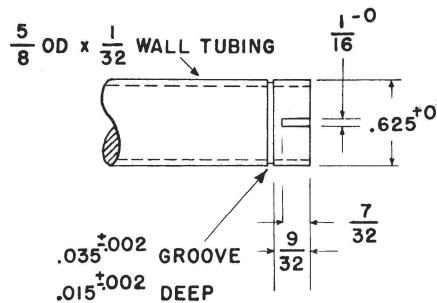
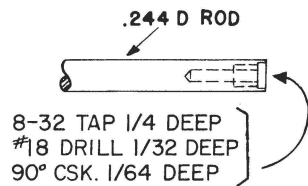




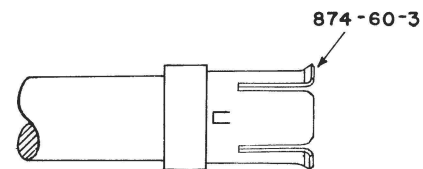
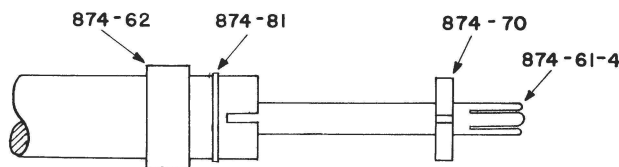
TYPE 874-B BASIC CONNECTOR

Cut rod and tube to make ends flush, and machine as illustrated. If connectors are used on both ends of tube, 1/16 keyways should be oriented 90° apart.



Slide on coupling nut (874-62) and install snap ring (874-81) on tube end. Insert inner connector (874-61-4) in insulating bead (874-70) and thread into rod end. See Notes 1 and 2 below.

Align keyway in insulating bead (874-70) with keyway in tube end. Slip outer connector (874-60-3) over bead and tube end so that key engages keyway, and thread up coupling nut (874-62). See Note 3 below.



TYPE 874-C, -C8, or -C9 CABLE CONNECTOR

RECOMMENDED PROCEDURE FOR TYPES 874-C8 AND -C9

Remove cable jacket and insulation to expose braid and inner conductor to dimensions shown.

Slip on cord guard (874-71 or 874-727) using talc if necessary, coupling nut (874-62), and cable ferrule (FEC-3 or -9).

Slip inner transition piece (874-64) over inner cable conductor until end touches cable insulation; then solder. Slide outer transition piece (874-63 or -63-2) over inner transition piece onto cable. Install snap ring (874-81).

Insert inner connector (874-61-4) in insulating bead (874-70) and thread into inner transition piece, holding hex with wrench. See Notes 1 and 2 below. **CAUTION:** Insulator will melt if inner connector and bead are screwed on before soldering cable. (over)

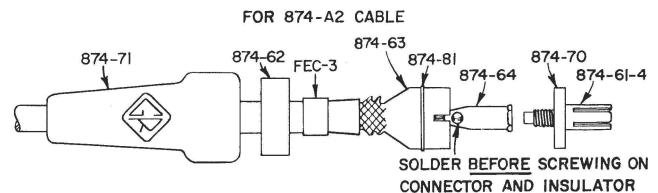
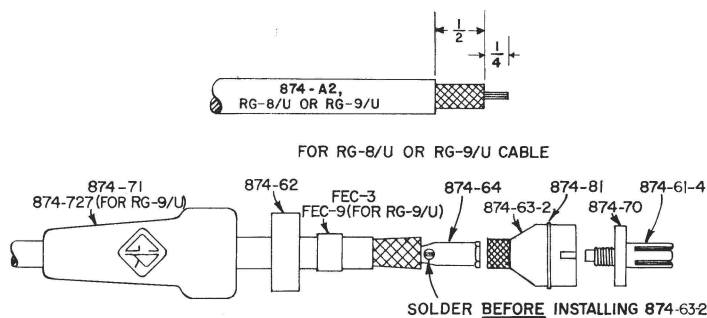
RECOMMENDED PROCEDURE FOR TYPE 874-C (ALTERNATE FOR TYPES 874-C8 AND -C9)

Remove cable jacket and insulation to expose braid and inner conductor to dimensions shown.

Slip on cord guard (874-71 or 874-727) using talc if necessary, coupling nut (874-62), and cable ferrule (FEC-3 or -9).

Slide outer transition piece (874-63 or -63-2) under braid and jacket until center cable conductor projects about 3/16 inch. Slip inner transition piece (874-64) over inner cable conductor until end touches cable insulation; then solder. Install snap ring (874-81).

Insert inner connector (874-61-4) in insulating bead (874-70) and thread into inner transition piece. See Notes 1 and 2 below. **CAUTION:** Insulator will melt if inner connector and bead are screwed on before soldering cable. (over)



NOTE 1. The Type 874-TOK Assembly Tool Kit is recommended for assembly of all Type 874 Connectors. This kit consists of an inner connector wrench (Type 874-TO117), an outer connector wrench (Type 874-TO115) and a coupling nut wrench (Type 874-TO116).

NOTE 2. To install inner connector and bead in rigid line or inner transition piece using tools: insert inner connector into bead, and push assembly into the end of the inner connector wrench observing alignment of keys and keyways. Thread assembly into the rod or inner transition piece.

NOTE 3. Clamp coupling nut wrench on ring coupling nut, push outer connector wrench onto outer connector and hold while tightening coupling nut.

