

CONNECTOR		CABLE	CRIMP TOOLING (Instruction Sheet)	
Plug	332225	RG-108 and 108A	SDE-SA Hand Crimping Tool Frame Assembly 9-1478240-0 (408-8851)	SDE Crimping Die Assembly 91909-1 (408-8580)
	5332225			
	5332225-5			
Bulkhead Jack	332342	—	—	—
	5332342			
Bulkhead Jack Adapter	332215	—	—	—
	5332215			

Figure 1

This instruction sheet covers selection and assembly of twin BNC series COAXICON connectors. The connectors consist of plugs, bulkhead jacks, and bulkhead jack adapters. See Figure 1. These connectors are designed for field service applications.

i **NOTE**
Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for re-issue of this instruction sheet are provided in Section 3, REVISION SUMMARY.

1. ASSEMBLY PROCEDURE

1.1. Plug and Bulkhead Jack

1. Refer to Figure 1 for applicable cable size and crimp tooling.
2. Slide the ferrule, small diameter end first, onto the cable. See Figure 2.
3. Strip the cable using the dimensions given in Figure 2.
4. Flare the cable braid, but do not comb the braid.

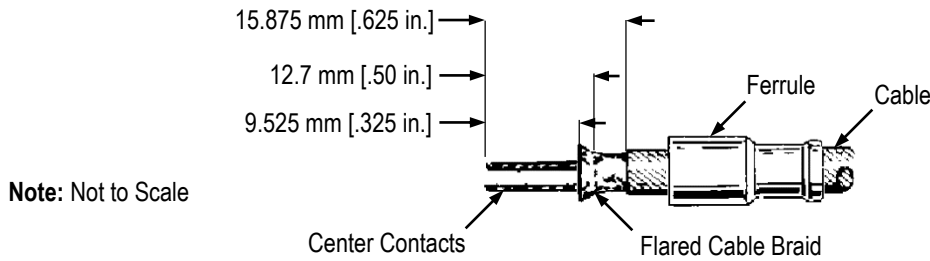


Figure 2

5. Hold the ferrule in place, and from the crimp end, insert the stripped cable conductors into each center contact. See Figure 3, Detail A. Ensure that the braid passes over and around the support sleeve as shown in Figure 3, Detail B.
6. Push the crimp end under the cable braid. Apply sufficient pressure to cause the cable dielectric to bottom against the dielectric inside of the crimp end. Twist the crimp end slightly to ensure bottoming.
7. Slide the ferrule over the cable braid until it bottoms against the connector shoulder. See Figure 3, Detail C.

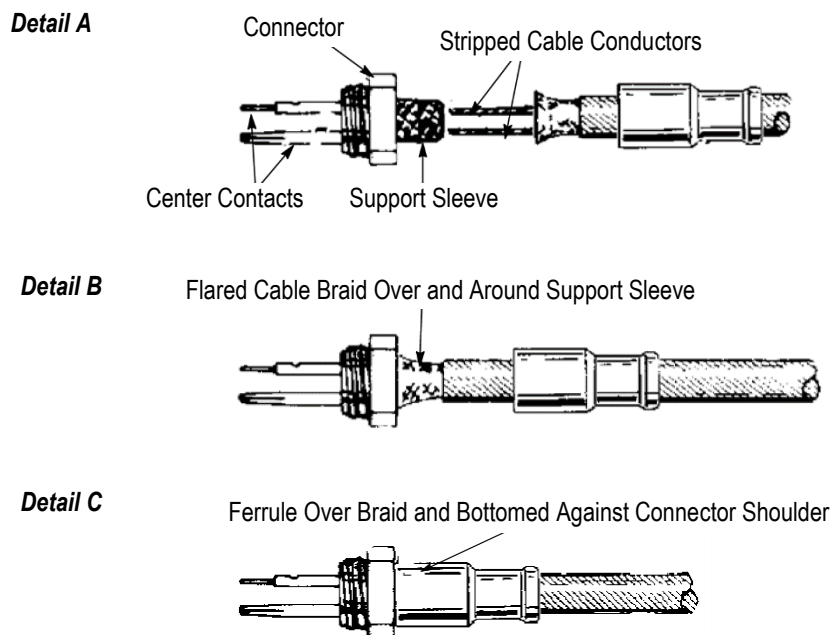


Figure 3

8. Crimp the ferrule according to instruction sheets included with the tooling (referenced in Figure 1).
9. Crimp the center contacts according to instruction sheets included with the tooling (referenced in Figure 1). Measure each center contact across the flats of the crimp to ensure that the crimp height is within 1.181 and 1.316 mm [.0465 and .0518 in.].



