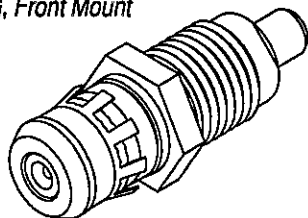
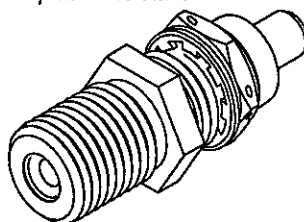


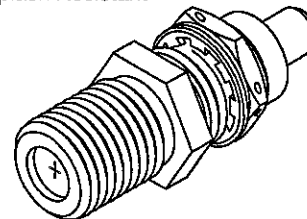
*Bulkhead Jack 415683-[]
Series G, Front Mount*



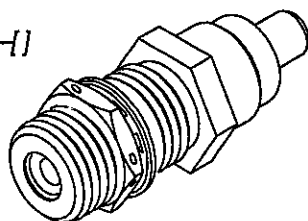
*Bulkhead Jack 415710-[]
Series F, Front Mount,
Non-Splash Resistant*



*Bulkhead Jack 415569-[]
Series F, Front Mount,
Splash Resistant*



*Bulkhead Jack 415712-[]
Series F, Rear Mount,
Non-Splash Resistant*



*Bulkhead Jack 415711-[]
Series F, Rear Mount,
Splash Resistant*

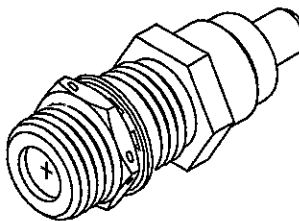


Figure 1

1. INTRODUCTION

This instruction sheet covers assembly of the AMP* Series F and Series G Coaxial Cable Bulkhead Jack Connectors shown in Figure 1. The jacks are crimped onto RG-179/U, RD-179 (double braid), and .086 conformable cable using AMP PRO-CRIMPER* II Frame Assembly 354940-1 (408-9930), which accepts interchangeable crimping die assemblies.

NOTE

All dimensions are in millimeters [with inches in brackets].

Read these instructions carefully before assembling the jack connectors.

2. DESCRIPTION (Figure 2)

Series F jack connectors consist of a jack assembly, contact, ferrule, jam nut, lockwasher, and tubing.

Series G jack connectors consist of a jack assembly, contact, ferrule, and tubing.

NOTE

Not all dash numbers include each item listed.

