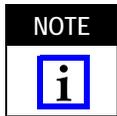


1. INTRODUCTION

Use the table below to select BNC jack connectors and recommended crimping tool or die. Strip the cable to dimensions shown in the table. Refer to the crimping procedure found in the tool instruction sheet listed in the table.

Standard connectors include body, gasket, ferrule, and crimp end.



All dimensions on this sheet are in millimeters [with inch equivalents provided in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

Refer to Figure 2 for assembling crimp end and connector body.



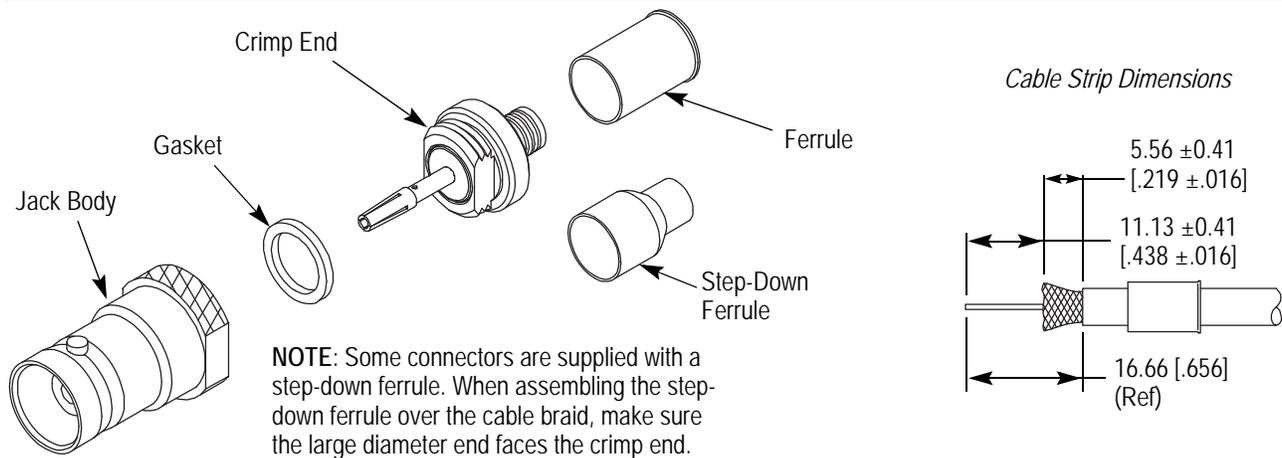
The crimp end should not be assembled to the connector body until the crimp is completed.

Reasons for reissue of this instruction sheet are provided in Section 3, REVISION SUMMARY.

2. CRIMP END ASSEMBLY

- Slip the ferrule on the cable, then strip the cable and flare the braid.
- Insert the stripped conductor into the center contact on crimp end. Twist the crimp end slightly to ease entry of wire.
- Push the crimp end back under the braid so that the braid passes over and around the support sleeve. Apply sufficient pressure to cause the cable dielectric to bottom against the dielectric of the crimp end. Refer to Figure 1. Twist the crimp end slightly to ensure bottoming.
- Slide the ferrule forward and over the braid on the crimp end as far as it will go. Crimp the ferrule and the contact portion simultaneously with the appropriate crimping tool. See the table below for the appropriate crimp tool.
- Assemble the crimp end into the connector body as shown in Figure 2, after the ferrule and contact portion is crimped.
- Use a wrench on the flats to tighten. A torque of 1.69 to 2.26 N•m [15 to 20 in.-lb] is suggested.

