

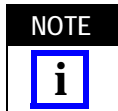
Note: When assembling the step-down ferrule over the cable braid, make sure the large diameter end faces the plug body.

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of 75-Ohm RF Series BNC Hex Crimp Plug Connectors 413589-[]. The connectors are terminated with Hand Tool 354940-1 which accepts interchangeable crimping dies.

For application and maintenance procedures of the hand tool, refer to instruction sheet 408-9930.



Dimensions on this instruction sheet are in millimeters [followed by inches 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.

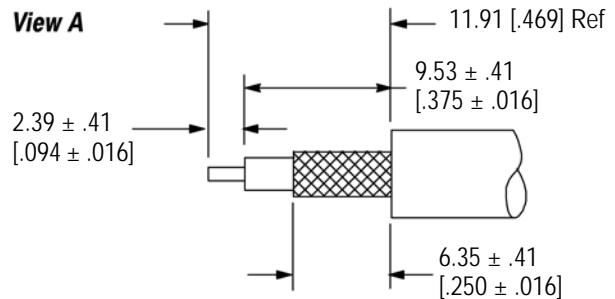
2. DESCRIPTION (Figure 1)

Each connector consists of a center contact, a plug assembly, and a ferrule. The center contact is crimped onto the cable center conductor and assembled into the plug body. The ferrule is then crimped onto the cable braid and plug body to complete the assembly.

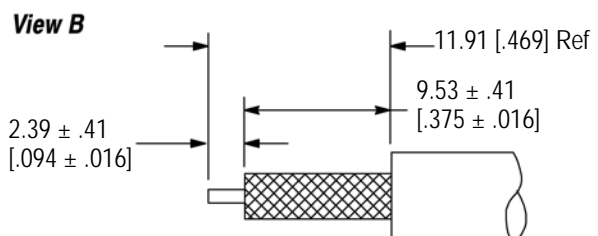
Some connectors are supplied with a step-down ferrule, a plastic bushing, and a brass tube. The plastic bushing and brass tube are slipped over the cable dielectric before the center contact is crimped. In this use, the bushing and tube compensate for small diameter cable dielectrics.

3. ASSEMBLY PROCEDURE

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



NOTE: All Part Numbers Except -5, -12



NOTE: P/N 413589-5 and 1-413589-2 Only

Figure 2



Refer to Figure 3 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.

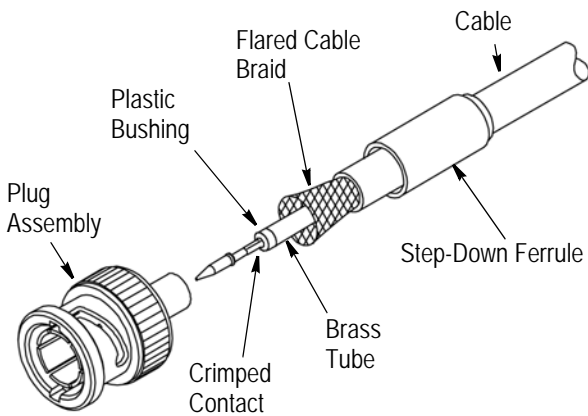


Figure 3

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 plug assembly to pass under the cable braid. Refer to Figure 3.

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

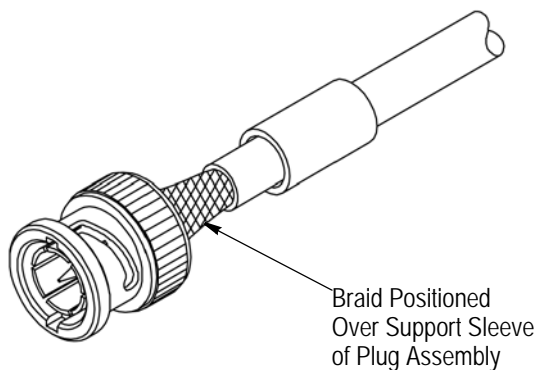


Figure 4

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

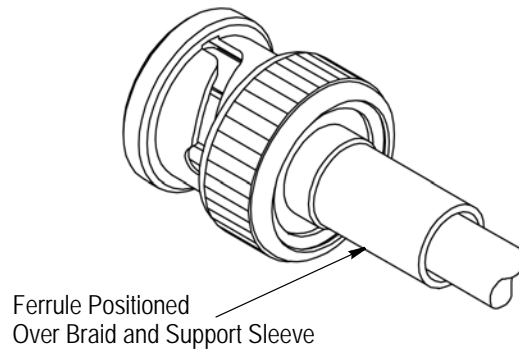


Figure 5

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

8. The finished plug should be as shown in Figure 6.

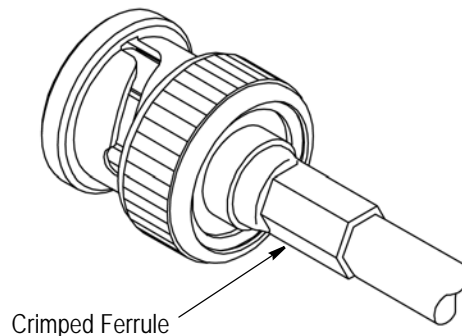


Figure 6

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo