

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of 50-Ohm and 75-Ohm RF Series BNC Bulkhead Jack Hex Crimp Decoupler Connectors. The connectors are terminated with AMP PRO-CRIMPER* Ili Hand Crimping Tool Frame Assembly 354940-1, which accepts interchangeable crimping die assemblies.

Catalog 82074 provides product application requirements, cable selection, and product part number information. Refer to the customer drawing of the connector being used for the appropriate crimping die assembly. For part numbers not listed, contact the Product Information Center for recommendations. Refer to instruction sheet 408-9930 for procedures concerning the operation of the tool frame 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)

Each connector features a jack assembly, a center contact, a ferrule, a jam nut, and a lockwasher. Some 50-Ohm connectors are supplied with a step-down ferrule and plastic tubing. Also, some 75-Ohm connectors are supplied with a step-down ferrule, a spacer, and brass tubing.

3. ASSEMBLY PROCEDURE

NOTE *Refer to Figure 2 for orientation of step-down ferrule.*

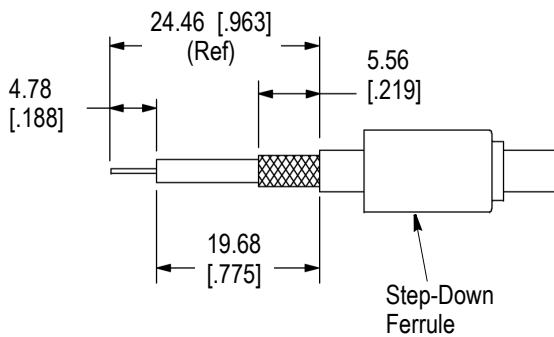
1. Slide ferrule over the cable end; then strip cable using the recommended strip-length dimensions in Figure 2. Do NOT nick or cut cable braid. Center conductor must be straight and free of burrs.
2. If assembling 50-Ohm connectors, slide the plastic tubing over the cable dielectric. If assembling 75-Ohm connectors, slip the tubing (flared end first), then the spacer, over the cable dielectric, as shown in Figure 3, Detail A.

NOTE *These components must be assembled onto the cable before crimping the center contact.*

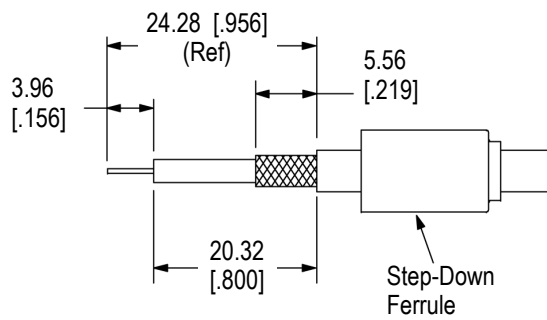
3. Crimp the center contact to center conductor of cable using the tool frame assembly fitted with the appropriate die assembly. See Figure 3, Detail A.
4. Flair the cable braid.

