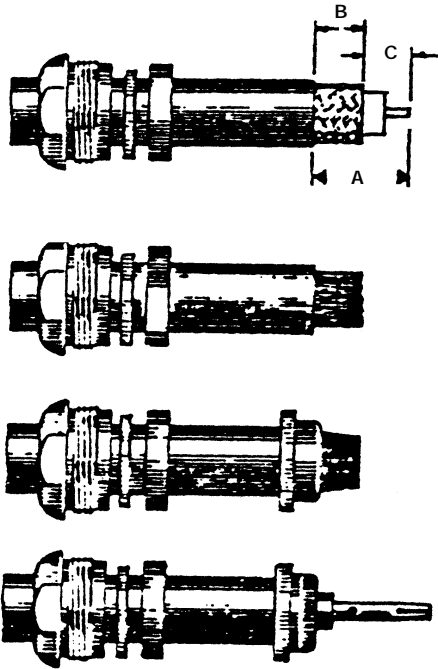


Stripping dims. inches (millimeters)

Amphenol Part #	a	b	c
82-804	1.00 (25.4)	.781 (19.8)	.219 (5.6)
82-856	.680 (17.3)	.34 (8.6)	.09 (2.3)
82-324	1.59 (40.4)	.875 (22.2)	.718 (18.2)



Place nut, gland, and gasket, with "V" groove toward nut, over cable and strip cable to dimensions as shown in table.

Comb out braid and fold out.

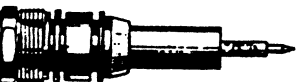
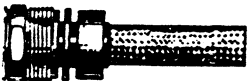
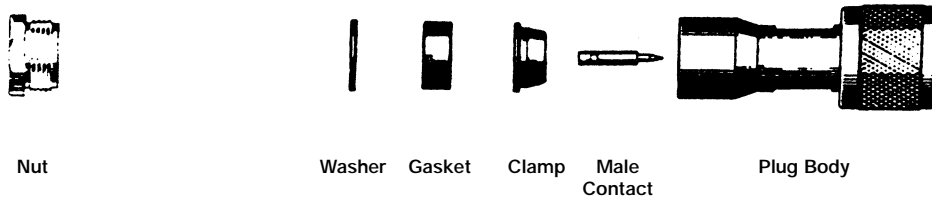
Pull braid wires forward and taper toward center conductor. Place clamp over braid and push back against cable jacket.

Fold back braid wires as shown, trim to proper length and form over clamp as shown. Solder contact to center conductor.

Insert cable and parts into connector body, make sure sharp edge of clamp seats properly in gasket. Tighten nut.
Recommended Torque: 35-40 in lbs.

Assembly Instructions-C18

HN - Typical Clamp



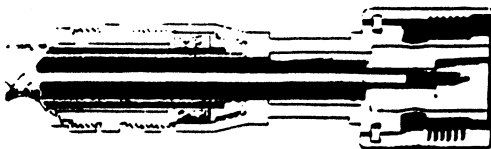
Stripping dims. inches (millimeters)

Amphenol Part #	a	b	c
16750	.799 (20.2)	.594 (15.1)	.203 (5.8)
82-816-1000	.843 (21.4)	.625 (15.9)	.218 (5.5)

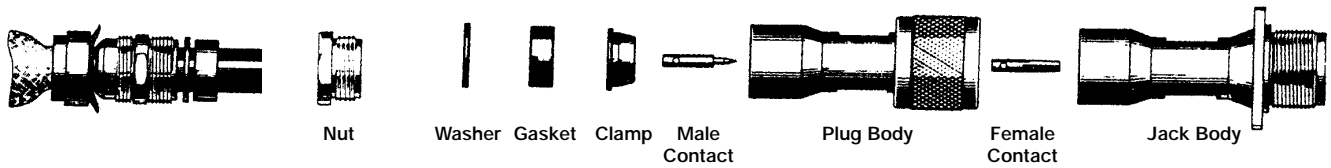
Push nut, washer and gasket over cable jacket.

Cut cable even to dimensions shown in table.

Push clamp over copper braid, flush against cable jacket. Cut exposed copper braid so that approximately 3/16 remains and fan over clamp. Trim braid even with end of taper. Cut cable dielectric (dim c) from end of cable cut. Tin exposed conductor.



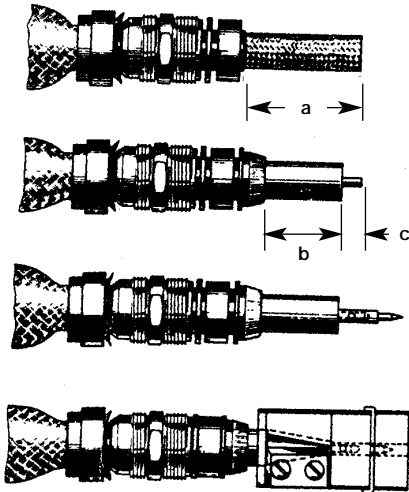
Solder contact pin to conductor. Do not overheat dielectric. Do not use excess solder. Wipe clean; see that dielectric is free from solder, resin and foreign material. Tighten nut to recommended torque 35-40 in lbs securely with wrench.



Cut end of cable even. Push nut, washer and gasket over cable jacket.

Stripping dims. inches (millimeters)

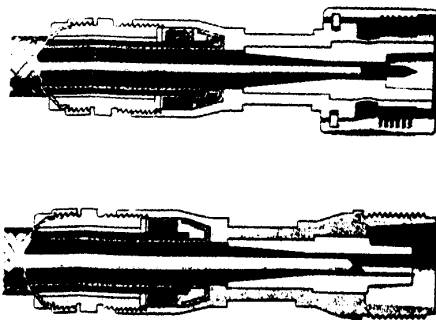
Amphenol Part #	a	b	c
82-38	1.0 (25.4)	.781 (19.8)	.219 (5.6)



Remove vinyl jacket .798" (20.3) from end of cable. For double shield cables, remove vinyl jacket 1 3/16" (30.2) from end of cable.

Push clamp over copper braid, flush against cable jacket. Cut exposed copper braid so that approximately .219" (5.6) remains and fan over clamp. Trim braid even with end of taper. Cut cable dielectric to Dim c.

Solder contact pin to conductor. Do not overheat dielectric. Do not use excess solder. Wipe clean; see that dielectric is free from solder, resin and foreign material.



Taper dielectric with AMPHENOL 103-301 (MX-103/U) trimming tool. When tapering dielectric of cable for plug assembly, push contact stop of tool to bottom of slot. Tool will stop cutting when shoulder of contact butts against stop. Cable will be properly tapered when end of center contact is flush with end of trimmer body.

Apply small amount of Dow Corning DC-4 Silicone Compound or equivalent (per MIL-S-8660) on tapered surface of dielectric. Insert assembly into connector body. Tighten nut securely with wrench.