

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* 75-Ohm TNC Dual Crimp Plug Connectors 221506-[]. The connector is crimped onto various sizes of RG/U cable using AMP PRO-CRIMPER* II Frame Assembly 354940-1, which accepts interchangeable crimping die assemblies.

AMP Catalog 82074 provides die assembly part numbers for the frame assembly, product application requirements, cable selection, and product part number information. For information not listed, contact AMP Engineering for recommendations. Refer to instruction sheet 408-9930 for procedures concerning the operation of the frame assembly.

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

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

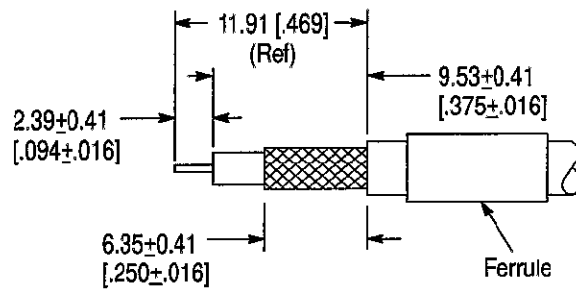
Each connector consists of a plug body, a center contact, and a ferrule. The center contact is crimped onto the cable center conductor and assembled into the plug body. The ferrule is then crimped onto the cable braid and plug body to complete the assembly.

Some connectors are supplied with a step-down ferrule, a plastic spacer, and a brass tubing. The plastic spacer and brass tubing are slipped over the cable dielectric before the center contact is crimped. In this use, the spacer and tubing compensate for small diameter cable dielectrics.

3. ASSEMBLY PROCEDURE

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

Recommended Cable Strip Length



Note: Not to Scale

For Connector 221506-2 Only

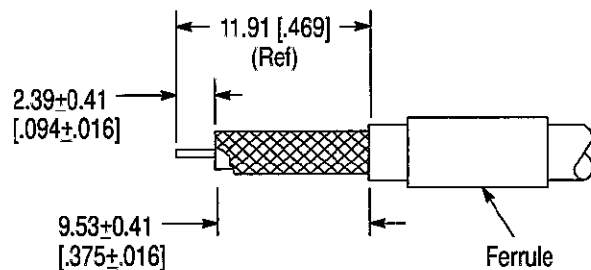


Figure 2

NOTE

Refer to Figure 3 for orientation of step-down ferrule. For connectors supplied with spacer and tubing, slip tubing (flared end first), then spacer over the cable dielectric, as shown in Figure 3.

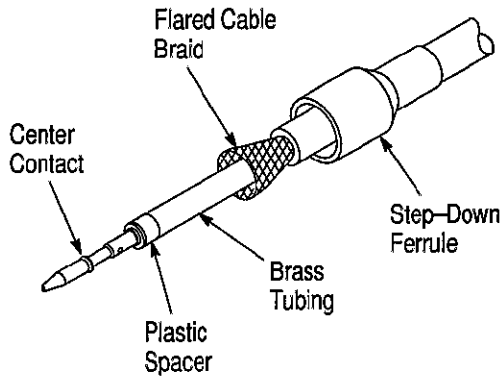


Figure 3

2. Insert center conductor into center contact. The center contact shoulder must be positioned against the cable dielectric, as shown in Figure 4. Be sure the cable insulation does not enter the center contact wire barrel.

3. Crimp the center contact with the recommended frame assembly fitted with the appropriate die assembly.

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

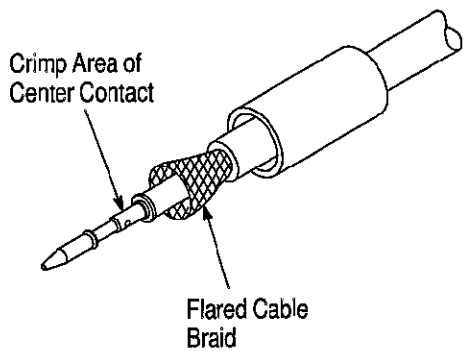


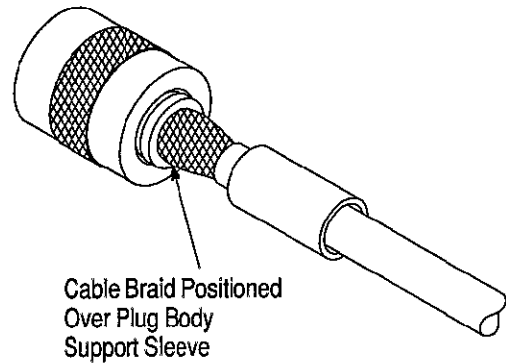
Figure 4

5. Insert center contact into plug body. The cable braid must be positioned over the plug body support sleeve. See Figure 5, Detail A.

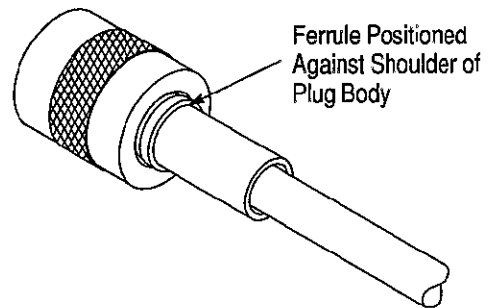
6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the plug body. See Figure 5, Detail B.

7. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 5, Detail C.

Detail A



Detail B



Detail C

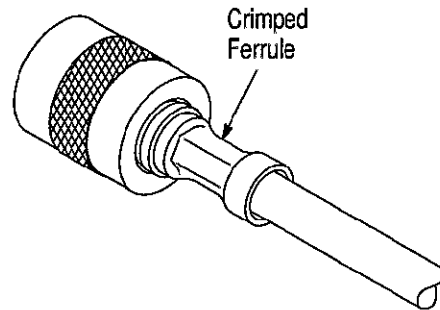


Figure 5

4. REVISION SUMMARY

Revisions to this instruction sheet include:

Per EC 0990-0110-97:

- Added connector components
- Replaced superseded hand tool
- Replaced die assembly part numbers with catalog reference
- Removed obsolete pneumatic tool