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

For 50-Ohm Connectors



For 75-Ohm Connectors



NOTE: Not to Scale

Figure 2

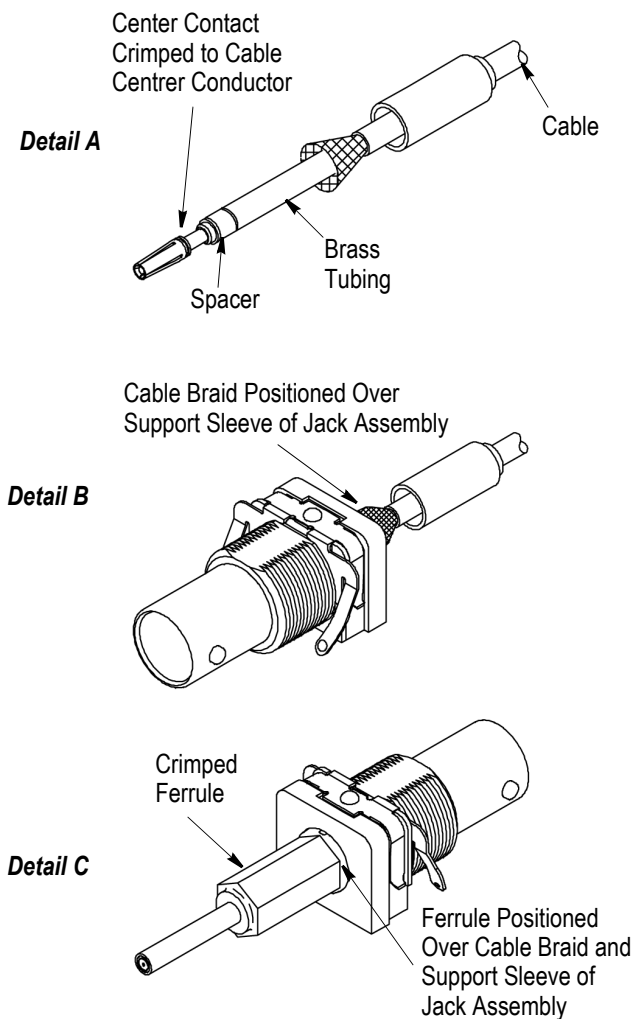


Figure 3

5. Insert contact assembly into jack assembly until it snaps into place. Make sure cable braid is positioned over the support sleeve of the jack assembly. See Figure 3, Detail B. Gently pull back on the cable to ensure that the contact is held in place by the internal locking feature.

6. Slide ferrule forward over braid and support sleeve. See Figure 3, Detail C.

7. Crimp ferrule using the tool frame assembly fitted with the appropriate die assembly. See Figure 3, Detail C.

8. Make the panel cutout using the dimensions shown in Figure 4. Insert assembly through the panel cutout and secure it with the lockwasher and jam nut using 1.0 to 1.4 NDM [9 to 12 in.-lb] torque.

4. REVISION SUMMARY

Since the previous release of this instruction sheet, the TE logo has been applied.

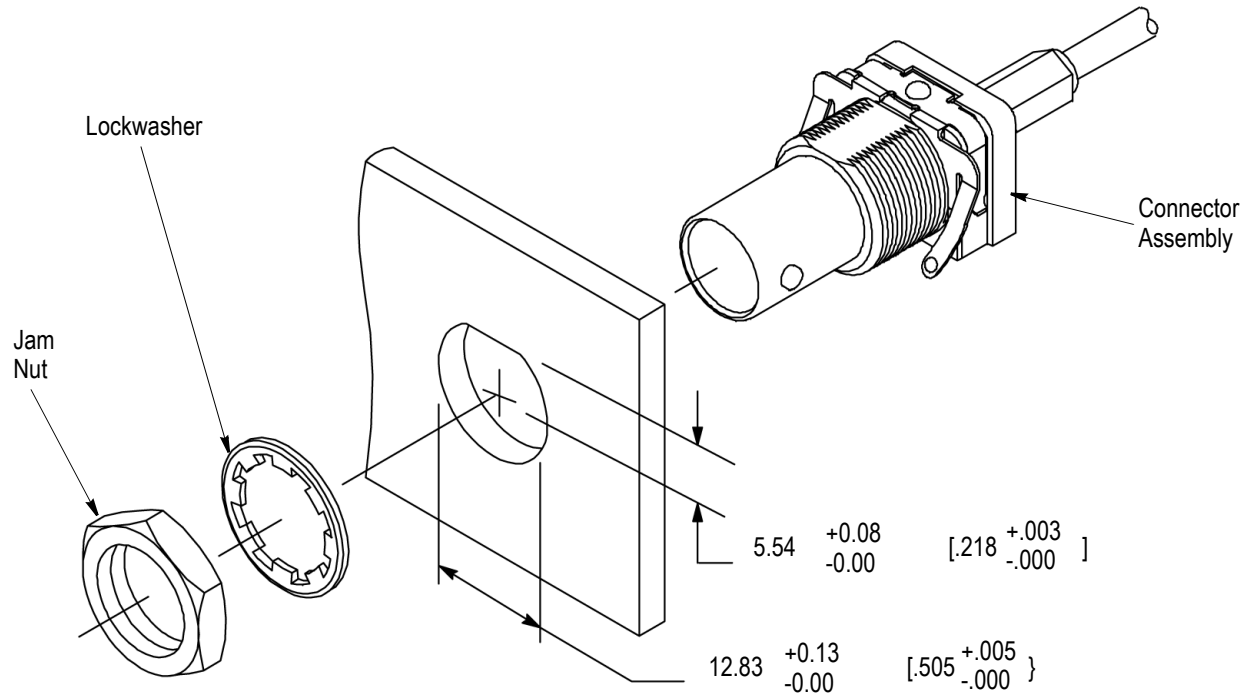


Figure 4