

NOTE: When assembling the step-down ferrule over the cable braid, make sure the large diameter end faces the plug body.

• Used for cable with air core dielectric only.

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* COAXICON 50-Ohm BNC Commercial Plug (Hex Crimp) Connectors 221128-[]. The plug connectors accept a wide range of coaxial cables and can be crimped using the AMP PRO-CRIMPER* II Frame Assembly 354940-1, which accepts interchangeable crimping die assemblies. Refer to instruction sheet 408-9930 for procedures concerning the operation of the frame assembly.

Read these instructions thoroughly before starting assembly.

NOTE

Dimensions are in millimeters [followed by inches in brackets].

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

2. DESCRIPTION (Figure 1)

The 50-ohm version hex crimp connectors feature a plug body with a knurled coupling sleeve, a center contact, and a ferrule. The center contact is crimped onto the cable center conductor and assembled onto the plug body. The ferrule is then crimped onto the cable braid and plug body to complete the assembly.

Some connectors are supplied with a step-down ferrule and a tubing. The tubing is slipped over the cable dielectric before the center contact is crimped. In this use, the tubing compensates for small diameter cable dielectrics. Also, a spacer is provided with connectors which use air core dielectric cable.

3. ASSEMBLY PROCEDURE

NOTE

AMP Catalog 82074 provides cable-to-connector selection guides which will assist you in matching connectors with a specific cable size, crimping tool, and die assembly. For cable sizes not listed in the guides, contact AMP Engineering for connector recommendations.

NOTE

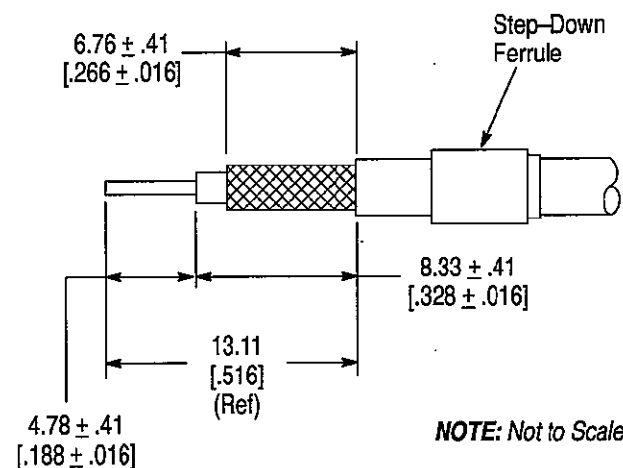
See Figure 2 for orientation of step-down ferrule.

1. Slide ferrule onto unstripped cable; then strip cable using the appropriate dimensions in Figure 2 or 3. Do not nick or cut cable braid. Center conductor must be straight and free of burrs.

NOTE

For cables with air core dielectric, spacer must be assembled over center conductor and bottomed against the cable dielectric prior to assembly of center contact. If tubing is provided with the connector, slide it over the cable dielectric prior to assembly of the center contact. Refer to the AMP Customer Drawing for part availability.

2. Slide center contact over center conductor of cable until shoulder of contact is positioned against inner dielectric of cable.



NOTE: Not to Scale

Figure 2

NOTE: For cables with air core dielectric only – RG62/U, 62A/U, and 62B/U.

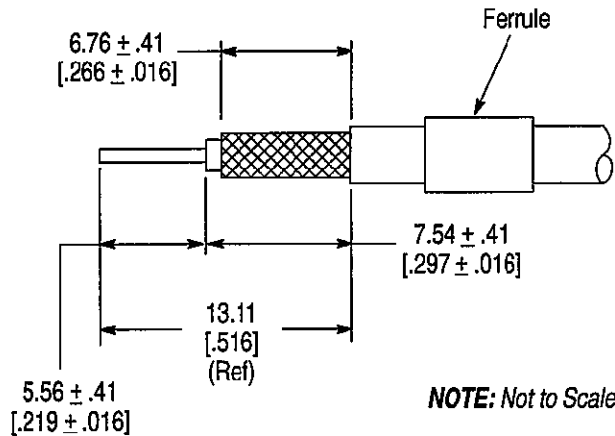


Figure 3

3. Using the recommended crimping tool (with appropriate die assembly), crimp the center contact, as shown in Figure 4.

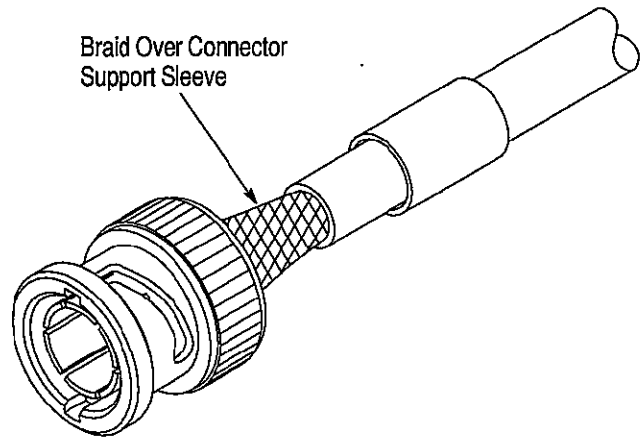


Figure 5

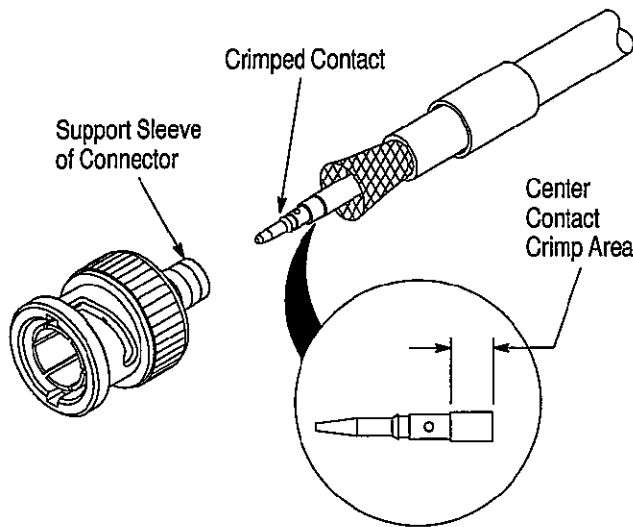


Figure 4

4. Flare cable braid to allow the support sleeve of the plug body to pass under the cable braid.

5. Insert center contact into plug body until it snaps into place. Make sure the cable braid is positioned over the connector support sleeve. Pull back gently on the cable to ensure that the contact is held in place by the internal locking feature. See Figure 5.

6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the plug body. Crimp the ferrule using the recommended crimping tool, as shown in Figure 6.

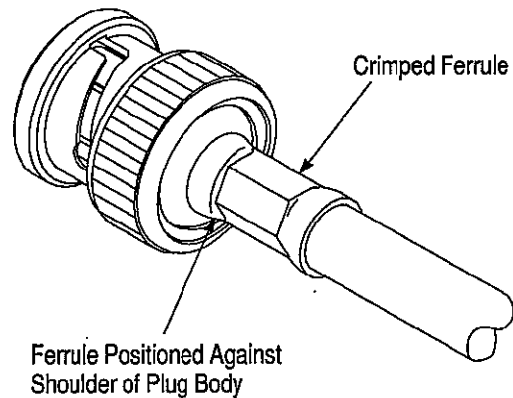


Figure 6

4. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made:

Per EC 0990-0486-97:

- Added Step-Down Ferrule and Tubing and information in text referring to step-down ferrule and tubing.
- Added PRO-CRIMPER Frame Assembly 354940-1 to Section 1.