Andrews coax connectors with the specified coax cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Supplier
44ASN	Andrews
40229	Andrews

B. Coax Cable Part Numbers

Table 2
COAX CABLE PART NUMBERS

Part Number	Supplier
FSJ4-50	Andrews

2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

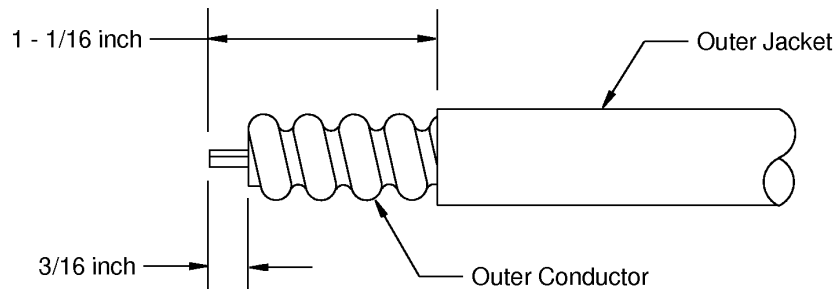
A. Cable Preparation

- (1) Cut the end of the cable.
Make sure that the end is perpendicular to the longitudinal axis of the cable.
- (2) Remove 1-1/16 inches of the outer jacket from the end of the cable. Refer to Figure 1.

20-51-51



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS



2446018 S00061546160_V1

CABLE PREPARATION

Figure 1

- (3) Remove 3/16 inch of the outer conductor from the end of the cable.
 - (a) Lightly cut around the circumference of the outer conductor with a serrated knife or an equivalent tool.

CAUTION: DO NOT CUT OR CAUSE DAMAGE TO THE INNER CONDUCTOR. DAMAGE TO THE CONDUCTOR CAN CAUSE UNSATISFACTORY PERFORMANCE.

- (b) Remove any burrs on the outer conductor with a file.
- (4) Remove 3/16 inch of the foam from the end of the cable. Refer to Figure 1.
- (5) Put the gasket on the cable. Refer to Figure 2.

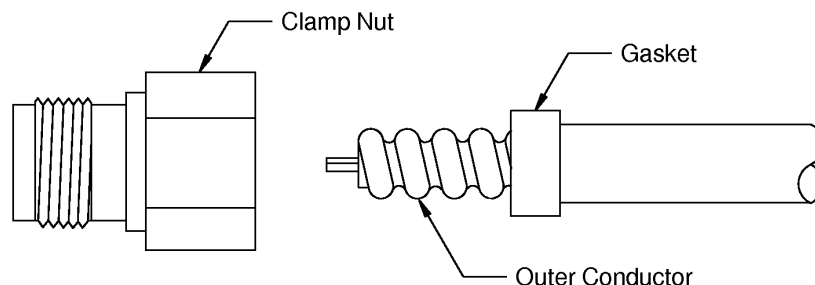
Make sure that the groove of the gasket is aligned with the corrugated groove of the outer conductor.

CAUTION: THE GASKET MUST BE AGAINST THE CORRUGATED GROOVE OF THE OUTER CONDUCTOR. A SEAL THAT IS NOT INSTALLED CORRECTLY CAN CAUSE UNSATISFACTORY PERFORMANCE.

20-51-51



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS



2446019 S00061546163_V1

POSITION OF THE GASKET ON THE CABLE

Figure 2

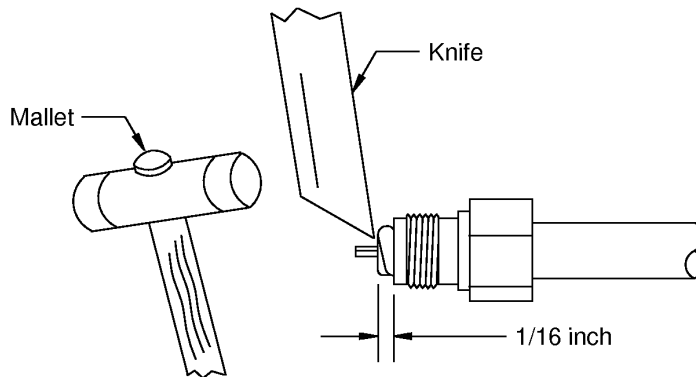
- (6) Put a thin layer of silicone grease on:
- The outside surface of the gasket
 - The inside surface of the clamp nut.
- (7) Put the clamp nut on the cable.
Make sure that the outer conductor is extended 1/16 inch from the end of the clamp nut.
- (8) Cut the edge of the outer conductor approximately 1/16 inch at 12 locations with a pair of fine wire cutters or a knife. Refer to Figure 3.
Make sure that the outer conductor is cut equally and symmetrically around the circumference.

NOTE: If a knife is used to cut the outer conductor, a mallet can be used to lightly hit the back edge of the knife.

20-51-51



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS



2446020 S00061546164_V1

LOCATIONS TO CUT THE OUTER CONDUCTOR

Figure 3

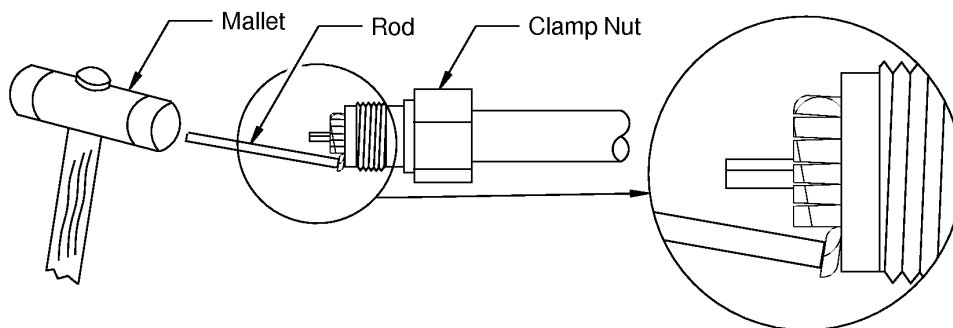
- (9) With a rod or an equivalent tool, bend each length between the locations where the outer conductor is cut. Refer to Figure 4.

Make sure that each part of the outer conductor is flat against the end of the clamp nut.

CAUTION: APPLY ONLY THE SUFFICIENT AMOUNT OF FORCE TO MAKE EACH PART OF THE END OF THE OUTER CONDUCTOR FLAT AGAINST THE CLAMP NUT. THE THICKNESS OF THE METAL MUST NOT BE DECREASED.

20-51-51

707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS



2446021 S00061546166_V1

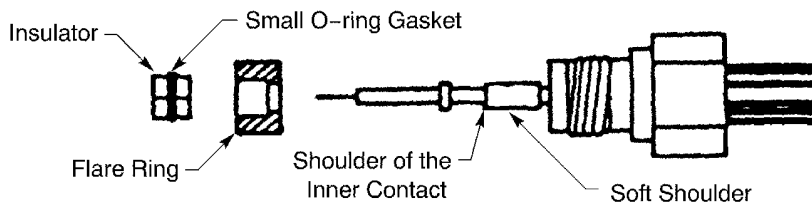
POSITION OF THE END OF THE OUTER CONDUCTOR AGAINST THE CLAMP NUT

Figure 4

- (10) Remove the unwanted parts of the outer conductor.
 Make sure that each end does not extend farther than the outside circumference of the clamp nut.

B. Inner Contact Assembly

- (1) Clean the inner conductor.
 (2) Put the inner contact on the inner conductor. Refer to Figure 5.



2446022 S00061546167_V1

INNER CONTACT ASSEMBLY

Figure 5

- (3) Temporarily put the flare ring on the inner conductor.
 Make sure that:
- The hole with the smaller diameter is pointed toward the cable
 - The rearward surface of the flare ring is flat against the shoulder of the inner contact.

20-51-51



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS

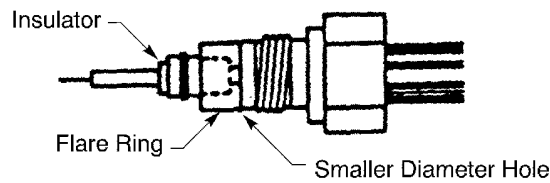
- (4) Remove the flare ring.
- (5) Solder the inner contact.

