

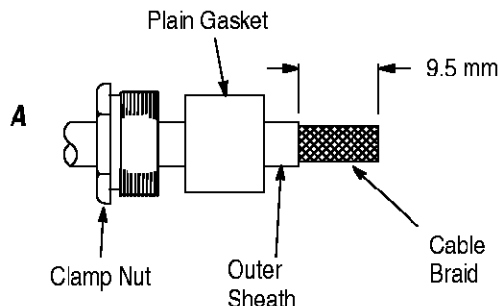
**CONNECTOR PART NUMBERS:**

1311378-1, 1311379-1, 1362489-1, 1312569-1, 1328580-1,  
and 1331180-1

**CABLE SIZE AND TYPE:**

URM 43, URM 76, RG58, RG141, RG55, RG142, RG223,  
RG400, and RG303

Figure 1



**1. INTRODUCTION**

These instructions contain the assembly procedures for the TNC straight connectors listed in Figure 1. Refer to Figure 1 for the size and type of cable specific to these connectors.

**NOTE**

*Dimensions on this sheet are in metric units.*

**2. ASSEMBLY PROCEDURES**

**NOTE**

*Although a TNC plug is illustrated, these instructions apply to both plugs and jacks. The shape of contacts and insulators will vary.*

1. Slide the clamp nut and plain gasket over the cable. Trim the outer sheath from cable as shown, exposing the cable braid, as shown in Figure 2,A.

**DANGER**

*To avoid personal injury, always wear protective gloves and exercise caution when working with a knife.*

2. Fold back the braid. Slide the (inner) ferrule under the cable braid, trapping the cable braid between the outer sheath and the dielectric. After the inner ferrule is located, trim off the excess braid. See Figure 2,B.

3. Trim back the dielectric. The protruding center conductor dimension should be as shown in Figure 2,C.

4. Tin the center conductor according to local safety practices, then slide the rear insulator over the dielectric so that it butts against the (inner) ferrule and cable end. See Figure 2,D.

**DANGER**

*The soldering equipment used in the following steps operates at very high temperatures. To avoid personal injury, always exercise caution when working with soldering equipment.*

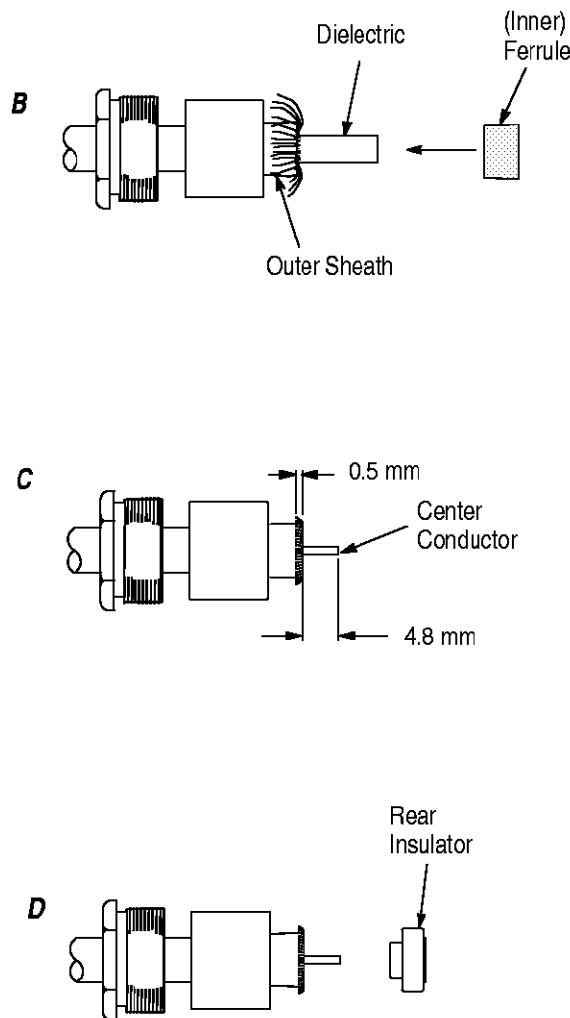


Figure 2

5. Fit the appropriate contact (male for plugs, female for jacks) onto the center conductor, with the collar of the contact pressed into the recess in the rear insulator. Hold the assembly together and solder the center contact to the center conductor. See Figure 3,A.

6. Slide the plain gasket and clamp nut up to the ferrule, trapping the braid. Fit the front insulator over the contact to butt against the the rear insulator and press the subassembly into the body as far as possible. See Figure 3,B.

7. Tighten the clamp nut to complete the connector assembly. Refer to Figure 3,C.

### 3. REVISION SUMMARY

Per EC 0990-1010-00:

- Initial release of instruction sheet

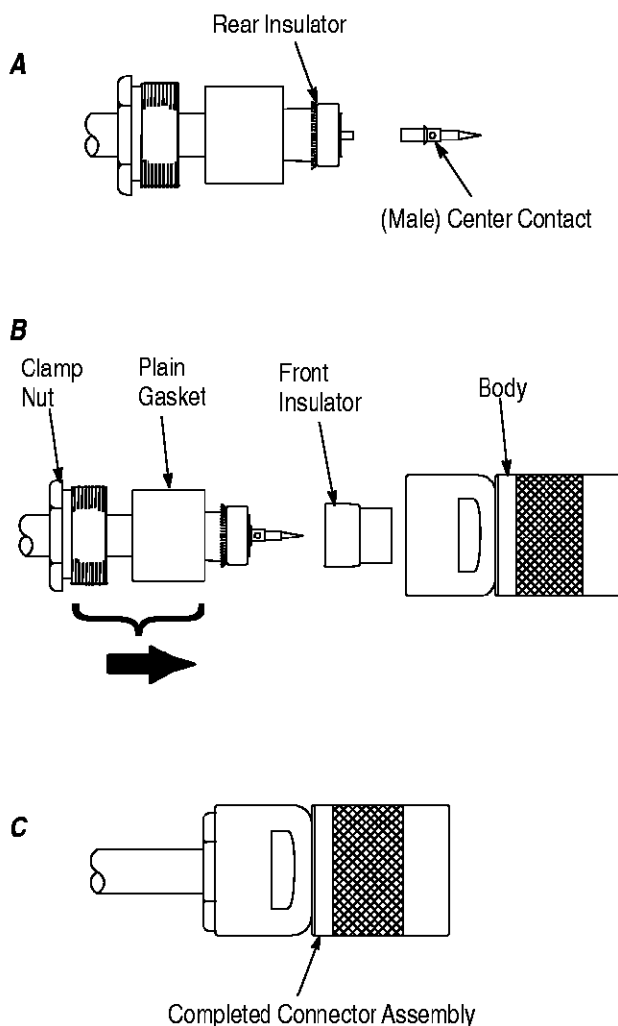


Figure 3