

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* 75-Ohm RF Series BNC Right-Angle Plug Hex Crimp Connectors 413588-[]. The connectors are terminated with AMP Hand Tool 354940-1 which accepts interchangeable crimping dies. Die set numbers for this hand tool, cable sizes, and connector part numbers are available in AMP Catalogs 82677 and 82074. For application and maintenance procedures of the hand tool, refer to Instruction Sheet 408-9930.

NOTE Dimensions on this instruction sheet are in millimeters [followed by inches in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

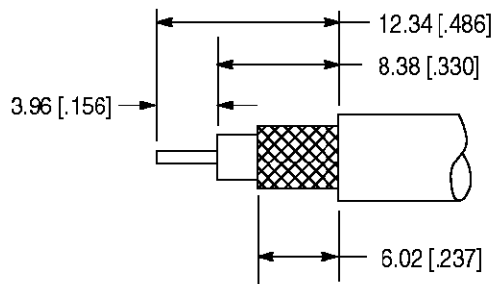
Reasons for reissue are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

Each connector features a center contact, a plug assembly, and a ferrule. For details concerning product specifications, refer to AMP Catalogs 82677 and 82074.

Some connectors are supplied with a step-down ferrule, a brass tube, and a plastic bushing. Slip brass tube (flared end first), then bushing over the cable dielectric before the center contact is crimped. In this use, the tube and bushing compensate for small diameter cable dielectrics.

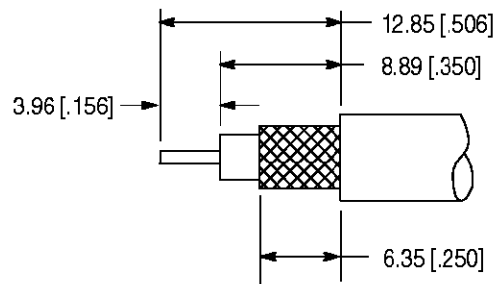
Recommended Strip-Length Dimensions (± 0.41 [.016])



NOTE: All Part Numbers Except -5

View A

Recommended Strip-Length Dimensions (± 0.41 [.016])



NOTE: For P/N 413588-5 Only

View B

Figure 2

3. ASSEMBLY PROCEDURE

Determine cable type for your application; then select an appropriate connector. Proceed as follows:

1. Slide ferrule over the cable end; then strip cable using the recommended strip-length dimensions provided in Figure 2, A or B.

NOTE

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

2. Insert center conductor into center contact. Crimp center contact using Hand Tool 354940-1 (fitted with the appropriate die assembly). See Figure 3.

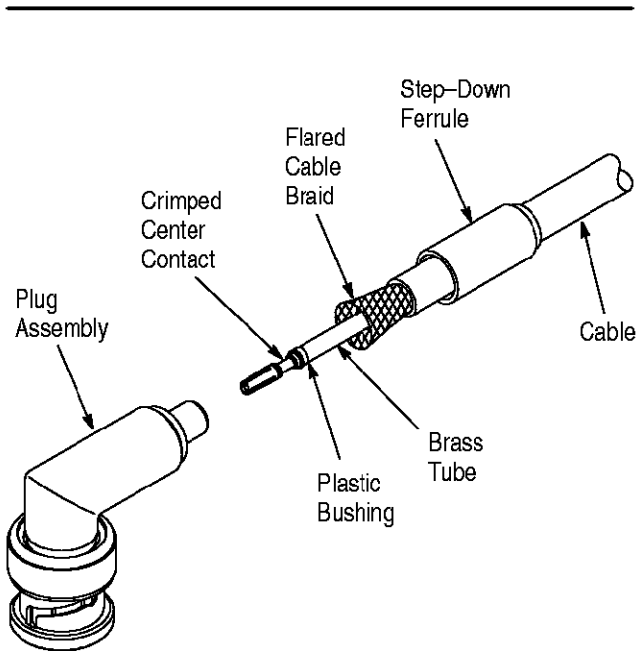


Figure 3

3. Insert center contact into plug assembly. Cable braid must be positioned over the support sleeve of the plug assembly. See Figure 4.

4. Slide ferrule forward over braid and support sleeve. Crimp ferrule with the hand tool. See Figure 5.

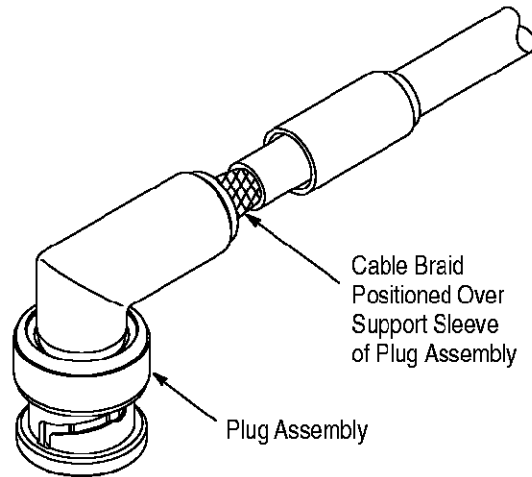


Figure 4

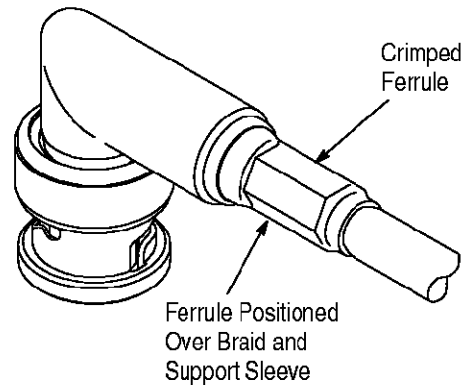


Figure 5

4. REVISION SUMMARY

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

Per EC 0990-1050-96

- Added plastic bushing, brass tube, and step-down ferrule to Figure 1
- Updated Section 2, DESCRIPTION
- Added note after Step 1 in Section 3
- Changed dimensions in Figure 2, View B
- Added "Insert center conductor into center contact." to Step 2 in Section 3
- Updated Figure 3
- Removed note regarding plugs in Section 3