CAUTION: DO NOT APPLY MORE THAN THE NECESSARY AMOUNT OF HEAT FOR LONGER THAN THE NECESSARY AMOUNT OF TIME TO MELT THE SOLDER. DAMAGE TO THE CABLE CAN CAUSE UNSATISFACTORY PERFORMANCE.

- (6) Immediately remove any unwanted solder.
- (7) Cut the foam dielectric to align the end of the dielectric with the end of the flat end of the outer conductor.

C. Connector Body Assembly

- (1) Remove the copper particles from the foam dielectric with a small wire brush.
- (2) Put the flare ring over the inner contact. Refer to Figure 6.
Make sure that the hole with the smaller inner diameter is against the outer conductor.

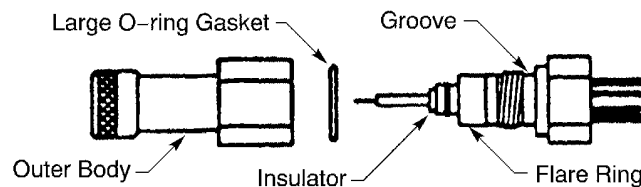


2446023 S00061546169_V1

POSITION OF THE FLARE RING AND INSULATOR

Figure 6

- (3) Push the insulator into the inner contact until it makes a click.
- (4) Put the heat shrinkable sleeve on the cable.
- (5) Put a thick layer of silicone grease on the large O-ring gasket.
- (6) Put the O-ring in the groove for the gasket on the clamp nut. Refer to Figure 7.



2446024 S00061546170_V1

CONNECTOR BODY ASSEMBLY

Figure 7

20-51-51



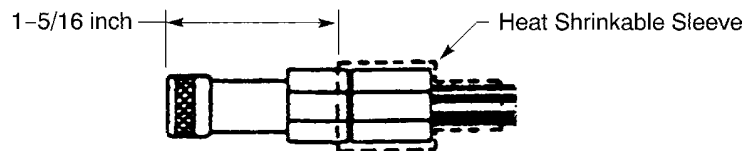
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS 44ASN AND 40229 COAX CONNECTORS

- (7) Push the outer body onto the contact assembly.
- (8) Engage the threads of the outer body and the clamp nut.
- (9) Torque the outer body 95 inch-pounds ± 5 inch-pounds.

NOTE: Hold the clamp nut in position and turn the connector body.

- (10) Push the heat shrinkable sleeve forward until the forward end of the sleeve is 1-5/16 inch from the end of the connector connector body. Refer to Figure 8.



2446025 S00061546171_V1

POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 8

- (11) Shrink the sleeve in position. Refer to Subject 20-10-14.



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers	2
2.	<u>CONNECTOR ASSEMBLY</u>	3
	A. Cable Preparation	3
	B. Center Contact Assembly	8
	C. Outer Body Installation	12
	D. Flux Residue Removal	13

20-51-52

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

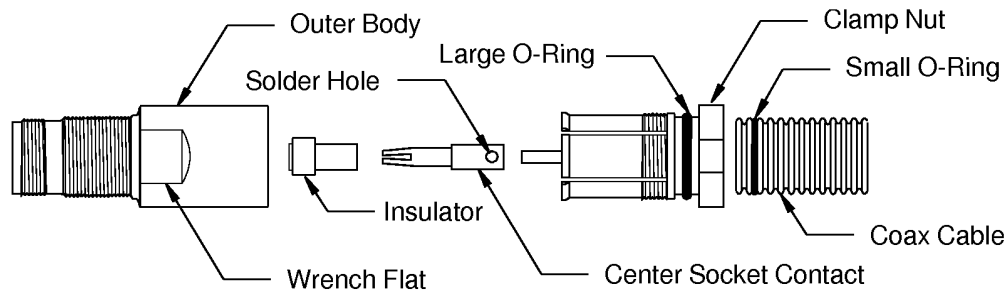
This subject gives the procedure to assemble Andrews L42ENT and L42EWT TNC coax connectors.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

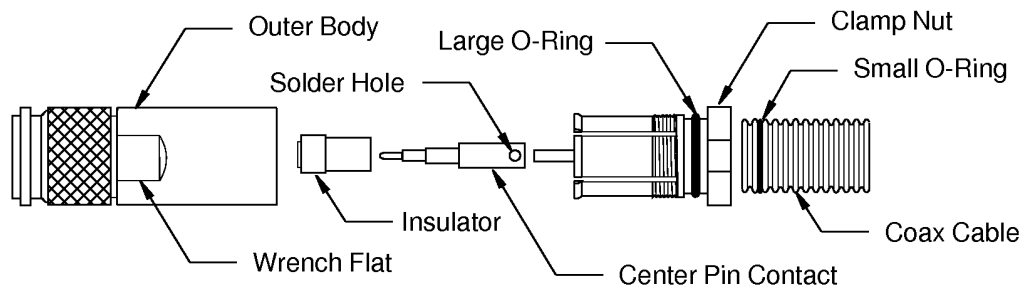
Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Type	Supplier
L42ENT	TNC Jack	Andrews
L42EWT	TNC Plug	Andrews



2449100 S00061546173_V1

L42ENT COAX JACK
Figure 1



2449101 S00061546174_V1

L42EWT COAX PLUG
Figure 2



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. Cable Preparation

Table 2
NECESSARY MATERIALS

Material	Type	Part Number or Specification	Supplier
Solvent	Alcohol, Isopropyl	TT-I-735 Grade A	An available source

Table 3
NECESSARY TOOLS

Tool	Type	Supplier
Adapter, Torque Wrench	9/16 inch	An available source
Black Stick	Small tip	An available source
Driver, Torque Wrench	55 inch-pounds minimum torque	An available source
File	Fine teeth	An available source
Knife	Sharp blade	An available source
Saw	32 teeth per inch or finer	An available source
Wiper, Absorbent	BMS15-5 or equivalent	An available source
Wrench	19/32 inch	An available source
	9/16 inch	An available source

- (1) Make a selection of a solvent from Table 2.
- (2) Make a selection of these tools from Table 3.
 - A saw
 - A file
 - A knife
 - A black stick
 - A 19/32 inch wrench
 - A 9/16 inch wrench
 - A torque wrench driver
 - A torque wrench adapter
- (3) Cut the end of the cable with a saw.

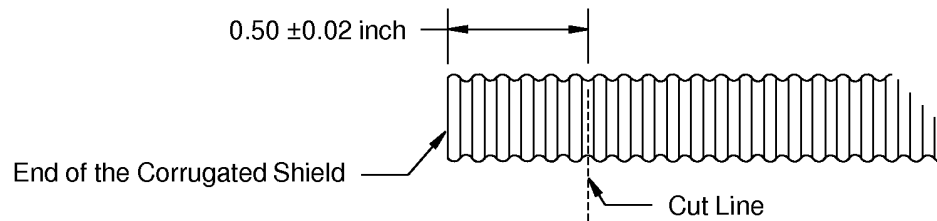
Make sure that the cut end of the cable is perpendicular to the longitudinal axis of the cable.
- (4) Remove the burrs from the end of the corrugated shield with a file
- (5) Make a cut line mark on the corrugated shield 0.50 inch \pm 0.02 inch from the end of the cable.

Refer to Figure 3.

20-51-52



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

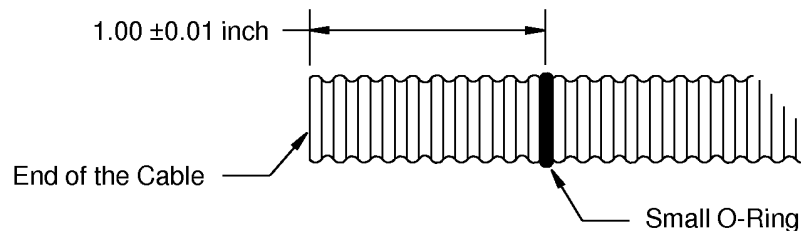


2449102 S00061546175_V1

LOCATION OF THE CUT LINE ON THE CORRUGATED SHIELD

Figure 3

- (6) Clean the corrugated shield with a wiper and the solvent.
- (7) Put the small O-ring on the cable 1.0 inch \pm 0.01 inch from the end of the cable. Refer to Figure 4.



