

Figure 1

### 1. INTRODUCTION

This instruction sheet covers the assembly of AMP\* 50-Ohm RF Series BNC Dual Crimp Jack Connectors 225396-[ ] and 331351-[ ]. The connectors are crimped onto various sizes of RG/U cable using AMP CERTI-CRIMP\* Hand Tools, such as 69477-2 (408-2329) and AMP PRO-CRIMPER\* II Frame Assembly 354940-1 (408-9930), which accepts interchangeable crimping die assemblies.

AMP Catalog 82074 provides CERTI-CRIMP hand tool part numbers and die assembly part numbers for the frame assembly, product application requirements, cable selection, and product part number information. For information not listed, contact AMP Engineering for recommendations.

**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 consists of a jack body, a center contact, and a ferrule (some ferrules are designed with a flange). The center contact is crimped onto the

cable center conductor and assembled onto the jack body. The ferrule is then crimped onto the cable braid and jack body to complete the assembly.

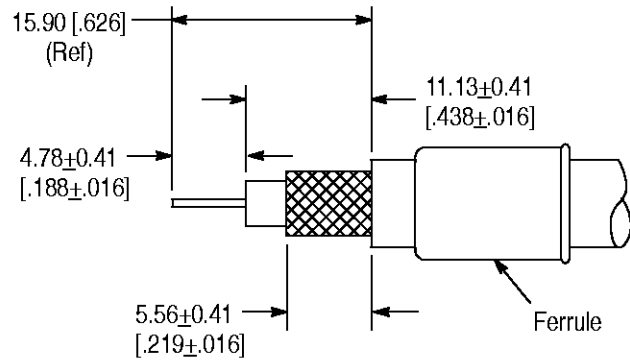
Some connectors are supplied with a step-down ferrule and a bushing. The bushing is slipped over the cable dielectric before the center contact is crimped. In this use, the bushing compensates for small diameter cable dielectrics.

### 3. ASSEMBLY PROCEDURE

- Slide ferrule onto unstripped cable; then strip cable using the appropriate dimensions provided in Figure 2. Do NOT nick or cut cable braid. Center connector must be straight and free of burrs.

**NOTE** If using a step-down ferrule, slide it onto the cable with the small opening first.

#### Recommended Cable Strip Length



**NOTE:** Not to Scale

Figure 2

**NOTE** For connectors supplied with a bushing, slip the bushing over the cable dielectric before applying center contact. Refer to Figure 3.

- Insert center conductor into center contact. The center contact shoulder must be positioned against the cable dielectric, as shown in Figure 3. Be sure the cable insulation does not enter the center contact wire barrel.

- Crimp the center contact with the recommended frame assembly fitted with the appropriate die assembly.

- Flare cable braid to allow the support sleeve of the jack body to pass under the cable braid. Refer to Figure 3.

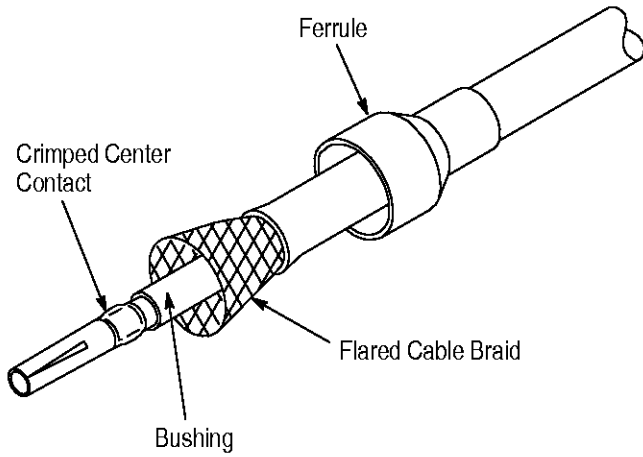


Figure 3

5. Insert center contact into jack body. The cable braid must be positioned over the jack body support sleeve. See Figure 4, Detail A.

6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the jack body. See Figure 4, Detail B.

7. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 4, Detail B.

**4. REVISION SUMMARY**

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

Per EC 0990-1038-98

- Entire document was revised, including text and artwork

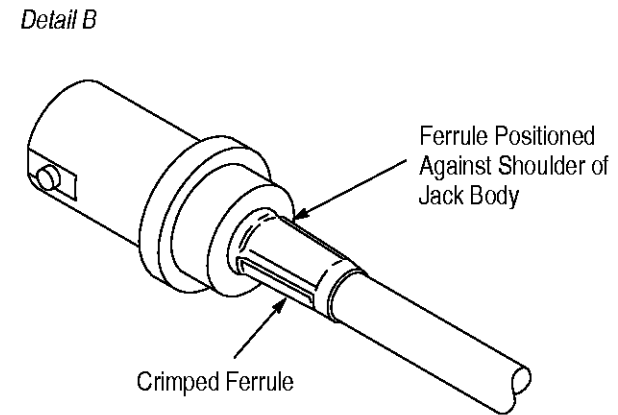
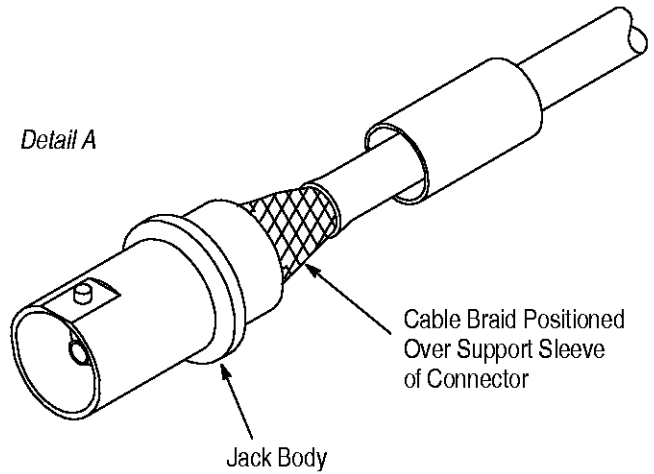


Figure 4