NOTE

Refer to the instruction sheet included with the hand crimping tool frame assembly for information on operating the tool. Refer to the instruction sheet included with the die assembly for instructions on crimping the ferrule and center contacts.

10. Slide the seal over the center contacts. Refer to Figure 4.

11. Insert the center contacts into the dielectric, making sure that the male contact protrudes.
12. Using a wrench on the flats of the crimp end, thread the crimp end onto the body. See Figure 4.
13. Using a wrench on the flats of the connector, tighten the components to a torque of 1.7 to 2.26 Nm [15 to 20 in.-lb]. See Figure 4.

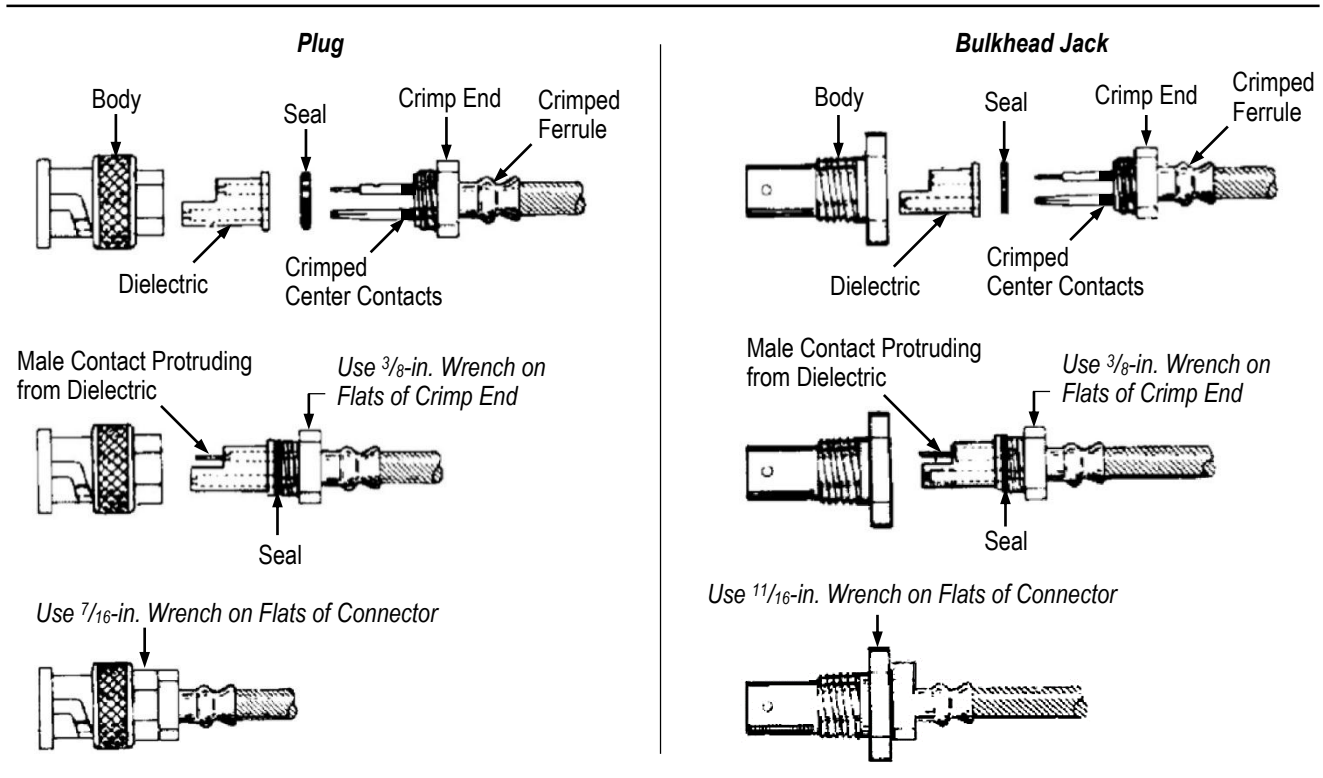


Figure 4

1.2. Mounting Bulkhead Jack and Bulkhead Jack Adapter

1. Cut the panel to the dimensions given in Figure 5.

Recommended Panel Cutout

Panel Thickness: 4.762 [.187]

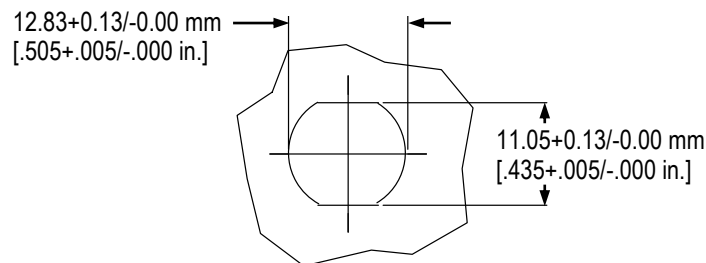


Figure 5

2. Slide the gasket over the body and into the groove. See Figure 6.
3. Insert the connector through the hole in the panel.