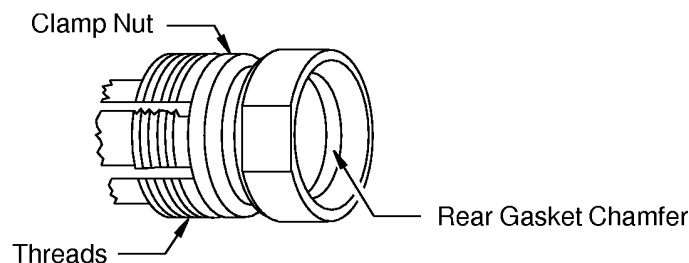
2449103 S00061546176_V1

POSITION OF THE SMALL O-RING ON THE CABLE

Figure 4

- (8) Put a thin layer of the silicone grease that is supplied with the connector on the outer surface of the O-ring.
- (9) Put a thin layer of the silicone grease around the circumference of the rear gasket chamfer of the clamp nut. Refer to Figure 5

Make sure that the grease is not put on the threads of the clamp nut.



2449104 S00061546177_V1

LOCATION OF THE SILICONE GREASE ON THE GASKET CHAMFER

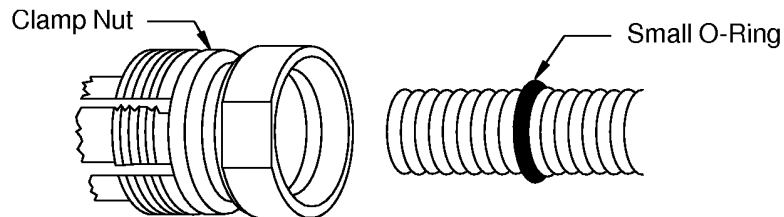
Figure 5

20-51-52

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

- (10) Align the rear end of the clamp nut and the end of the cable. Refer to Figure 6.

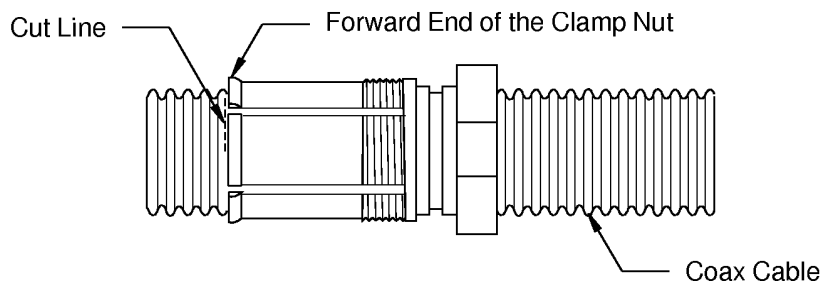


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ALIGNMENT OF THE CLAMP NUT AND THE CABLE
Figure 6

- (11) Push and twist the clamp nut on the cable until the cut mark on the corrugated shield is aligned with the forward end of the clamp nut. Refer to Figure 7.

Make sure that silicone grease is not on the center conductor or the corrugated shield.



2449106 S00061546179_V1

POSITION OF THE CLAMP NUT ON THE CABLE
Figure 7

- (12) Hold the clamp nut and lightly cut through the corrugated shield with the saw.
Make sure that the saw does not cut through the dielectric of the cable.

CAUTION: IF THE SAW CUTS THROUGH THE DIELECTRIC OF THE CABLE, DAMAGE TO THE CENTER CONDUCTOR CAN OCCUR.

- (13) Remove the rough edges from the end of the shield with a file.

Make sure that:

- The file is not put on the surfaces of the clamp nut
- The shield particles do not stay on the dielectric or the clamp nut.

- (14) Carefully remove the length of the dielectric from the forward end of the clamp nut to the end of the center conductor.

Make sure that:

- The dielectric does not extend farther than the forward end of the clamp nut
- Damage to the center conductor does not occur.

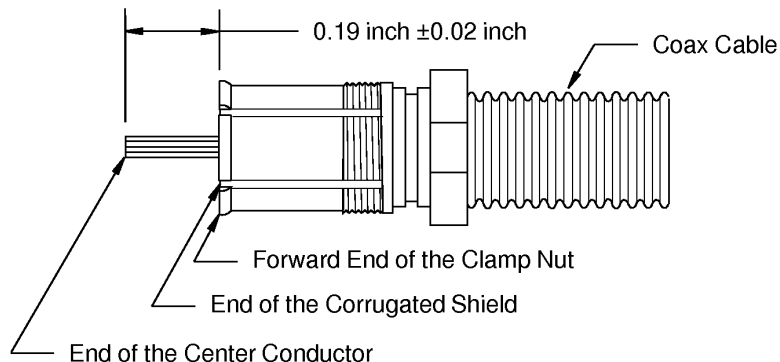


707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

CAUTION: DAMAGE TO THE CENTER CONDUCTOR CAN CAUSE UNSATISFACTORY PERFORMANCE OF THE CABLE.

- (15) Remove the necessary length of the center conductor to make the distance from the end of the clamp nut to the end of the center conductor equal to 0.19 inch ± 0.02 inch. Refer to Figure 8.



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LENGTH OF THE CENTER CONDUCTOR

Figure 8

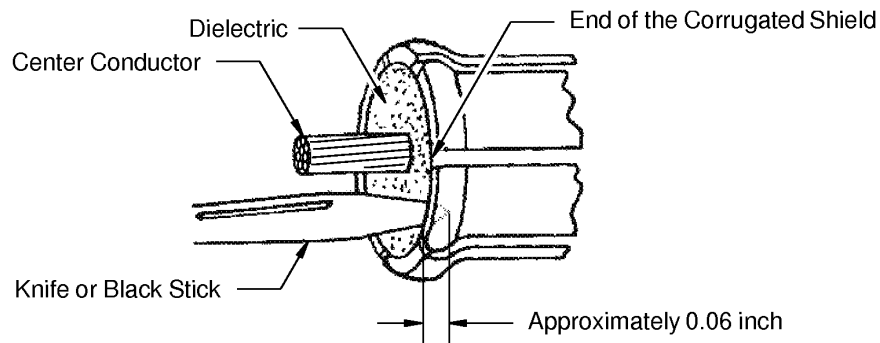
- (16) If the end of the center conductor has a burr, remove it with a file.
- (17) Make a separation between the dielectric and the shield approximately 0.06 inch deep around the circumference of the corrugated shield. Refer to Figure 9.

20-51-52



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS



2449109 S00061546183_V1

SEPARATION OF THE DIELECTRIC AND THE CORRUGATED SHIELD

Figure 9

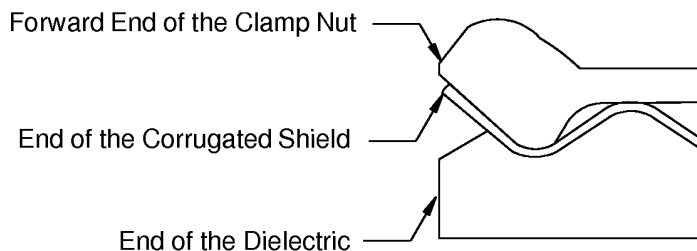
- (18) Hold the clamp nut in its position and fully engage the threads of the outer body of the connector and the clamp nut.
Make sure that the clamp nut does not turn on the coax cable.
- (19) Hold the clamp nut with the 19/32 inch wrench and torque the outer body 48 inch-pounds \pm 4 inch-pounds.
Make sure that the clamp nut does not turn on the coax cable.
- (20) Hold the clamp nut with the 19/32 inch wrench.
- (21) Loosen the outer body with the 9/16 inch wrench.
Make sure that the clamp nut does not turn on the coax cable.
- (22) Disengage the threads of the outer body and the clamp nut.
- (23) Examine the end of the corrugated shield. Refer to Figure 10.
Make sure that the shield is against the inner surface of the end of the clamp nut.

20-51-52



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS



2449110 S00061546184_V1

POSITION OF THE END OF THE CORRUGATED SHIELD AGAINST THE CLAMP NUT

Figure 10

B. Center Contact Assembly

CAUTION: THE CENTER CONDUCTOR AND THE WIRE BARREL OF THE CENTER CONTACT MUST BE TINNED BEFORE THE CONDUCTOR IS SOLDERED IN THE CONTACT. IF THE COMPONENTS ARE NOT TINNED, AN UNSATISFACTORY SOLDER JOINT OCCURS.

