AMP

75–Ohm RF Series BNC Bulkhead Jack Hex Crimp Connectors 413590–[ ]

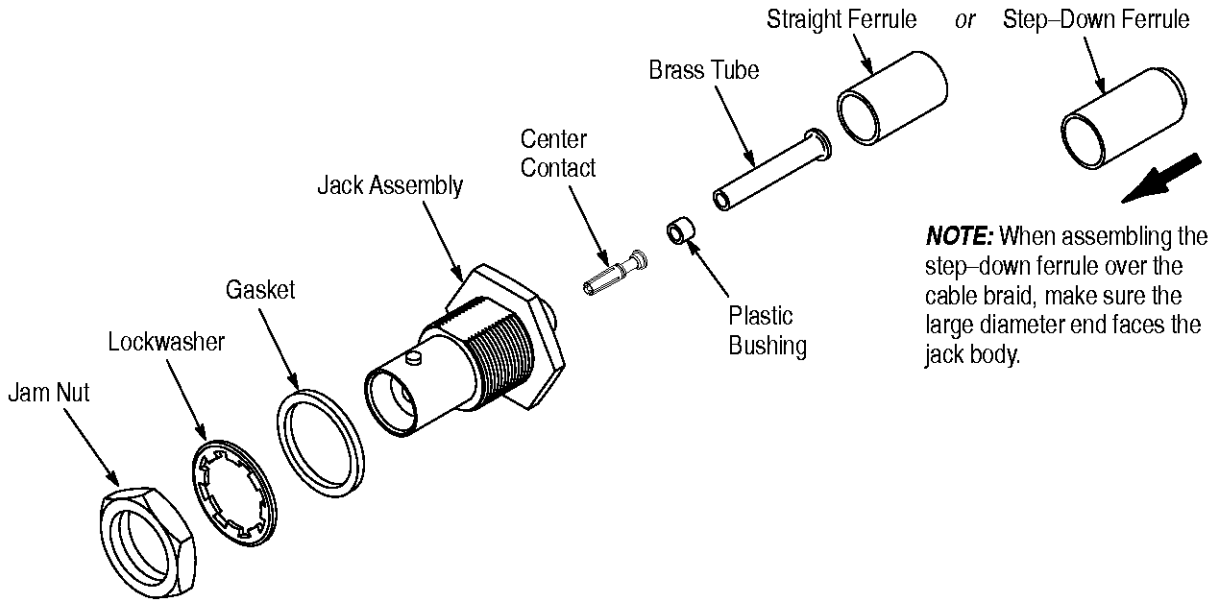


Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* 75–Ohm RF Series BNC Bulkhead Jack Hex Crimp Connectors 413590–[ ]. The connector is crimped onto various sizes of RG/U cable using AMP PRO–CRIMPER* II Frame Assembly 354940–1, which accepts interchangeable crimping die assemblies. Refer to instruction sheet 408–9930 for procedures concerning the operation of the frame assembly.

AMP Catalog 82074 provides 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 *All dimensions on this sheet are in millimeters [with inch equivalents provided in brackets]. Figures and illustrations are for identification only and are not drawn to scale.*

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

2. DESCRIPTION (Figure 1)

Each connector consists of a center contact, a jack assembly, a ferrule, a lockwasher, a jam nut, and a gasket. The center contact is crimped onto the cable center conductor and assembled into 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, a plastic bushing, and a brass tube. The plastic bushing and brass tube are slipped over the cable dielectric before the center contact is crimped. In this use, the busing and tube compensate for small diameter cable dielectrics.

3. ASSEMBLY PROCEDURE

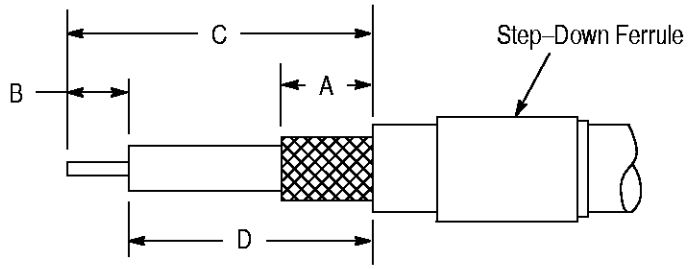
1. Slide ferrule onto unstripped cable; then strip cable using the appropriate dimensions provided in Figure 2. Do not nick or cut cable braid. Center conductor must be straight and free of burrs.