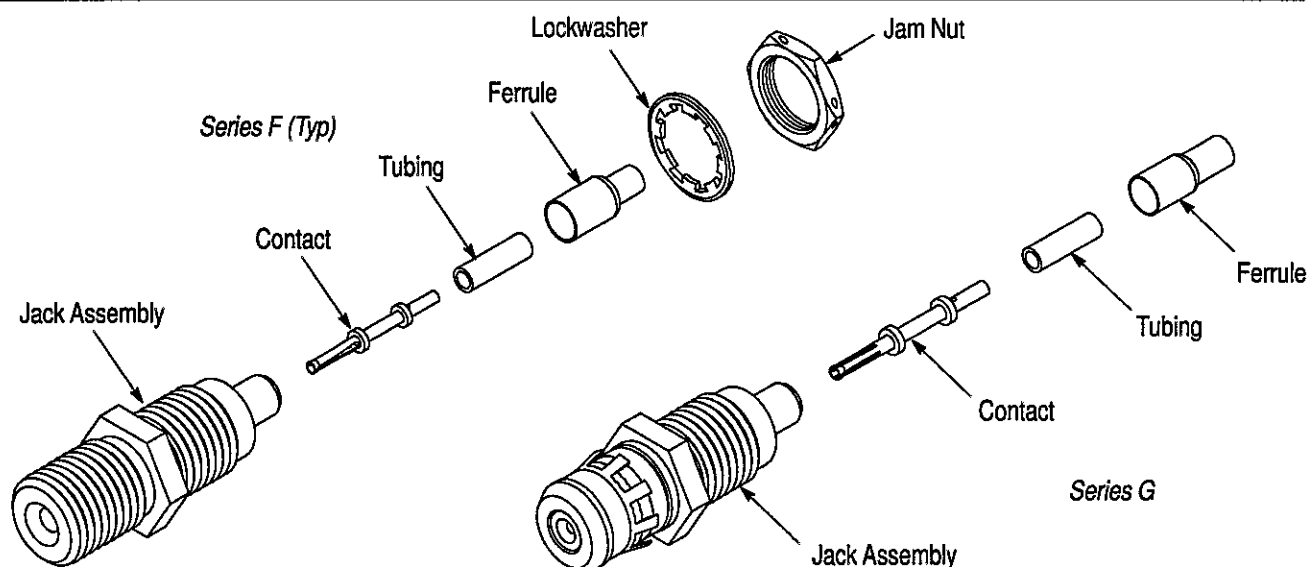


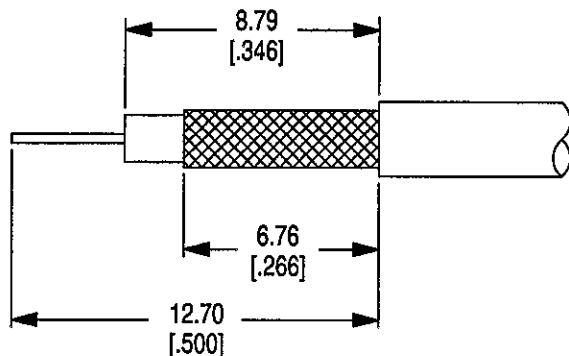
Figure 2

3. ASSEMBLY PROCEDURE

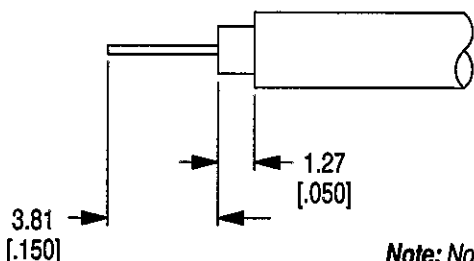
1. Slide ferrule onto unstripped cable; then strip cable using the appropriate dimensions provided in Figure 3. Do NOT nick or cut cable braid.

Recommended Cable Strip Length

For RG-179/U and RD-179 Cable



For .086 Conformable Cable



All strip dimensions have a tolerance of ± 0.25 [.010].

Note: Not to Scale

Figure 3

2. Flair braid and slide tubing onto cable dielectric beneath braid for RG-179/U and RD-179 cable only. Tubing is not used with conformable cable. See Figure 4.

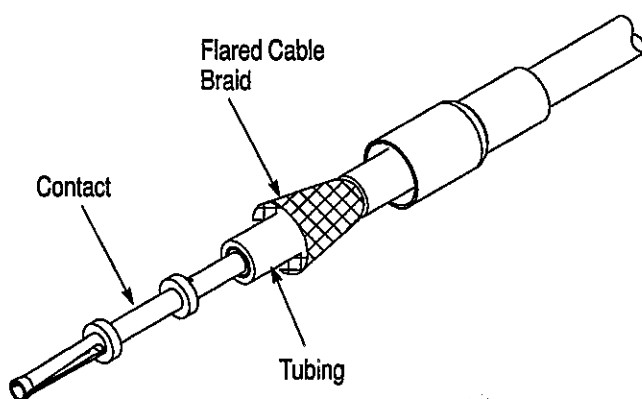


Figure 4

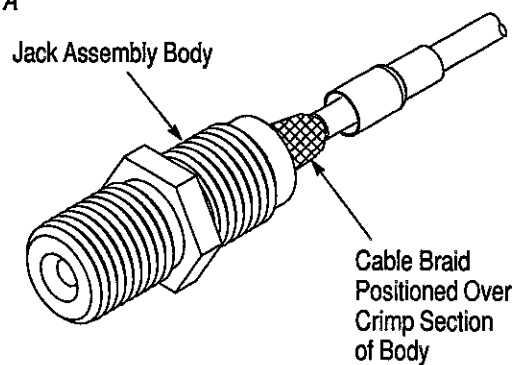
3. Insert cable center conductor into contact crimp end. Before crimping, be certain that the contact is

bottomed against the cable dielectric and held tight. Crimp using AMP PRO-CRIMPER II Frame Assembly 354940-1 fitted with appropriate die assembly.

4. Insert the crimped contact into the rear of the jack assembly body. Make sure braid is over the crimp section of the body for RG-179/U and RD-179 cable only. There is no braid on conformable cable. See Figure 5, Detail A.

5. Slide the ferrule over cable braid and bottom against the jack assembly body. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 5, Detail B.

Detail A



Detail B

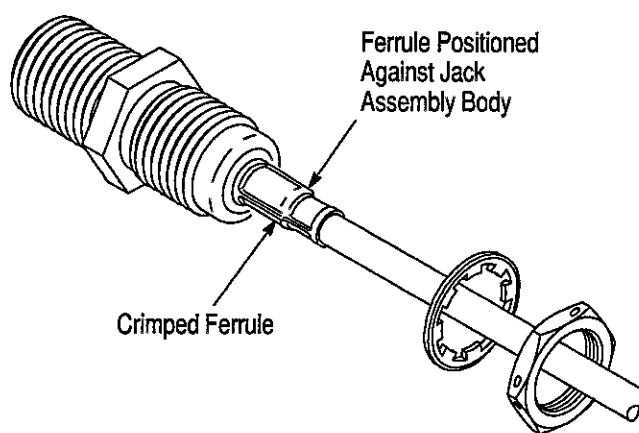


Figure 5

CAUTION

Be sure the center contact is fully inserted into the jack assembly body and held tight during crimping of the outer ferrule.

Improper termination of these connectors will result in a loss of both mechanical and electrical characteristics.