Table 4
NECESSARY TOOLS

Tool	Type	Idle Temperature Tolerance (degrees F)	Supplier
Solder Tool	Iron	±10	An available source
	Resistance	±10	An available source

- (1) Make a selection of the solder tools from

NOTE: For the tin operation of a contact or the solder operation of the conductor in the contact:

- The resistance solder tool is recommended
- The use of the two types of solder tools together is a satisfactory alternative.

Make sure that:

- For a solder iron, the tip of the iron does not have contamination and has a continuous film of solder
- For a resistance solder tool, the tip of each electrode does not have contamination.

WARNING: DO NOT APPLY THE ELECTRODES OF A RESISTANCE SOLDER TOOL WHILE THE POWER IS ON. AN INJURY TO PERSONNEL CAN OCCUR.

WARNING: DO NOT REMOVE THE ELECTRODES OF A RESISTANCE SOLDER TOOL WHILE THE POWER IS ON. AN INJURY TO PERSONNEL CAN OCCUR.

- (2) Tin the center conductor:

- (a) Heat the end of the conductor with a solder iron.
- (b) Apply a small amount of the solder on the end of the conductor.

20-51-52



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

- (c) Remove the heat source.
- (d) Examine the conductor.

Make sure that:

- The solder has a smooth, continuous, and shiny surface
- The dielectric is not burned
- The dielectric does not have a blister.

NOTE: A small amount of melted dielectric is normal.

- (3) Tin the wire barrel of the contact:

- (a) Heat the wire barrel of the contact with a solder tool.
- (b) Apply a small amount of the solder on the inner surface of the wire barrel.
- (c) Remove the heat source.

Make sure that the inner surface of the wire barrel has only a thin layer of solder.

- (d) Remove the remaining flux. Refer to

Make sure that remaining flux is removed in less than one hour after the solder becomes solid.

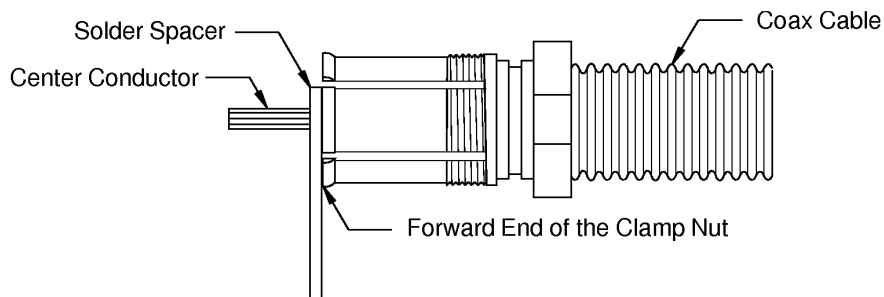
- (4) Put the solder spacer that is supplied with the connector on the center conductor adjacent to the clamp nut. Refer to Figure 11.

Make sure that:

- The center conductor is in the slot of the spacer
- The surface of the spacer is against the end of the clamp nut.



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS



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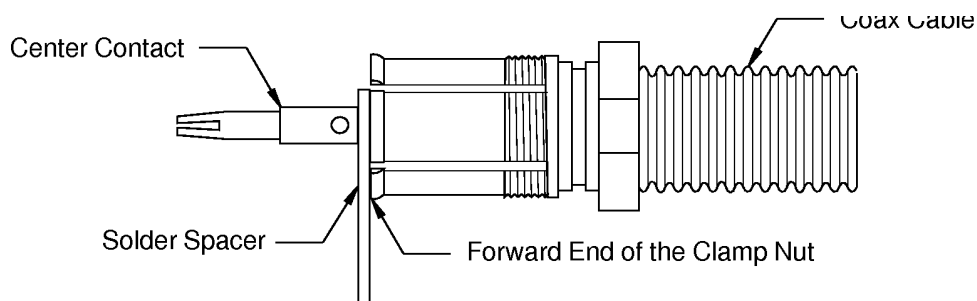
POSITION OF THE SOLDER SPACER ON THE CENTER CONDUCTOR

Figure 11

- (5) Put the center contact on the center conductor. Refer to Figure 12

Make sure that:

- The contact and the conductor are aligned axially
- The solder spacer stays against the end of the clamp nut.



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POSITION OF THE CENTER CONTACT ON THE CENTER CONDUCTOR

Figure 12

- (6) Apply the heat on the outer surface of the wire barrel. Refer to Figure 13.

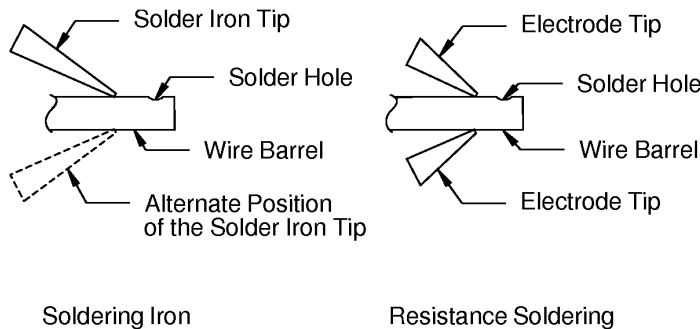
20-51-52



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS



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POSITION OF THE SOLDER TOOL ON THE CONTACT WIRE BARREL

Figure 13

- (7) Apply the solder in the solder hole until the solder level is aligned with the outer surface of the wire barrel.

- (8) Remove the heat source.

Make sure that:

- The contact and the conductor stay aligned axially
- The contact is not moved on the center conductor before the solder becomes solid.

CAUTION: AN UNSATISFACTORY SOLDER JOINT CAN OCCUR IF:

- A CONTACT IS MOVED BEFORE THE SOLDER BECOMES SOLID
- A RESISTANCE SOLDER TOOL IS NOT TURNED OFF AND THE SOLDER IS SOLID BEFORE THE ELECTRODES ARE REMOVED FROM THE WIRE BARREL.

- (9) Remove the solder spacer from the center conductor.

- (10) Remove the remaining flux. Refer to Section

Make sure that remaining flux is removed in less than one hour after the solder becomes solid.

- (11) Examine the contact assembly. Refer to Figure 14.

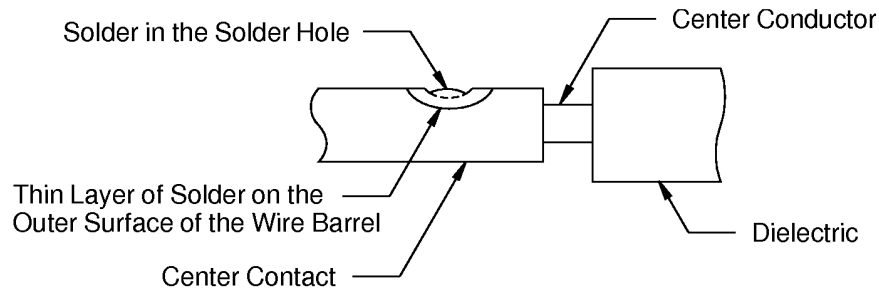
Make sure that:

- The solder in the solder hole does not extend farther than the outer surface of the wire barrel
- The wire barrel does not have more than a thin layer of solder around the circumference of the solder hole.

20-51-52

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS



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CONFIGURATION OF THE SOLDER OF THE SONTACT ASSEMBLY

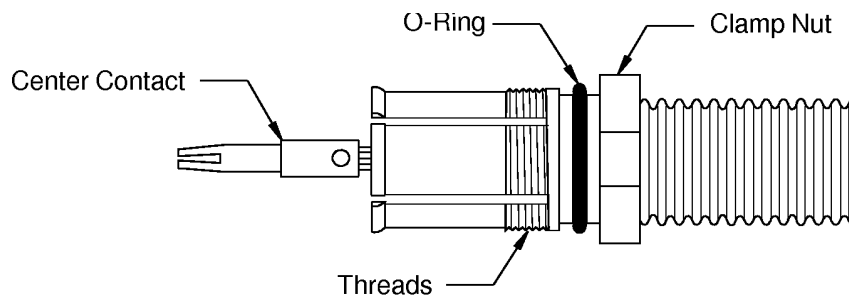
Figure 14

C. Outer Body Installation

Table 5
NECESSARY TOOLS

Tool	Type	Supplier
Adapter, Torque Wrench	9/16 inch	An available source
Driver, Torque Wrench	55 inch-pounds minimum torque	An available source
Wrench	19/32 inch	An available source
	9/16 inch	An available source

- (1) Make a selection of these tools from Table 5:
 - A 19/32 inch wrench
 - A 9/16 inch wrench
 - A torque wrench driver
 - A torque wrench adapter
- (2) Put the large O-ring in the slot near the rear end of the clamp nut. Refer to Figure 15.



