

Figure 1

**1. INTRODUCTION**

This instruction sheet covers the assembly of AMP\* 50-Ohm SMA Series Hex Crimp Commercial RF Connectors with the base part numbers shown in Figure 1. The connectors are crimped onto various sizes of RG/U flexible coaxial cable using hand tools and die assemblies that are qualified to Military Specification M22520†. AMP Hand Tool 601966-1 (408-7516) can also be used. Refer to the AMP customer drawing for the appropriate hand tools, settings, and die assemblies. For detailed crimping procedures, refer to the instructions packaged with the hand tool.

AMP Catalogs 65198 and 82074 provide a guide for cable-to-connector selection. For cable sizes and connectors not referenced in the catalog, contact an AMP representative for recommendations.

**NOTE**

Dimensions are in millimeters [followed by inch equivalents in brackets]. Figures are for identification only and are not drawn to scale.

Read these instructions carefully before assembling the connectors.

Reasons for reissue are provided in Section 4, REVISION SUMMARY.

**2. DESCRIPTION**

Each connector consists of a body, center contact, and braid ferrule. The bulkhead jack also contains a seal, lockwasher, and locknut. See Figure 1. The center contact is crimped onto the cable's center conductor. If the center contact is to be soldered as well, a spacer is provided. The center contact is assembled onto the connector body, then the braid ferrule is crimped to the cable and connector body to complete the assembly.

**3. ASSEMBLY PROCEDURE**

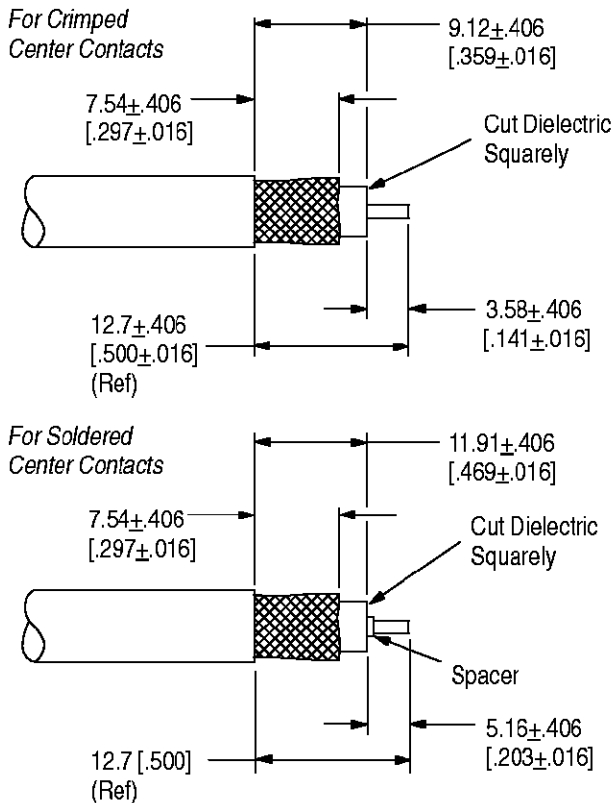
Select the appropriate cable size, connector, and application tooling.

1. Strip the cable according to the dimensions shown in Figure 2. Be sure that the center conductor is straight and free of burrs, and that the cable braid is not nicked.
2. Slide the center contact over the center conductor of the cable until the contact shoulder butts against the dielectric of the cable. See Figure 3, Detail A.
3. Solder (if applicable) and crimp the center contact, using the appropriate hand tool and correct settings.

**NOTE** *If the spacer is provided with the connector, it must be installed before the center contact is soldered. Position the spacer over the center conductor and against the dielectric.*

4. Slide the braid ferrule onto the stripped cable.
5. Flair the cable braid.
6. Insert the center contact into the connector body, making sure the cable's braid is over the support sleeve of the body. See Figure 3, Detail B.

**Recommended Cable Stripping Dimensions**



**NOTE:** Not to Scale

Figure 2

**Connector Assembly**

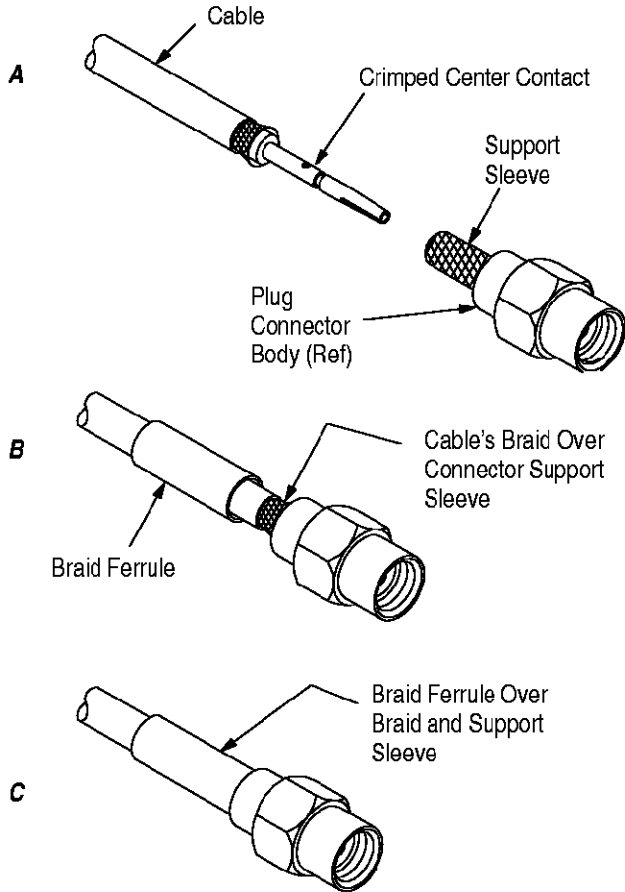


Figure 3

Lightly pull back to make sure the center contact is held securely by the body's internal locking feature.

7. Slide braid ferrule over the cable's braid and support sleeve of the connector body. See Figure 3, Detail C.

**NOTE** *Trim off any excess cable braid that would prevent the braid ferrule from bottoming against connector body.*

8. Crimp the braid ferrule using the appropriate hand tool and die assembly.

**NOTE** *When using bulkhead jack, panel jack, and flange-type plug connectors, refer to the recommended panel cutout in the AMP customer drawing for the connector.*

**4. REVISION SUMMARY**

Since the previous release of this sheet, the following changes were made per EC 0990-1431-99:

- Added part numbers 415788, 415789, and 1274406 to Figure 1
- Changed document title
- Updated document to corporate requirements