

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly procedures for AMP\* 50-Ohm N Series Hex Crimp Right Angle Plug Connectors 415255-[ ]. The connectors are crimped onto flexible coaxial cable using the AMP PRO-CRIMPER\* II Frame Assembly 354940-1 or 626 Series Pneumatic Hand Tool with Head Assembly 679304-1.

For the selection of connector part numbers, cable sizes, and recommended crimping tools, refer to the AMP customer drawing for the specific connector, or see AMP catalog 82074.

**NOTE**

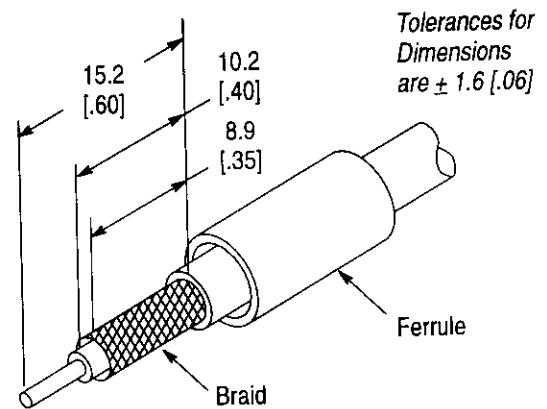
All dimensions are in millimeters [with inch equivalents in brackets]. Figures are for identification only, and are not drawn to scale.

## 2. DESCRIPTION (Figure 1)

The right angle plug consists of a plug assembly, center contact, and a ferrule.

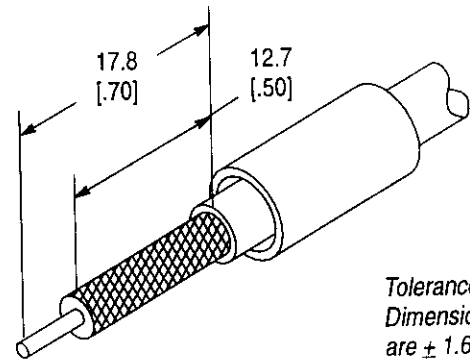
## 3. ASSEMBLY PROCEDURE

- Slide ferrule onto unstripped cable; then strip cable using the recommended strip-length dimensions in Figure 2 or 3. DO NOT nick or cut cable braid. Center conductor must be straight and free of burrs.



**NOTE:** For Part Numbers 415255-1 and -2 Only.

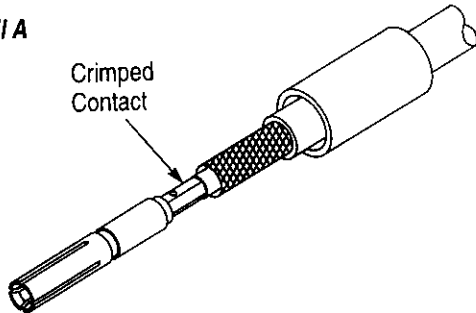
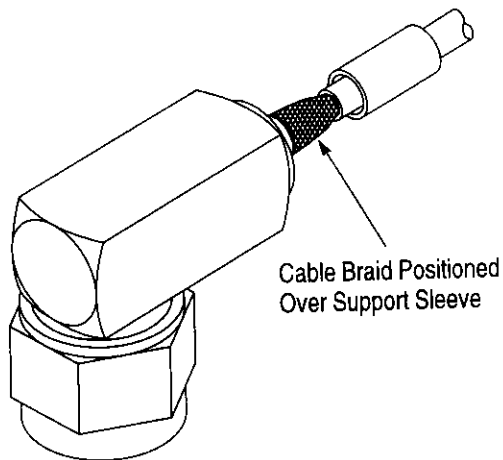
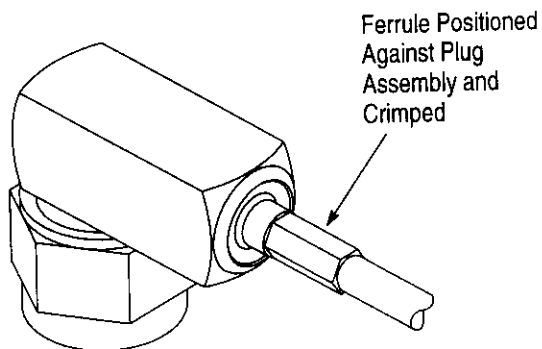
Figure 2



**NOTE:** For Part Numbers 415255-3 through -5 Only.

Figure 3

2. Insert center conductor into center contact; then crimp contact using the appropriate crimping tool. See Figure 4, Detail A.
3. Flare cable braid. Insert center contact into plug assembly until it snaps into place. Make sure the cable braid is positioned over the support sleeve of the connector. See Figure 4, Detail B.
4. Slide ferrule over braid and support sleeve; then crimp ferrule using the appropriate crimping tool. See Figure 4, Detail C.

**Detail A****Detail B****Detail C****Figure 4**