2449118 S00061546193_V1

POSITION OF THE O-RING ON THE CLAMP NUT

Figure 15

- (3) Put a thin layer of the silicone grease that is supplied with the connector on the outer surface of the O-ring.

20-51-52

707, 727-787 STANDARD WIRING PRACTICES MANUAL

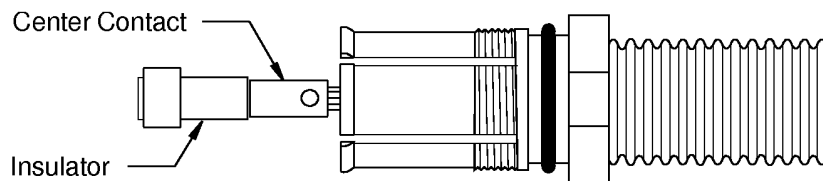
ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

Make sure that the grease is not put on:

- The threads of the clamp nut
- The center contact.

- (4) If the insulator is not installed in the outer body, put the insulator on the center contact. Refer to Figure 16.

Make sure that the end of the insulator that has the larger hole is put on the contact first.



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POSITION OF THE INSULATOR ON THE CENTER CONTACT

Figure 16

- (5) Hold the clamp nut in its position and fully engage the threads of the outer body of the connector and the clamp nut.

Make sure that the clamp nut does not turn on the coax cable.

- (6) Hold the clamp nut with the 19/32 inch wrench and torque the outer body 48 inch-pounds \pm 4 inch-pounds.

Make sure that the clamp nut does not turn on the coax cable.

D. Flux Residue Removal

Flux residue must be removed in less than one hour after the solder becomes solid.

**Table 6
NECESSARY MATERIALS**

Material	Type	Part Number or Specification	Supplier
Solvent	Alcohol, Isopropyl	TT-I-735Grade A	An available source

**Table 7
NECESSARY TOOLS**

Tool	Type	Supplier
Brush	Natural bristle, compatible with the applicable solvent	An available source
Wiper, Absorbent	BMS15-5 or equivalent	An available source

- (1) Make a selection of a solvent from Table 6:
- (2) Make a selection of these tools from Table 7.
- A brush

20-51-52



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF ANDREWS L42ENT AND L42EWT TNC COAX CONNECTORS

- An absorbent wiper.
- (3) Rub the area to be cleaned with the brush and solvent.
- (4) Rinse the area with new solvent.
- (5) Let the area dry for 5 minutes minimum.

NOTE: As an alternative, the area can be dried with clean compressed air.



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

TABLE OF CONTENTS

<u>PARAGRAPH</u>	<u>PAGE</u>
1. <u>PART NUMBERS AND DESCRIPTION</u>	2
A. Connector Part Numbers	2
2. <u>CONNECTOR ASSEMBLY</u>	4
A. Connector Assembly	4
3. <u>CONNECTOR INSTALLATION</u>	13
A. Plug Connector Installation	13

20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

This subject gives the procedure to assemble BACC64BT and BACC64BW coaxial connectors supplied by Radiall.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
CONNECTOR PART NUMBERS

Connector				Applicable Coax Cable
Part Number	Type	Configuration	Supplier	
BACC64BW2	TNC Coax Plug	Straight	Boeing	BMS13-65 Type 0F
BACC64BW3	TNC Coax Plug	Straight	Boeing	BMS13-65 Type 0G
BACC64BW4	TNC Coax Plug	Straight	Boeing	BMS13-65 Type 0H
BACC64BW5	TNC Coax Plug	Straight	Boeing	BMS13-65 Type 0J
BACC64BW6	TNC Coax Plug	Straight	Boeing	BMS13-65 Type 0K
BACC64BT2	TNC Coax Plug	Right Angle	Boeing	BMS13-65 Type 0F
BACC64BT3	TNC Coax Plug	Right Angle	Boeing	BMS13-65 Type 0G
BACC64BT4	TNC Coax Plug	Right Angle	Boeing	BMS13-65 Type 0H
BACC64BT5	TNC Coax Plug	Right Angle	Boeing	BMS13-65 Type 0J
BACC64BT6	TNC Coax Plug	Right Angle	Boeing	BMS13-65 Type 0K

Table 2
ALTERNATIVE CONNECTOR PART NUMBERS

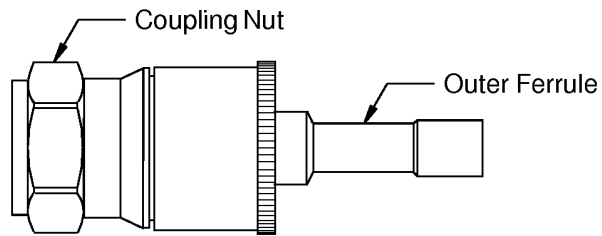
Specified Connector		Alternative Connector	
Part Number	Supplier	Part Number	Supplier
BACC64BW2	Boeing	R143017510	Radiall
BACC64BW3	Boeing	R143017520	Radiall
BACC64BW4	Boeing	R143017530	Radiall
BACC64BW5	Boeing	R143017540	Radiall
BACC64BW6	Boeing	R143017560	Radiall
BACC64BT2	Boeing	R143197510	Radiall
BACC64BT3	Boeing	R143197520	Radiall
BACC64BT4	Boeing	R143197530	Radiall
BACC64BT5	Boeing	R143197540	Radiall
BACC64BT6	Boeing	R143197560	Radiall

20-51-60



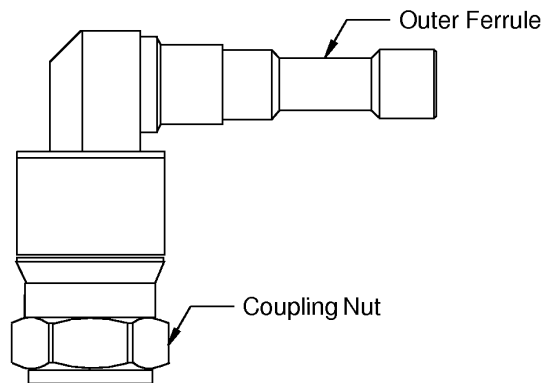
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL



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BACC64BW TNC COAX PLUG
Figure 1



2449445 S00061546197_V1

BACC64BT TNC COAX PLUG
Figure 2

20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

2. CONNECTOR ASSEMBLY

Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. Connector Assembly

Table 3
COAX CABLE TRIM DIMENSIONS

Connector Part Number	Cable Trim Dimensions (inch)		
	A ± 0.01	B ± 0.01	C ± 0.01
BACC64BW2	0.74	0.47	0.23
BACC64BW3	0.86	0.59	0.23
BACC64BW4	0.90	0.59	0.21
BACC64BW5	0.68	0.33	0.23
BACC64BW6	0.76	0.33	0.23
BACC64BT2	0.70	0.43	0.19
BACC64BT3	0.74	0.47	0.19
BACC64BT4	0.76	0.45	0.19
BACC64BT5	0.76	0.41	0.19
BACC64BT6	0.74	0.31	0.23

Table 4
CENTER CONTACT CRIMP TOOLS

Connector Part Number	Tool Frame or Actuator		Locator		Setting
	Part Number	Supplier	Part Number	Supplier	
BACC64BW2	M22520/1-01	QPL	R282589102	Radiall	5
	WA27F	Daniels	R282589102	Radiall	5
BACC64BW3	M22520/1-01	QPL	R282589104	Radiall	6
	WA27F	Daniels	R282589104	Radiall	6
BACC64BW4	M22520/1-01	QPL	R282589106	Radiall	8
	WA27F	Daniels	R282589106	Radiall	8
BACC64BW5	M22520/1-01	QPL	R282589108	Radiall	8
	WA27F	Daniels	R282589108	Radiall	8
BACC64BW6	M22520/1-01	QPL	R282589110	Radiall	8
	WA27F	Daniels	R282589110	Radiall	8
BACC64BT2	M22520/1-01	QPL	R282589103	Radiall	5
	WA27F	Daniels	R282589103	Radiall	5

