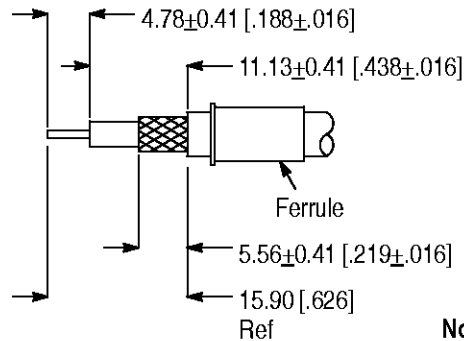


Figure 1

**Strip Length for Connectors 225395-[ ]  
(Except 2-225395-1) and 331350-[ ]**



Note: Not to scale

**1. INTRODUCTION**

AMP\* COAXICON 50-Ohm RF Series BNC Plug Connectors 225395-[ ], 225886-[ ], and 331350-[ ] are crimped onto coaxial cable using CERTI-CRIMP\* Hand Tool 69477-2 (408-2329), PRO-CRIMPER\* II Hand Tool Frame 354940-1 (408-9930) fitted with appropriate die assembly, or 626 Pneumatic Tooling Assemblies 189721-[ ] or 189722-[ ] fitted with appropriate tool holder or adapter, crimping head, and die set (409-5862).

For a cross-reference of connector-to-cable and applicable tools and die assemblies, refer to AMP Catalog 82074. For detailed information on the tooling, refer to the applicable instructions (408- or 409-series).

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

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

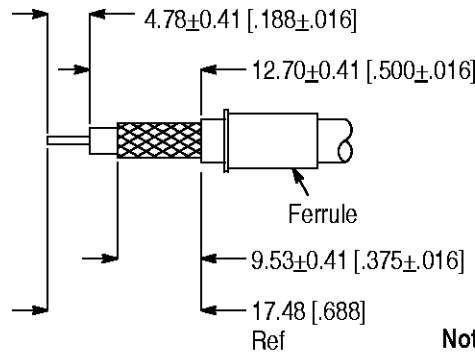
**2. DESCRIPTION** (Figure 1)

The plug connector consists of a plug body, a center contact, and a ferrule or step-down ferrule. Some connectors are also supplied with a tubing to compensate for small diameter cable dielectrics.

**3. ASSEMBLY PROCEDURE**

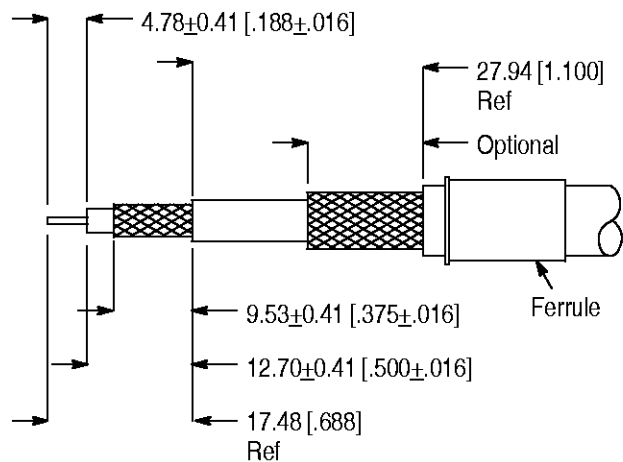
- Slide ferrule onto unstripped cable so that the flange will face the connector; or slide step-down ferrule onto unstripped cable with small opening first. Strip cable using the appropriate strip-length dimensions shown in Figure 2. DO NOT nick or cut cable braid. Center conductor must be straight and free of burrs.

**Strip Length for Connectors 225886-[ ] and  
2-225395-1**



Note: Not to scale

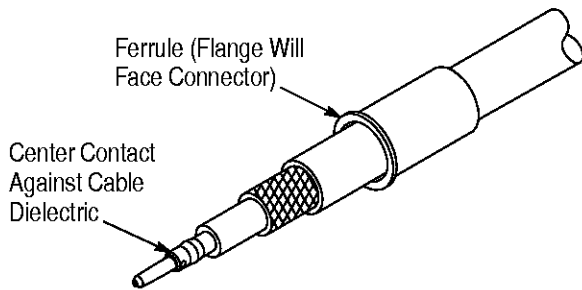
**Strip Length for Intercomp Cable RG-11/U  
Used with Connector 225886-6**



Note: Not to scale

Figure 2

2. If using tubing, slip the tubing over the cable dielectric as shown in Figure 3.
3. Insert center conductor into center contact until shoulder of contact is against dielectric of cable. See Figure 3.



—or—

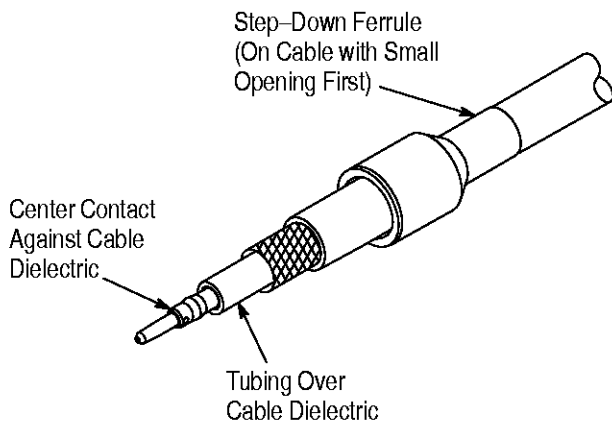


Figure 3

4. Crimp center contact using the recommended tooling.
5. Flare cable braid, and insert center contact into plug body, making sure that the cable braid is positioned over the support sleeve of the connector. See Figure 4.

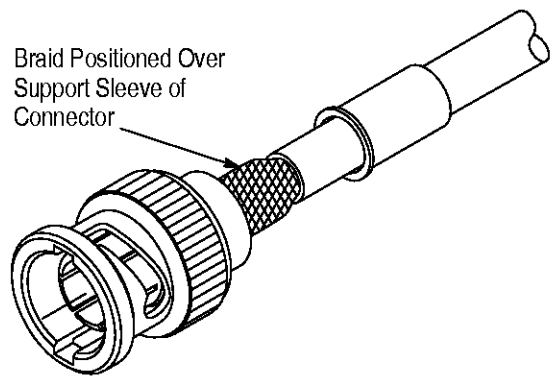


Figure 4

6. Slide ferrule over braid and support sleeve until the ferrule is positioned against the shoulder of the plug body. Crimp ferrule using the recommended tooling. See Figure 5.

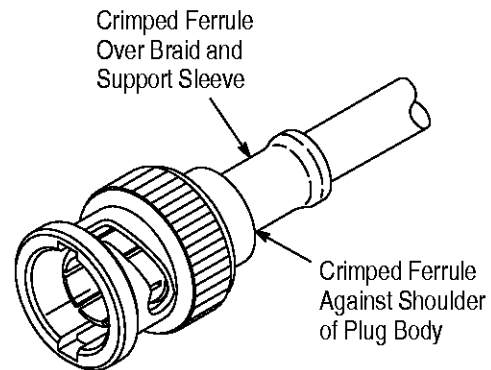


Figure 5

**4. REVISION SUMMARY**

Revisions to this instruction sheet per EC 0990-1003-98 include:

- Removed obsolete Plug Connector 225708-[ ]
- Added step-down ferrule and tubing
- Replaced Tool 69477-2 with Frame 354940-1
- Replaced Tools 69365 and 69365-3 with Tooling Assemblies 189721-[ ] and 189722-[ ]