

Figure 1

1. INTRODUCTION

AMP* COAXICON 50-ohm RF series BNC right-angle plug connectors (shown in Figure 1) are crimped onto coaxial cable using the tooling listed in Figure 2. Read these instructions thoroughly before starting assembly. For detailed information on tooling, refer to the applicable instructions (408- and 409-series) also listed in Figure 2.

NOTE Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

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

2. DESCRIPTION (Figure 1)

These right-angle plug connectors consist of a right-angle plug body, gasket, crimp end, and ferrule. Some connectors are also supplied with a step-down ferrule to compensate for small diameter cable.

3. ASSEMBLY PROCEDURE

1. Slide ferrule onto unstripped cable; or slide step-down ferrule, small opening first, onto the unstripped cable. Strip cable using the appropriate strip-length dimensions shown in Figure 3. **DO NOT** nick or cut cable braid. Center conductor must be straight and free of burrs.

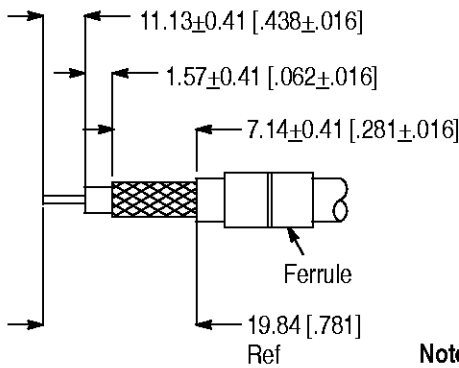
NOTE When using the step-down ferrule, make sure that the large opening will face the crimp end.

2. Flare cable braid.
3. Insert stripped cable conductor into the center contact on the crimp end. Twist the crimp end slightly to ease entry of the conductor. See Figure 4, Detail A.
4. Push crimp end under the cable braid so that the braid passes over and around the crimp end support sleeve. Apply sufficient pressure so that the cable dielectric bottoms against the dielectric. Twist crimp end slightly to ensure bottoming. See Figure 4, Detail B.

CABLE SIZE (RG/U)	PLUG CONNECTOR	TOOLING	
		HAND CRIMPING TOOL (408-2340)	DIE SET (408-2496) FOR Hand Tool Frame 69710-1 (408-2095) or 626 Pneumatic Tools 189721-2 or 189722-2 Fitted with Tool Holder 189928-1 and Crimping Head 318161-1 (409-5862)
58, 58A, 58B, 58C	331175	69140-1	69223-1
59, 59A, 59B, 62, 62A, 62B, 124, 140, 210	331176	69141-1	69224-1
174, 188	331178	69245-1	69422
161, 179, 187	331179	69245-1	69408
AMPHENOL 21-597	331181	69246-2	—
55, 55A, 55B, 223	331182	69140-2	69424
142, 142A, 142B		69331-1	69429-1
BELDEN 8281, 9141, 9231 WE 724, 3049, 728	50635	69652	220000

Figure 2

Stripping Dimensions for Belden and WE Cable



Stripping Dimensions for All Other Cable

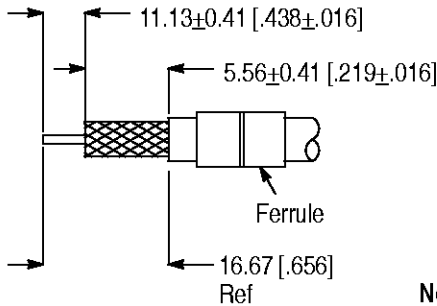


Figure 3

5. Slide ferrule over the cable braid until the ferrule bottoms against the shoulder of the crimp end. See Figure 4, Detail C.
6. Crimp the ferrule with appropriate tooling (refer to Figure 2) according to the instructions packaged with the tooling.
7. Slide the gasket onto the crimp end.
8. Assemble crimp end onto the plug body then tighten crimp end using a torque of 1.7 to 2.3 N•m [15 to 20 in.–lb]. See Figure 4, Detail D.

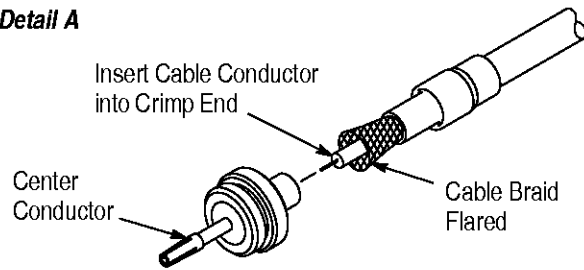
CAUTION Do not assemble crimp end onto plug body until crimp is completed.

4. REVISION SUMMARY

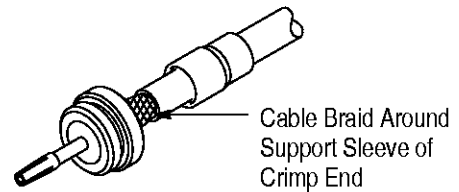
Revisions to this instruction sheet per EC 0990–1002–98 include:

- Added step–down ferrule
- Removed weatherproof type connectors
- Modified stripping dimensions
- Added Step 2 to Section 3

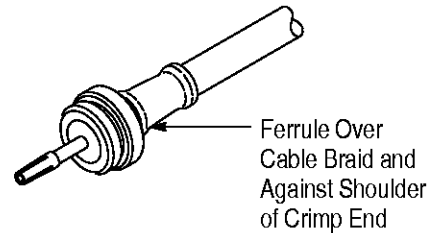
Detail A



Detail B



Detail C



Detail D

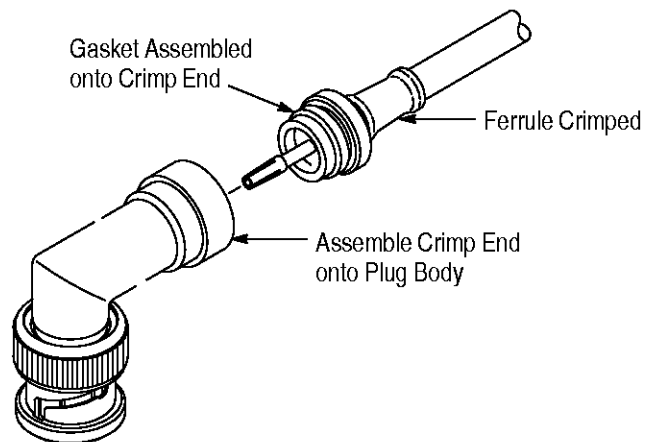


Figure 4

- Modified Figure 2: added cable sizes, removed connector part numbers, removed Die Set 69423–1, replaced Die Set 69408 with 69422, removed Tool 69365, replaced Tool 69710 with 69710–1, added Tools 189721–2 and 189722–2
- Added information to Section 3, Step 6.