20-51-60



707, 727-787

STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

Table 4 CENTER CONTACT CRIMP TOOLS (Continued)

Connector Part Number	Tool Frame or Actuator		Locator		Setting
	Part Number	Supplier	Part Number	Supplier	
BACC64BT3	M22520/1-01	QPL	R282589105	Radiall	6
	WA27F	Daniels	R282589105	Radiall	6
BACC64BT4	M22520/1-01	QPL	R282589107	Radiall	8
	WA27F	Daniels	R282589107	Radiall	8
BACC64BT5	M22520/1-01	QPL	R282589109	Radiall	8
	WA27F	Daniels	R282589109	Radiall	8
BACC64BT6	M22520/1-01	QPL	R282589111	Radiall	8
	WA27F	Daniels	R282589111	Radiall	8

Table 5
OUTER FERRULE CRIMP TOOLS

Connector Part Number	Tool Frame or Actuator			Die	
	Part Number	Tool Safety Guard	Supplier	Part Number	Supplier
BACC64BW2	HX23	HX23-32M The HX23-32M safety guard must be used instead of the supplied safety guard to crimp the BACC64BW and BACC64BT connectors with the R28223530() dies .	Daniels	R282235301	Radiall
BACC64BW3	HX23		Daniels	R282235302	Radiall
BACC64BW4	HX23		Daniels	R282235303	Radiall
BACC64BW5	HX23		Daniels	R282235304	Radiall
BACC64BW6	HX23		Daniels	R282235305	Radiall
BACC64BT2	HX23		Daniels	R282235301	Radiall
BACC64BT3	HX23		Daniels	R282235302	Radiall
BACC64BT4	HX23		Daniels	R282235303	Radiall
BACC64BT5	HX23		Daniels	R282235304	Radiall
BACC64BT6	HX23		Daniels	R282235305	Radiall

- (1) Cut the end of the cable perpendicular to the longitudinal axis of the cable.

Make sure that the cut end of the cable has a round cross-section. If the end of the cable does not have a round cross-section, damage to the O-ring inside the outer ferrule can occur.

- (2) Push the outer ferrule onto the cable.

Make sure that the end of the outer ferrule that has the larger diameter points forward to the end of the cable.

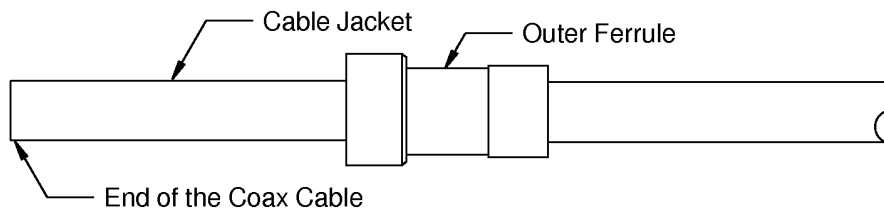
Refer to Figure 3.

20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL



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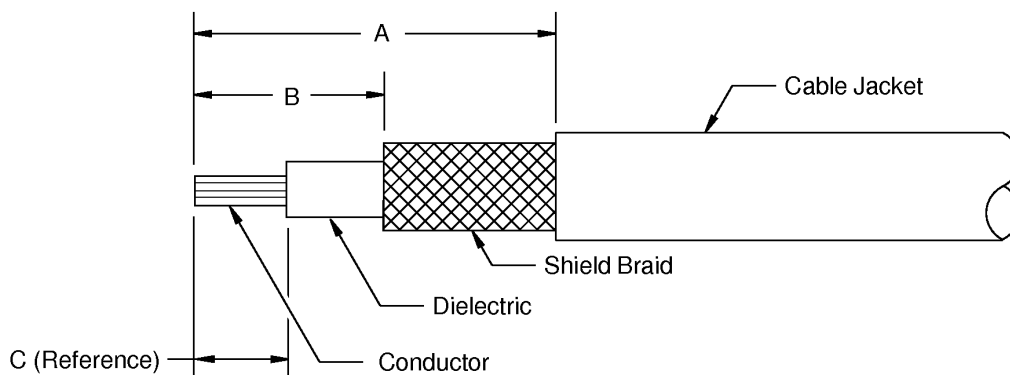
POSITION OF THE OUTER FERRULE ON THE CABLE

Figure 3

- (3) Prepare the end of the cable.

Refer to:

- Table 3
- Figure 4.



2449434 S00061546199_V1

COAX CABLE TRIM DIMENSIONS

Figure 4

- (a) Remove the necessary length of the cable jacket.
Make sure that the distance from the end of the jacket to the end of the cable is dimension A.
- (b) Remove the necessary length of the round shield and the flat shield.
Make sure that:

20-51-60

707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

- The distance from the end of the shields to the end of the cable is dimension B.
- Damage to the dielectric does not occur.

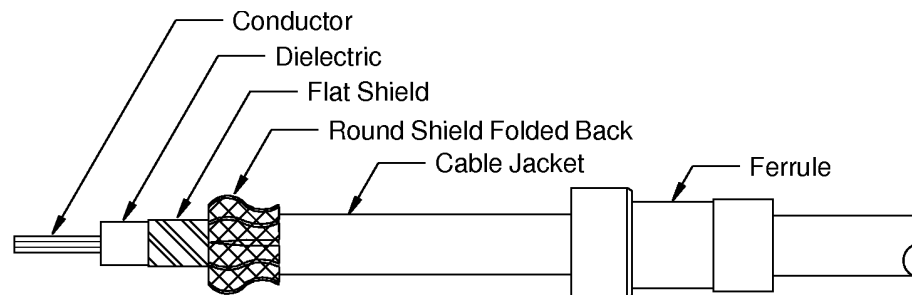
(c) Remove the necessary length of the dielectric.

Make sure that the distance from the end of the dielectric to the end of the cable is dimension C.

Refer to Figure 4.

(4) Fold the round shield back onto the cable jacket.

Refer to Figure 5.



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POSITION OF THE ROUND SHIELD FOLDED BACK ON THE CABLE JACKET

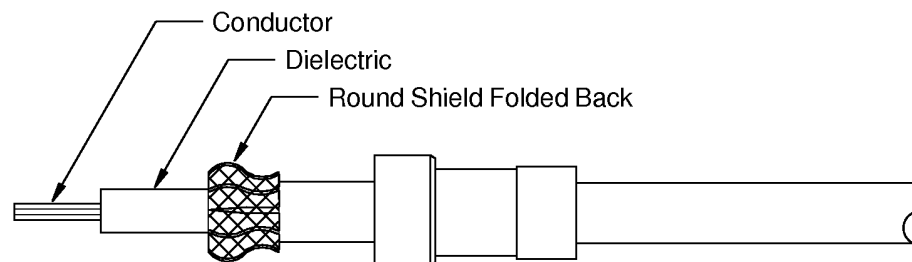
Figure 5

(5) Remove the unwanted length of the flat shield.

Make sure that the end of the flat shield is aligned with the forward edge of the folded round shield.

Refer to Figure 6.

CAUTION: DO NOT CAUSE DAMAGE TO THE DIELECTRIC OR THE ROUND BRAID.



2449436 S00061546202_V1

FLAT SHIELD REMOVED

Figure 6

(6) Assemble the center contact on the conductor:

- Make a selection of a center contact crimp tool from Table 4.
- Push the conductor into the crimp barrel of the center contact until it stops.

20-51-60

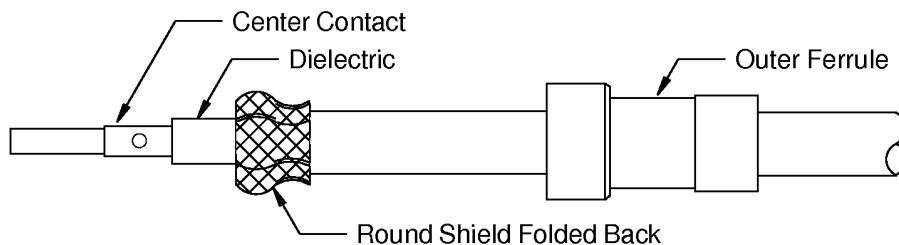
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

Make sure that all of the conductor strands are in the crimp barrel.