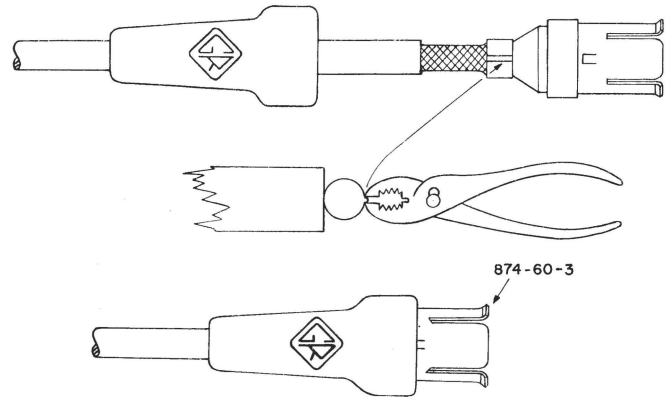
TYPE 874-C, -C8, OR -C9 CABLE CONNECTOR (CONT)

Slide outer transition piece (874-63 or 874-63-2) up to insulating bead (874-70); align keyways; slip outer connector (874-60-3) over bead (874-70) and outer transition piece so that keys engage keyways. Thread up coupling nut (874-62). See Note 3 above.

Tighten and arrange braid over small end. Cover with cable ferrule (FEC-3 or -9) and crimp in place. Crimping can be easily accomplished by holding ferrule against a sturdy surface and pinching and pushing simultaneously with a pair of ordinary gas pliers as illustrated. Type 874-TO58 and 874-TO8 Crimping Tools are available for hex-crimping the ferrules, and are recommended for large-quantity operations or when a neater crimp is desired. Use the appropriate tool and die as indicated in the following table:

CONNECTOR	TOOL	DIE
C58	874-TO58	0.215"
C62	"	0.250"
C	"	0.375"
C8	874-TO8	0.389"
C9	"	0.411"

Disengage ratchet lock by squeezing the handles together. Carefully position the ferrule in the appropriate die and squeeze the handles together until the ratchet lock releases.



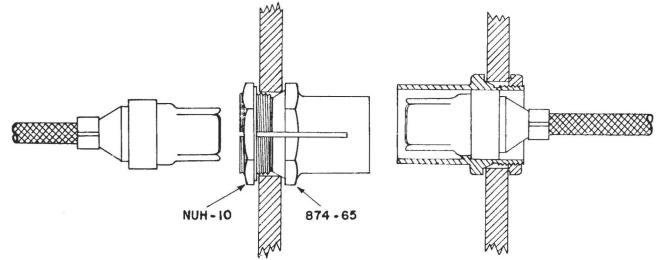
Stretch rubber cord guard (874-71 or 874-727) over coupling nut (874-62).

Note: For minimum VSWR tightly wrap exposed portion of braid between jacket and ferrule with plastic tape before sliding rubber guard in place in order to keep braid in contact with dielectric.

TYPE 874-P, -PC, -P8, -PC8, OR -PC9 PANEL CONNECTOR

Assemble connector to cable same as 874-C, 874-C8, or 874-C9 but less rubber cord guard. Mount panel adaptor (874-65 without cap, 874-211 with cap) through 15/16-inch clearance hole in panel, leaving nut (NUH-10) loose.

Slide connector assembly into panel adaptor until pierced key engages keyway in connector assembly. Clamp in place by tightening nut (NUH-10).

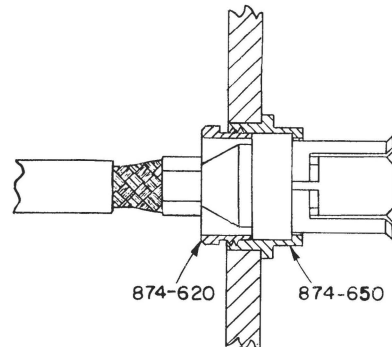
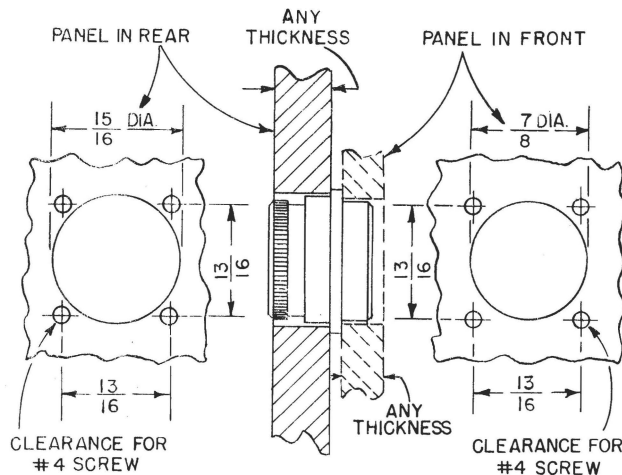


TYPE 874-PB, -PB8, -PB9, -PB58, OR -PB62 PANEL CONNECTOR

Mount panel adaptor through 15/16-inch (panel in rear) or 7/8-inch (panel in front) clearance hole as shown in the diagram, using four #4 screws provided.

Remove knurled retaining nut and slide this nut back over cable. Then assemble connector to cable same as Type 874-C, -C8, or -C9 but less rubber cord guard.

Slide connector assembly into the panel adaptor as far as it will go. Take care that the Type 874 Connector is properly oriented so that the panel adaptor tooth engages the groove on the side of the cable connector. Tighten up knurled retaining nut (see diagram).



GENERAL RADIO COMPANY

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