

NOTE: When assembling the step-down ferrule over the cable braid, make sure the large diameter end faces the jack body.

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* 50-Ohm BNC and TNC dual crimp jack connectors 228979-[] and 414171-[]. The connectors are applied using the AMP PRO-CRIMPER* II frame assembly 354940-1, which accepts different crimping die assemblies according to the cable type being used with the connector. For information on cable sizes, and connector part numbers, refer to AMP Catalog 82074.

NOTE All dimensions on this document are in metric units [with U.S. customary units in brackets].

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

Each connector features a center contact, a jack body, and a ferrule. The center contact is crimped to the cable's center conductor, and the ferrule is crimped onto the back of the connector, over the cable braid, to secure the cable to the jack body.

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

3. ASSEMBLY PROCEDURE

See Figure 2 on the following page; read thoroughly before proceeding.

4. REVISION SUMMARY

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

Per EC 0990-0694-98:

- Added tubing in Figure 1
- Added notes regarding step-down ferrule
- Added step-down ferrule to Step 2 illustration in Figure 2

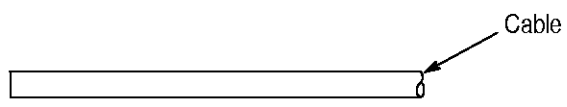
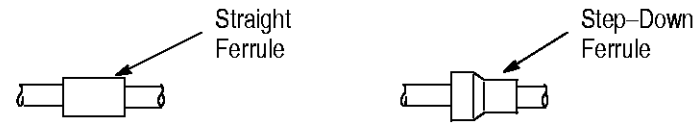
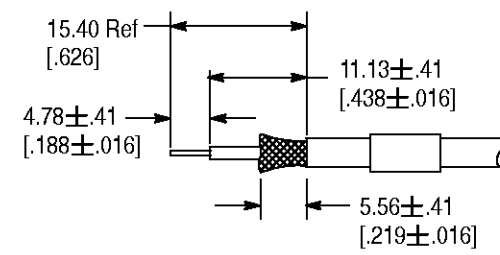
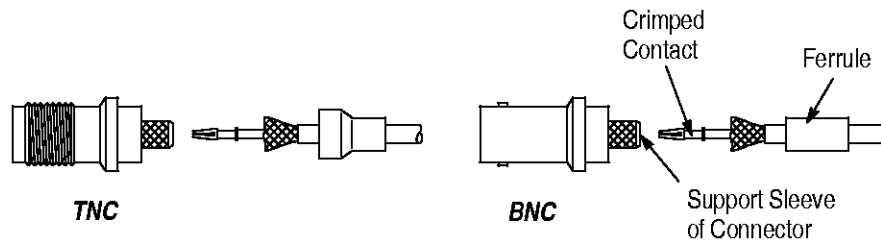
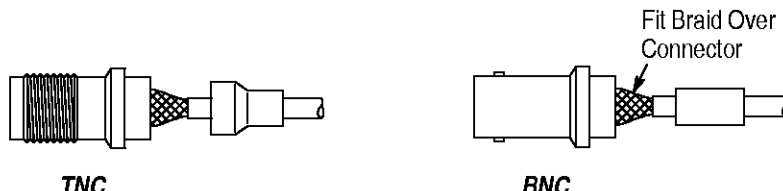
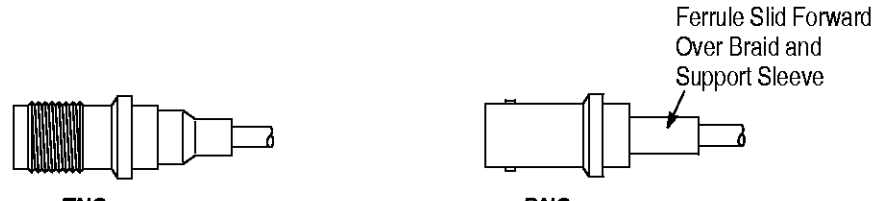

<p>1. Determine the cable type for your application, then select an appropriate connector. Refer to AMP Catalog 82074.</p>	
<p>2. Slide the ferrule over the cable end.</p> <p>NOTE: If using a step-down ferrule, slide it onto the cable with the small opening first.</p>	
<p>3. Strip the cable according to these dimensions:</p> <p>NOTE: Not to scale.</p> <p>NOTE: On connectors where tubing is provided, slide tubing over dielectric of cable before crimping contact.</p>	
<p>4. Crimp the center contact using the tooling referenced in AMP Catalog 82074.</p>	
<p>5. Insert the crimped center contact into the jack, with the cable braid over the support sleeve on the jack body.</p>	
<p>6. Slide the ferrule forward over the braid and the support sleeve.</p>	
<p>7. Crimp the ferrule with the appropriate tooling.</p>	

Figure 2