- (c) Crimp the contact.

Refer to Figure 7.



2449437 S00061546203_V1

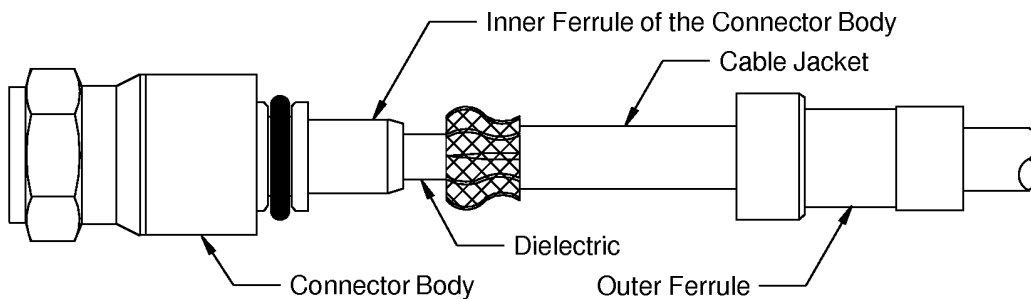
POSITION OF THE CENTER CONTACT ON THE CONDUCTOR

Figure 7

- (7) Push the center contact and the cable into the inner ferrule of the connector body until it stops.

Refer to:

- Figure 8
- Figure 9.



2449438 S00061546204_V1

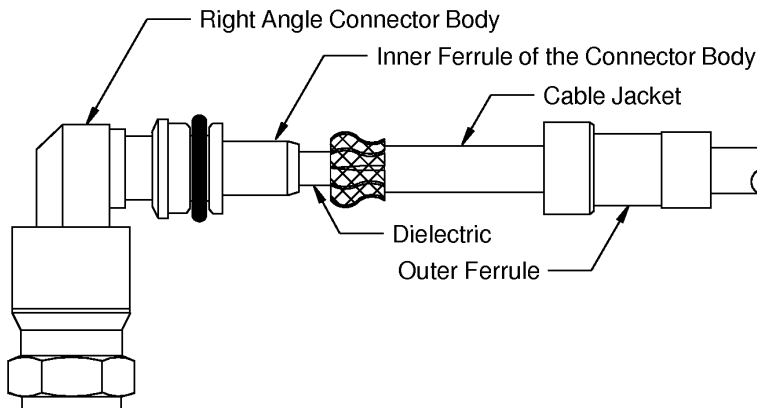
POSITION OF THE CABLE IN THE STRAIGHT CONNECTOR BODY

Figure 8



**707, 727-787
STANDARD WIRING PRACTICES MANUAL**

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL



2449439 S00061546205_V1

POSITION OF THE CABLE IN THE RIGHT ANGLE CONNECTOR BODY

Figure 9

- (8) Fold the round shield braid forward on the inner ferrule of the connector body.

Make sure that:

- The strands of the shield are applied evenly around the outside of the inner ferrule
- The forward edge of the shield strands is not on the rear shoulder of the connector body.

Refer to:

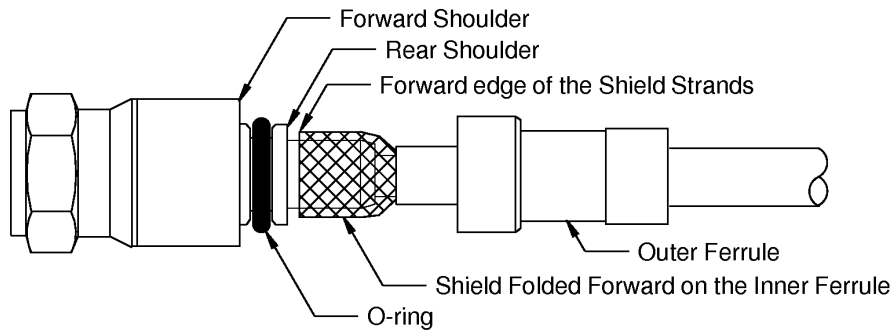
- Figure 10
- Figure 11.

20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL

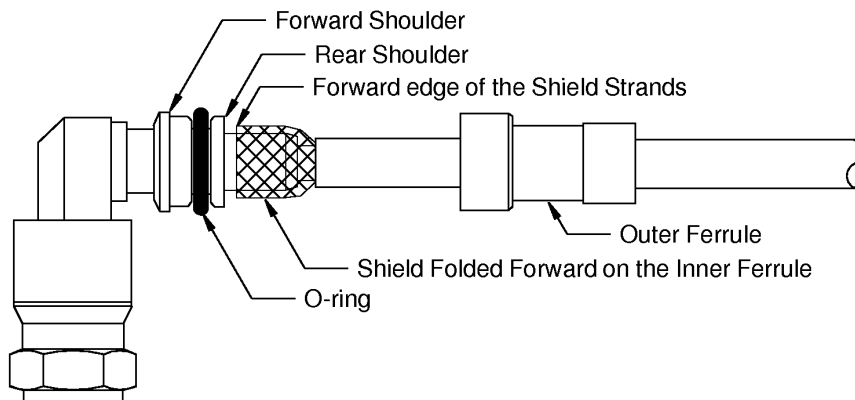
ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL



2449440 S00061546206_V1

POSITION OF THE ROUND SHIELD BRAID ON THE INNER FERRULE OF THE STRAIGHT CONNECTOR

Figure 10



2449441 S00061546207_V1

POSITION OF THE ROUND SHIELD BRAID ON THE INNER FERRULE OF THE RIGHT ANGLE CONNECTOR

Figure 11

20-51-60

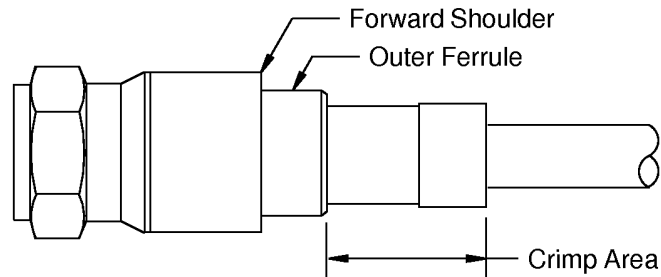
707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

- (9) Push the outer ferrule forward on the shield, and on the O-ring until it stops against the forward shoulder of the connector body.

Refer to:

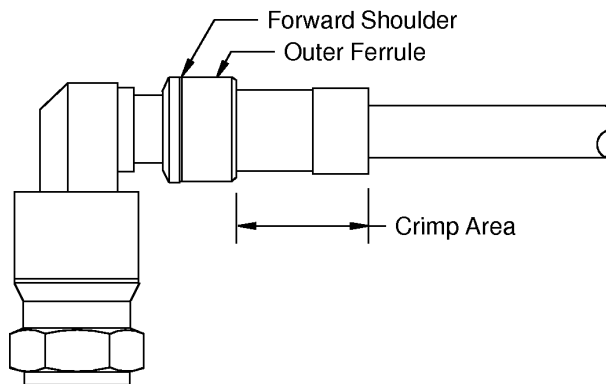
- Figure 12
- Figure 13.



2449442 S00061546208_V1

POSITION OF THE OUTER FERRULE AGAINST THE FORWARD SHOULDER OF THE STRAIGHT CONNECTOR

Figure 12



2449443 S00061546209_V1

POSITION OF THE OUTER FERRULE AGAINST THE FORWARD SHOULDER OF THE RIGHT ANGLE CONNECTOR

Figure 13

- (10) Make a selection of an outer ferrule crimp tool from Table 5.
- (11) Crimp the outer ferrule.

