

■ Used for cable with air core dielectric only.

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* 50-Ohm RF Series Commercial TNC Plug Connectors (Hex Crimp Type) No. 222506-[]. The plug connectors accept a wide range of coaxial cables and are interchangeable with industry standard connectors. The plug connectors can be crimped using various hand tools, such as AMP PRO-CRIMPER* II Frame 354940-1 (408-9930) and Die Assembly 58436-[] (408-9657). The plug connectors can also be crimped with Hand Tool KTH1000, and Die Assemblies KTH2001 and KTH2002 from Kings Electronics†. (Any industry standard crimp tooling with equivalent crimp heights and lengths may be used in place of King's tooling.)

AMP Catalog 82074 provides a guide for cable-to-connector selection and recommended crimping tools. For cable sizes and connectors not referenced in the catalog, contact AMP Product Engineering for recommendations. For detailed crimping procedures, refer to the instructions packaged with the appropriate crimping tool.

NOTE Dimensions are in metric units [with U.S. customary units in brackets.]

Read these instructions carefully before assembling connectors.

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

2. DESCRIPTION (Figure 1)

Each TNC plug contains a plug body, a center contact, and a ferrule. See Figure 1. If the plug is to be used with a cable containing an air core dielectric, a spacer is provided. Also, tubing is provided for small cable sizes. Some connectors are also supplied with a step-down ferrule.

3. CRIMPING PROCEDURE

Select the appropriate cable, TNC plug, and application tooling.

NOTE See Figure 2 for orientation of step-down ferrule.

- Slide the ferrule over the unstripped cable end and strip the cable as shown in Figure 2. Be sure that the center conductor is straight and free of burrs, and that the cable braid is not nicked.

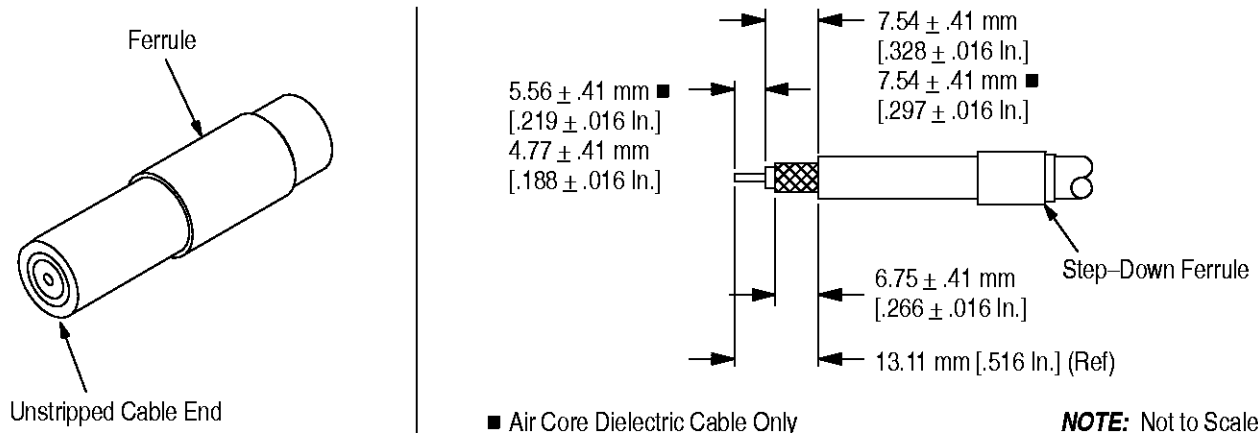


Figure 2

NOTE: Not to Scale

NOTE

If a plastic spacer or tubing is provided with the connector, they must be installed before the center contact is crimped. Position the spacer over the center conductor and against the air-core dielectric. To install the tubing, slip it over the cable dielectric prior to assembly of the center contact. Refer to the AMP customer drawing for part availability.

2. Slide center contact over center conductor of cable until the contact shoulder butts against the inner dielectric of the cable. See Figure 3.

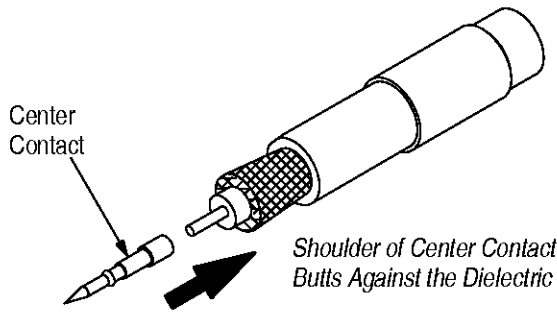
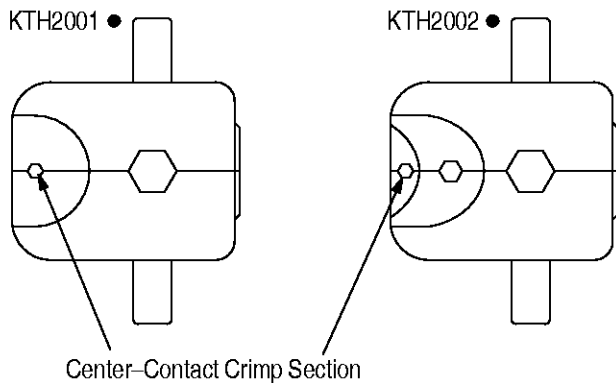
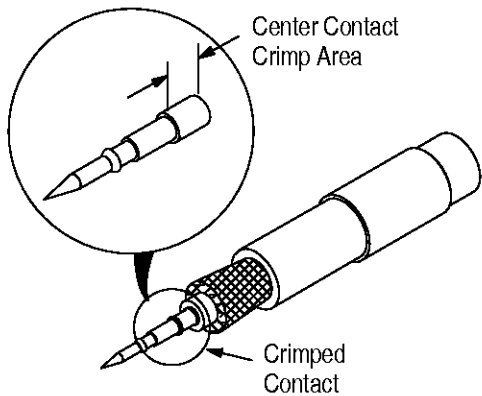


