



Figure 1

1. INTRODUCTION

This Instruction Sheet covers the installation of AMP* Commercial BNC PC Board Connector 221336-[], 414493-[], and 414553-[] with ACTION PIN contacts. Read these instructions thoroughly before installing or using the connector.

NOTE

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

Read these instructions thoroughly before installing the connector.

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

2. DESCRIPTION (See Figure 1)

The connector features a shell, a center contact assembly with a single post, two drive screws, and two sleeve assemblies. The ACTION PIN contacts are contained in the two sleeve assemblies and the center contact assembly. See Figure 1.

The connector is seated onto the pc board using a customer-designed seating tool and pc board fixture, and an arbor frame assembly or H-frame applicator that is capable of applying a force of 2224 N [500 lb] for each connector.

NOTE

More than one connector can be terminated to a pc board at the same time if the applicator can provide the necessary force.

3. PC BOARD LAYOUT

Make a pc board layout using the dimensions shown on the specific part number customer print. The thickness of the board must be 2.36 to 3.17 mm [.093 to .125 in.] for connectors 221336-1, 221336-3, 414493-[], and 414553-[]; and 2.36 to 6.35 mm [.093 to .250 in.] for connector 221336-4.

4. SEATING TOOL DESIGN (See Figure 2)

Design and construct a seating tool using the dimensions provided in Figure 2.

5. CONNECTOR INSERTION (See Figure 3)

1. Align the pc board on an appropriate pc board support fixture (customer-designed) to protect the contact posts.
2. Align the contact posts with the proper holes of the pc board.
3. Press the connector contacts into the pc board evenly, by hand, making sure that the contact posts do not bend. The post split sections of the contacts should bottom on the pc board, as shown in Figure 3, View A.
4. Align the seating tool over the connector, as shown in Figure 3, View B.
5. Center the entire assembly under the applicator ram.
6. Actuate the applicator ram until the connector bottoms on the pc board. See Figure 3, View C.
7. Raise the applicator ram, and remove the assembly from the applicator.
8. Remove the seating tool from the connector, and remove the pc board from the pc board support fixture.