

Figure 1

1. INTRODUCTION

AMP* 75-Ohm RF Series BNC Coaxial Hex Crimp Jack Connectors 413760-[] are terminated onto various sizes of RG/U cable using AMP PRO-CRIMPER* II Hand Tool Frame Assembly 354940-1, which accepts interchangeable crimping die assemblies.

For a cross-reference of crimping die assembly part numbers, cable selection, and connector part numbers, refer to AMP Catalog 82074. For information not listed, contact AMP Engineering for recommendations. Refer to Instruction Sheet 408-9930 for detailed information on the hand tool frame assembly.

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

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

2. DESCRIPTION (Figure 1)

Each connector consists of a center contact, jack body, and straight ferrule or step-down ferrule. In addition, some connectors are supplied with a plastic bushing and brass tube.

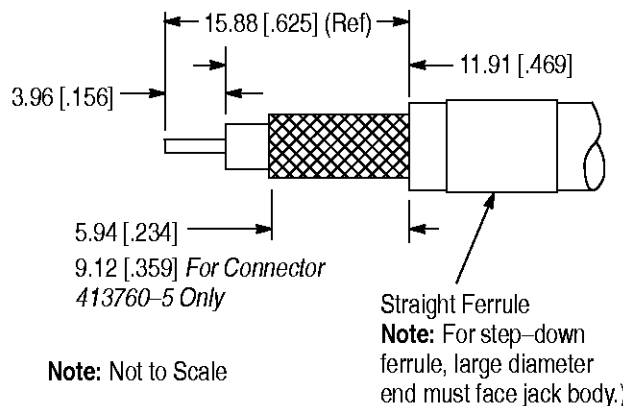
The center contact is crimped onto the cable center conductor, then assembled onto the jack body. The ferrule is crimped onto the cable braid and jack body to complete the assembly. The bushing and tube are slipped over the dielectric before the center contact is crimped to compensate for small diameter cable.

3. ASSEMBLY PROCEDURE

Determine cable type for your application; then select the appropriate connector. Proceed as follows:

1. Slide ferrule over unstripped cable end; for the step-down ferrule, make sure the large diameter end will face the jack body.
2. Strip cable using the recommended strip-length dimensions provided in Figure 2. Do not nick or cut the cable braid. Center conductor must be straight and free of burrs.

Strip-Length Dimensions (± 0.41 [$\pm .016$])



Note: Not to Scale

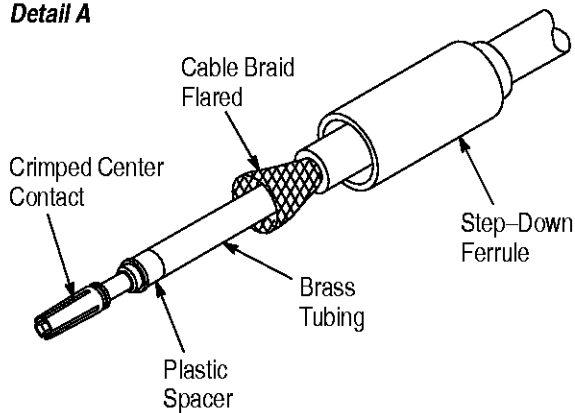
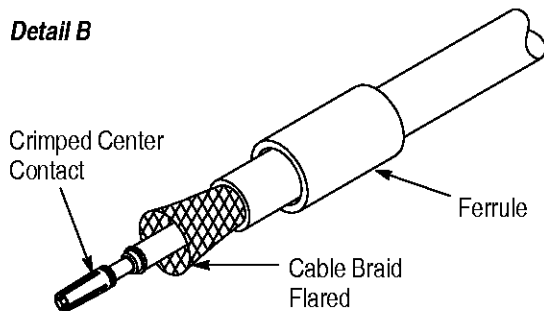
Figure 2

3. For connectors supplied with the bushing and tube, slip the tube (flared end first), then the bushing over the cable dielectric, as shown in Figure 3, Detail A.

4. Insert cable center conductor into center contact. The center contact shoulder must be positioned against the cable dielectric, as shown in Figure 3, Detail A or B. Make sure that the cable insulation does not enter the center contact wire barrel.

5. Crimp center contact using the hand tool frame assembly fitted with the appropriate die assembly.

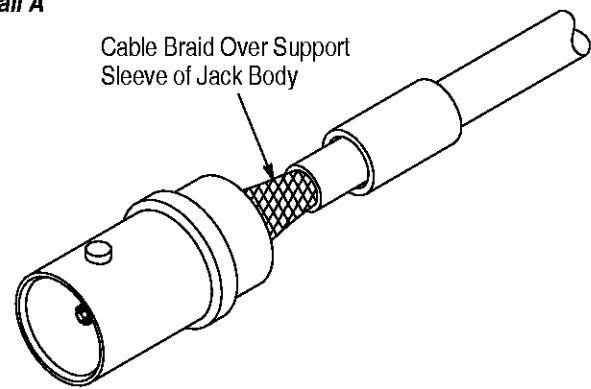
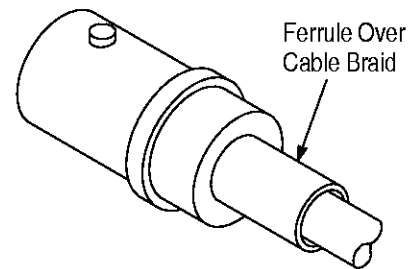
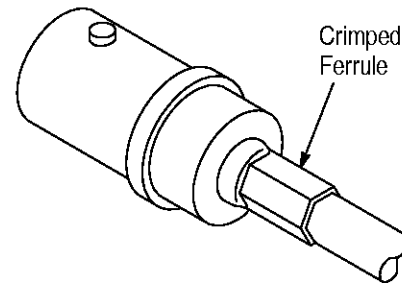
6. Flare the cable braid to allow the support sleeve of the jack body to pass under the cable braid. See Figure 3, Detail A or B.

Detail A**Detail B***Figure 3*

7. Insert the center contact into the jack body (with the braid over the support sleeve of the jack body) until it snaps into place. Gently pull back on the cable to ensure that the center contact is held into place by the internal locking feature. See Figure 4, Detail A.

8. 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.

9. Crimp the ferrule using the hand tool frame fitted with the appropriate die assembly. See Figure 4, Detail C.

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

4. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0649-97 include:

- Added plastic bushing, brass tube, and step-down ferrule to Figures 1 and 3
- Added cable type
- Changed hand tool frame, instruction sheet reference number, and removed catalog reference number in Section 1