Figure 3

3. Crimp the center contact in the center-contact crimp section of die assembly. See Figure 4.



Refer to 408-9657 for AMP Crimping Dies 58436-[]

● Kings Part Nos. (Dies Used in Kings Tool No. KTH1000)

Figure 4

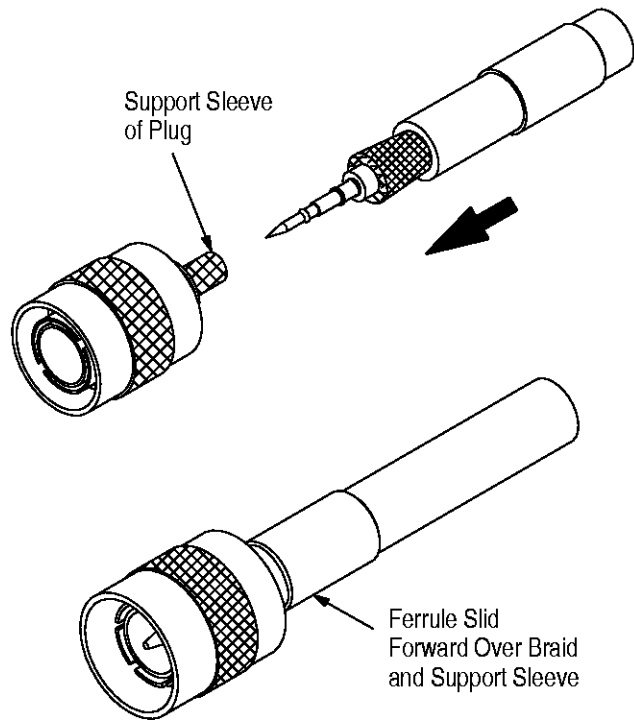


Figure 5

4. Flair the cable braid.
5. Insert the center contact into the plug body, making sure the cable braid is positioned over the support sleeve of the plug body. Figure 5.
6. Pull lightly on cable to be sure the center contact has snapped into place.
7. Slide metal ferrule over braid and support sleeve of plug body until it butts against shoulder of plug body. See Figure 6.
8. Crimp the ferrule in the ferrule-crimp section of die assembly. See Figure 7.

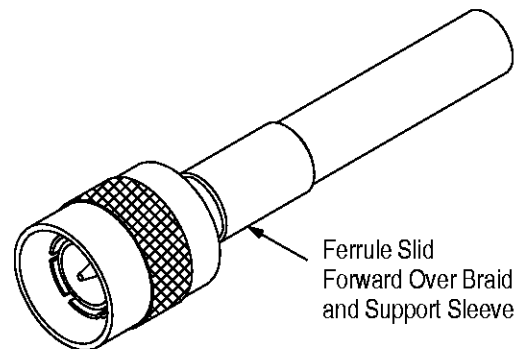
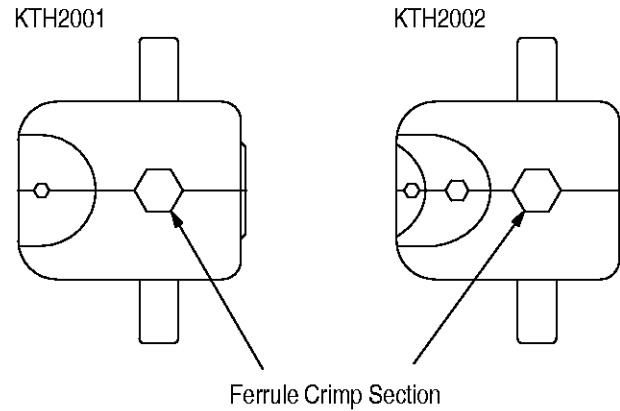
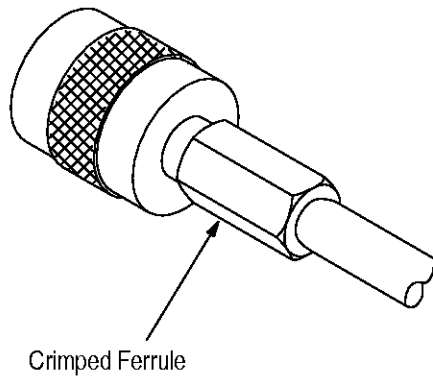


Figure 6



Refer to 408-9657 for AMP Crimping Dies 58436-[]

Figure 7

4. REVISION SUMMARY

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

Per EC 0990-1166-98

- Added step-down ferrule to Figures 1 and 2
- Added notes and information regarding step-down ferrule in Figure 1, Section 2, and Section 3
- Changed ferrule in Figure 7 to a hex crimp ferrule
- Changed PRO-CRIMPER II Hand Tool 58433-2 (408-9159) to PRO-CRIMPER II Frame 354940-1 (408-9930) in Section 1