4. Assemble the lock washer and jam nut onto the connector. Tighten the jam nut using a $\frac{9}{16}$ -inch wrench.

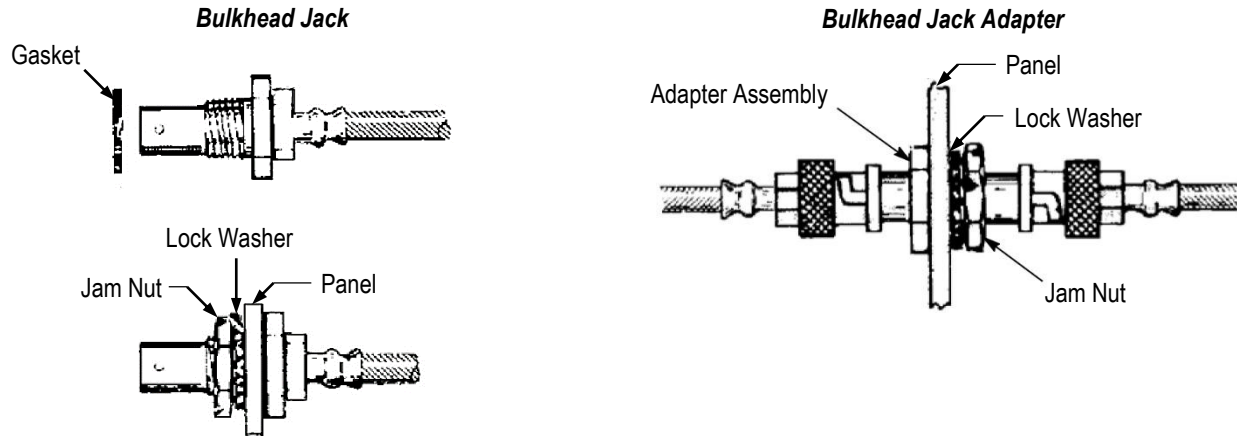


Figure 6

1.3. Connector Coupling

This procedure is required for proper alignment of the connector dielectrics during coupling.

1. Align the slots in the plug body collar with the lugs on the bulkhead jack. See Figure 7, Detail A.
2. Push the plug over the bulkhead jack until the ends of the dielectrics butt.
3. As the dielectrics come into alignment, slide the plug collar over the bulkhead jack lugs and into the locked position. For some connectors, the dielectrics will properly align and permit the collar to slide over the lugs. For connectors with misaligned dielectrics, grasp the rear of the plug over the flats and twist the plug while applying slight pressure. See Figure 7, Detail B. As the dielectric aligns, the collar will be allowed to slide over the lugs and into the locked position.

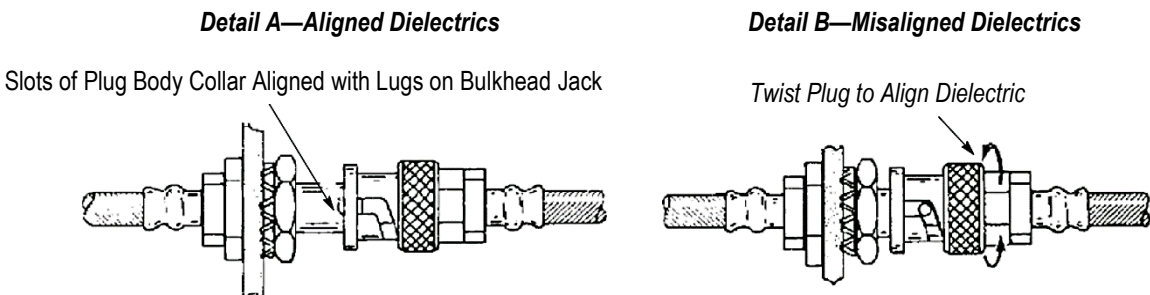


Figure 7

2. REPLACEMENT AND REPAIR

Components of the connectors are not repairable. Damaged or defective components must not be used. Connectors cannot be re-used by removing the cable.

3. REVISION SUMMARY

Revisions to this instruction sheet include:

- Replaced hand crimping tool, replaced obsolete connector part numbers, and added bulkhead jack adapter part numbers to Figure 1
- Added step 9 to Paragraph 1.1, and corrected wrench sizes in Figure 4
- Removed bulkhead jack adapter panel cutout, and added Section 2