STANDARD TYPE BNC JACKS



CABLE (RG/U Coaxial Cable Manufactured in Accordance with MIL-C-17D)	PART NUMBER Silver Plated (Polypropylene Dielectric)	PART NUMBER Silver Plated (PTFE Dielectric)	CRIMPING TOOL		CRIMPING DIES FOR TOOL 69710-1	
			Part Number	Instruction Sheet	Part Number	Instruction Sheet
59, 59A, 59B, 62, 62A, 62B, 124, 140, 210	2-329063-1	--	69141-1	408-2340	69224-1	408-2496
55, 55A, 55B, 223	--	2-329452-2	69140-2		69424	
174, 188	--	2-330062-1	69245-1		69422	
142, 142A, 142B	--	2-329452-2	69331-1		69429-1	

Typical Assembly Procedure

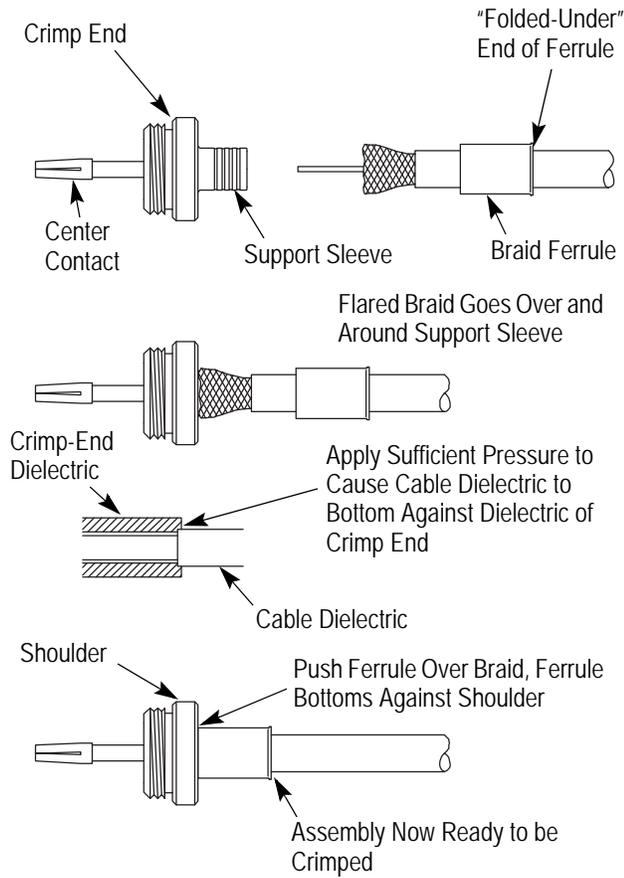


Figure 1

Assembly of Typical Crimp End to Connector Body

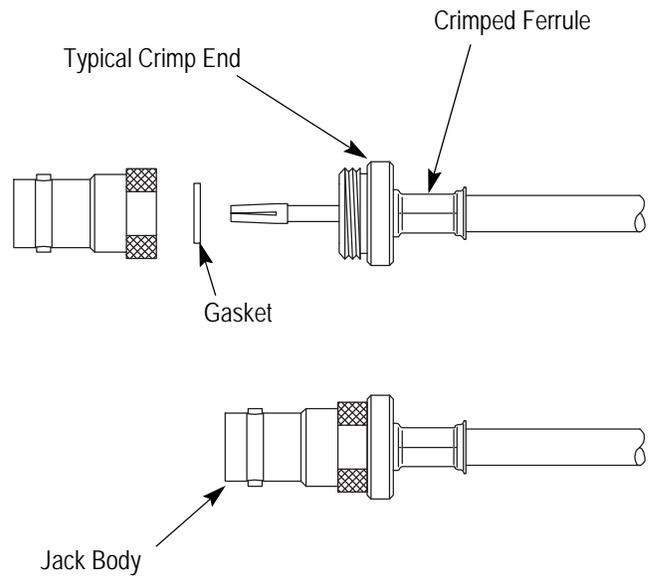


Figure 2

3. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Removed obsolete parts (and references to obsolete weatherproof connectors).
- Edited table on Page 1 for clarity.
- Replaced improper trademark reference for PTFE.
- Updated document to corporate requirements.