Refer to:

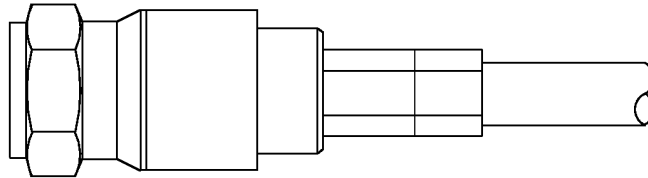
20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL

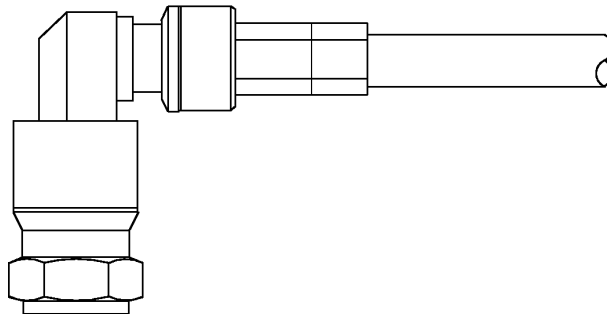
ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

- Figure 12
- Figure 13
- Figure 14
- Figure 15.



2449446 S00061546210_V1

CONFIGURATION OF THE CRIMP OF THE OUTER FERRULE OF THE STRAIGHT CONNECTOR
Figure 14



2449447 S00061546211_V1

CONFIGURATION OF THE CRIMP OF THE OUTER FERRULE OF THE RIGHT ANGLE CONNECTOR
Figure 15

20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF BACC64BT, BACC64BW TNC COAX CONNECTORS SUPPLIED BY RADIAL

3. CONNECTOR INSTALLATION

A. Plug Connector Installation

Table 6
CONNECTOR INSTALLATION TOOLS

Tool	Part Number	Supplier
Torque Wrench	-	Any source
Wrench	76-101	Balmar
	ST2580-570	Boeing
	TG-70	Glenair

Table 7
PLUG CONNECTOR TORQUE VALUES

Connector	Torque Value (inch-pounds)	
	Minimum	Maximum
BACC64BT	15	17
BACC64BW	15	17

- (1) Make a selection of a torque wrench from Table 6.
- (2) Make a selection of a wrench from Table 6.
- (3) Fully engage the threads of the plug and the jack.
- (4) Tighten the plug to the specified torque value. Refer to Table 7.
- (5) If lockwire or safety wire is specified, refer to Subject 20-60-07.

20-51-60



707, 727-787
STANDARD WIRING PRACTICES MANUAL
ASSEMBLY OF CABLEWAVE COAX CONNECTORS

TABLE OF CONTENTS

<u>PARAGRAPH</u>		<u>PAGE</u>
1.	<u>PART NUMBERS AND DESCRIPTION</u>	2
	A. Connector Part Numbers	2
	B. Coax Cable Part Numbers	2
2.	<u>CONNECTOR ASSEMBLY</u>	2
	A. Cable Preparation	2
	B. Connector Assembly	4

20-51-90



707, 727-787 STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF CABLEWAVE COAX CONNECTORS

This subject gives the procedure to assemble the specified Cablewave coax connectors with the specified coax cables.

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
COAX CONNECTOR PART NUMBERS

Part Number	Supplier
75-500	Cablewave
76-500	Cablewave

B. Coax Cable Part Numbers

Table 2
COAX CABLE PART NUMBERS

Part Number	Description	Supplier
64-500	Coax Cable, Aluminum Sheath	Prodelin

2. CONNECTOR ASSEMBLY

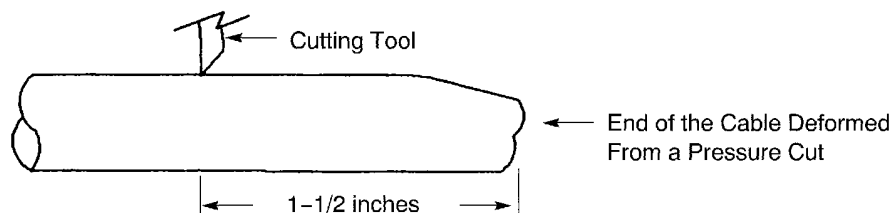
Refer to Subject 20-51-00 for the general conditions that are applicable for the assembly of coax connectors.

A. Cable Preparation

- (1) Make a selection of a tube cutting tool with a flat-sided blade.
- (2) Cut through the cable jacket and the outer conductor 1-1/2 inches from the end of the cable. Refer to Figure 1.

Make sure the flat side of the blade is opposite of the end of the cable.

CAUTION: TO PREVENT DEFORMATION OF THE OUTER CONDUCTOR, A FLAT-SIDED BLADE MUST BE USED.



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CABLE JACKET AND OUTER CONDUCTOR REMOVAL
Figure 1

- (3) Cut the hollow dielectric cores at the end of the outer conductor.

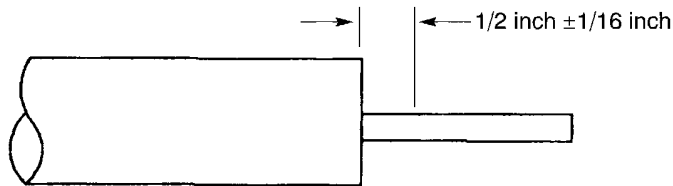
20-51-90



707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF CABLEWAVE COAX CONNECTORS

- (4) Remove the sheath and the core.
- (5) Cut the inner conductor $1/2$ inch $\pm 1/16$ inch from the end of the outer conductor. Refer to Figure 2.



2446287 S00061546215_V1

INNER CONDUCTOR PREPARATION

Figure 2

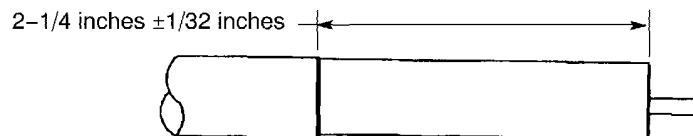
- (6) Hold the cable down and file the end of inner conductor to make the radius equal to or more than $1/32$ inch.

NOTE: The inner conductor is the center contact.

CAUTION: MAKE SURE THAT NO PARTICLES GO INTO THE HOLLOW DIELECTRIC CORE.

- (7) Cut the outer jacket $2-1/4$ inches $\pm 1/32$ inch from the end of the outer conductor. Refer to Figure 3.
- (8) Remove the jacket.

CAUTION: MAKE SURE THAT DAMAGE TO THE OUTER CONDUCTOR DOES NOT OCCUR WHEN THE JACKET IS REMOVED.



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OUTER JACKET REMOVAL LENGTH

Figure 3

20-51-90

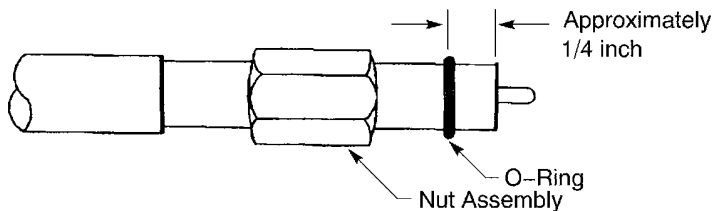


707, 727-787
STANDARD WIRING PRACTICES MANUAL

ASSEMBLY OF CABLEWAVE COAX CONNECTORS

B. Connector Assembly

- (1) Put the nut assembly of connector on the cable.
- (2) Put the O-Ring approximately 1/4 inch from the end of the cable. Refer to Figure 4.



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POSITION OF THE O-RING

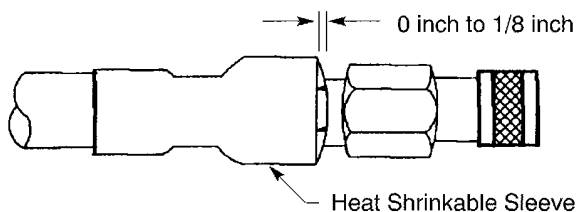
Figure 4

- (3) Hold the connector body against the end of the cable.
- (4) Engage the threads of the connector body and the nut assembly.
- (5) Manually tighten the nut.
- (6) Make one additional turn of the nut with a wrench.

CAUTION: ONLY THE NUT MUST BE TURNED. DO NOT TURN THE CONNECTOR BODY.

- (7) Put a 3 inch to 4 inch length of 1 inch diameter heat shrinkable sleeve on the assembly. Refer to Figure 5.

Make sure that the forward edge of the sleeve is 0 inch to 1/8 inch from the edge of the nut assembly.



2446290 S00061546221_V1

POSITION OF THE HEAT SHRINKABLE SLEEVE

Figure 5

- (8) Shrink the sleeve in position. Refer to Subject 20-10-14.

20-51-90