NOTE *Refer to Figure 2 for orientation of step–down ferrule. For connectors supplied with bushing and tube, slip tube (flared end first), then bushing over the cable dielectric, as shown in Figure 3.*

2. 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.

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

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



CONNECTOR PART NUMBER	STRIP–LENGTH DIMENSIONS			
	A (Ref)	B	C	D
413590–[ ]	5.94 ± .41 [.234 ± .016]	3.96 ± .41 [.156 ± .016]	19.84 ± .41 [.781 ± .016]	15.88 ± .41 [.625 ± .016]
	9.12 ± .41 [.359 ± .016]●			

● For 413590–5 Only

Figure 2

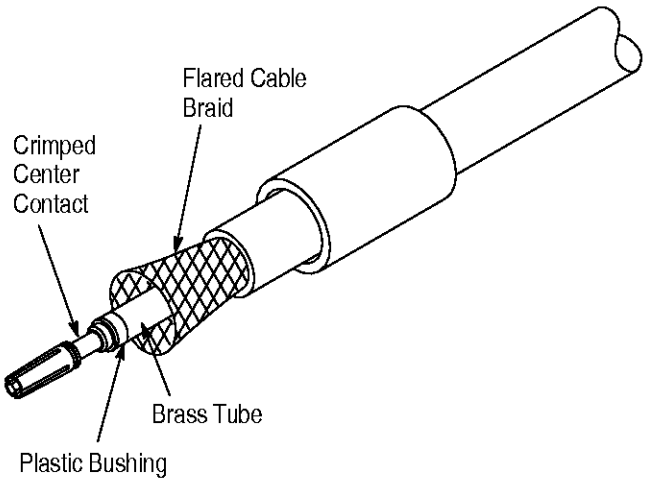


Figure 3

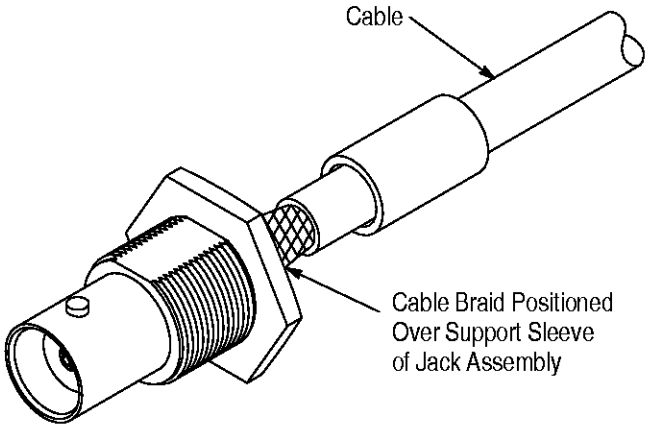


Figure 4

5. Insert contact assembly into jack assembly until it snaps into place. Make sure cable braid is positioned over the support sleeve of the jack assembly. Gently pull back on the cable to ensure that the contact is held in place by the internal locking feature. See Figure 4.

6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the jack body. See Figure 5.

7. Crimp ferrule using the hand tool (fitted with the appropriate die assembly). See Figure 5.

8. Make the panel cutout using the dimensions shown in Figure 6. Install gasket onto connector assembly; then insert assembly through the panel cutout and secure it with the lockwasher and jam nut.

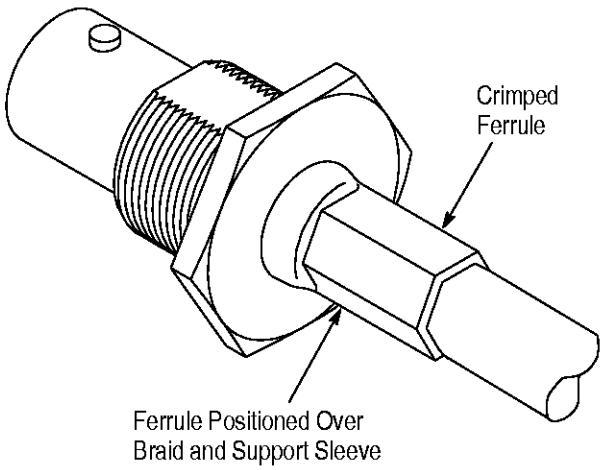


Figure 5

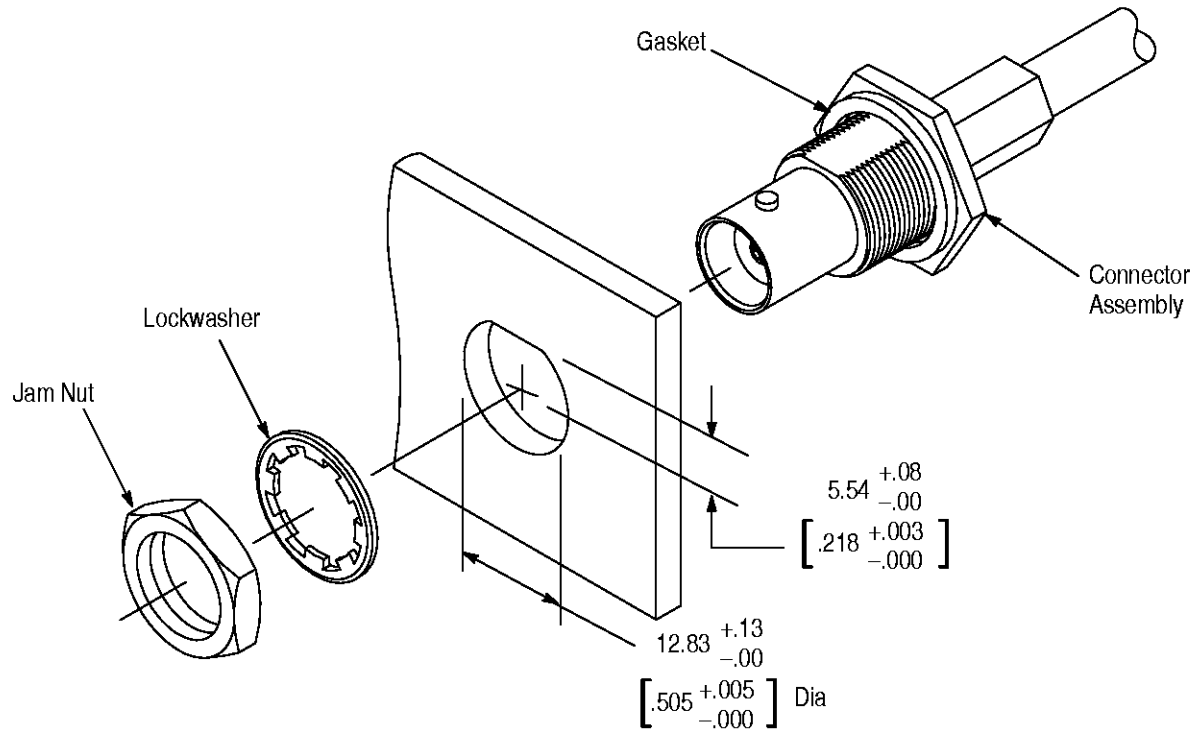


Figure 6

4. REVISION SUMMARY

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

Per EC 0990–0143–98

- Added plastic bushing, brass tube, and step–down ferrule to Figure 1.
- Updated Sections 1, 2, and 3.
- Deleted old Figure 2.
- Added step–down ferrule to Figure 2.
- Added plastic bushing and new callouts to Figure 3.
- Corrected metric dimensions in Figures 2 and 6.