

Figure 1

1. INTRODUCTION

These instructions cover the assembly procedure for 50-Ohm RF Series BNC Bulkhead Jack (Dual Crimp Type) Connectors 225398-[], 331693-[], and 414791-[]. The connectors are crimped onto flexible (braided) coaxial cable or coaxial ribbon cable using various TE tools, such as CERTI-CRIMP* Hand Tool 220187-1, PRO-CRIMPER* III Hand Crimping Tool 354940-1, Hand Crimping Tool 69710-1, or Pneumatic Tools 69365 or 69365-3.

For the selection of connector part numbers, cable sizes, and recommended crimping tools, refer to the customer drawing for the specific connector; or see the appropriate catalog for flexible coaxial cable assemblies, or for coaxial ribbon cable assemblies.

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

Reasons for reissue are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The bulkhead jack connector consists of a bulkhead jack body, a gasket, a lockwasher, a jam nut, a center contact, and a ferrule. 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

3.1. Flexible Coaxial Cable

NOTE *If using a step-down ferrule, slide it onto the cable with the small opening first.*

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

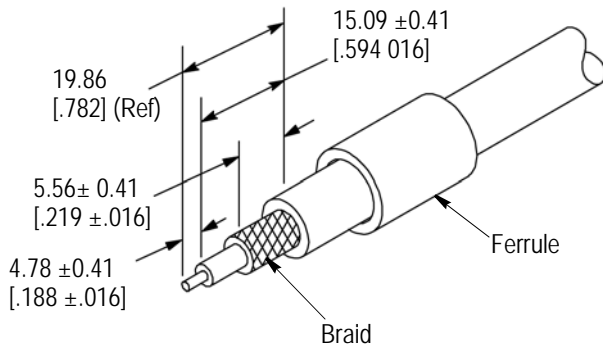
NOTE *For connectors supplied with tubing, slip tubing over the cable dielectric before applying center contact.*

2. Insert center conductor into center contact; then crimp contact using the appropriate crimping tool. See Figure 3, Detail A.

3. Flare cable braid. Insert center contact into bulkhead jack body, making sure the cable braid is positioned over the support sleeve of the connector. See Figure 3, Detail B.

4. Slide ferrule over braid and support sleeve; then crimp ferrule using the appropriate crimping tool. See Figure 3, Detail C.

**Recommended Strip-Length Dimensions
(For Flexible Coaxial Cable)**

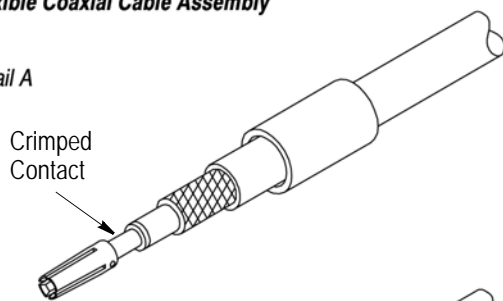


NOTE: Not to Scale

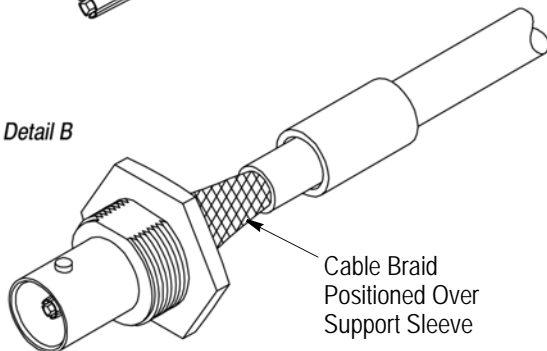
Figure 2

Flexible Coaxial Cable Assembly

Detail A



Detail B



Detail C

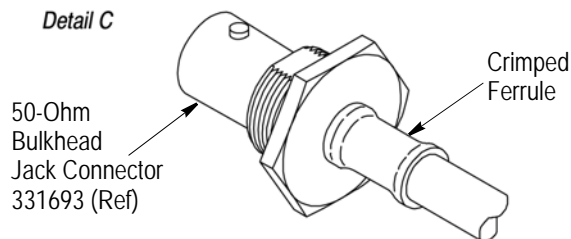


Figure 3

3.2. Coaxial Ribbon Cable

NOTE Discrete ribbon cable assemblies can be fabricated according to customer specifications. Refer to the appropriate catalog for additional information concerning custom ribbon cable assemblies.

NOTE If using a step-down ferrule, slide it onto the cable with the small opening first.

1. Prepare ribbon cable by making a slit in the insulation seam approximately 76-102 [3-4] long. Slide ferrule over the end of the cable. See Figure 4, Detail A.

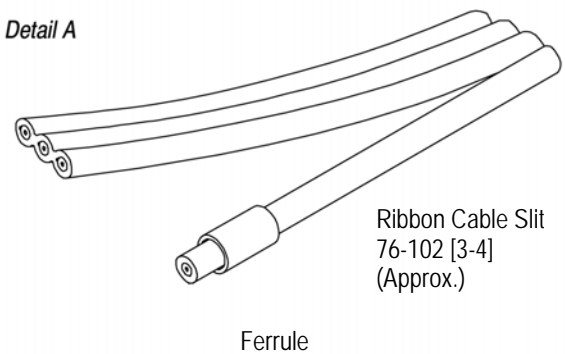
NOTE Do NOT pierce the insulation or cut the drain wire when slitting the cable.

2. Strip the cable using the dimensions in Figure 4, Detail B. Remove the foil around the exposed dielectric.

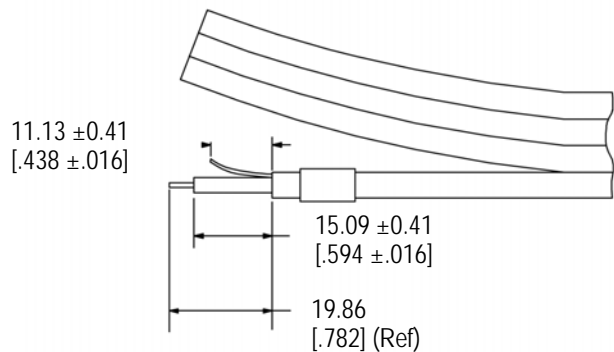
NOTE For connectors supplied with tubing, slip tubing over the cable dielectric and under the drain wire prior to assembly of the center contact.

**Recommended Strip-Length Dimensions
(For Coaxial Ribbon Cable)**

Detail A



Detail B

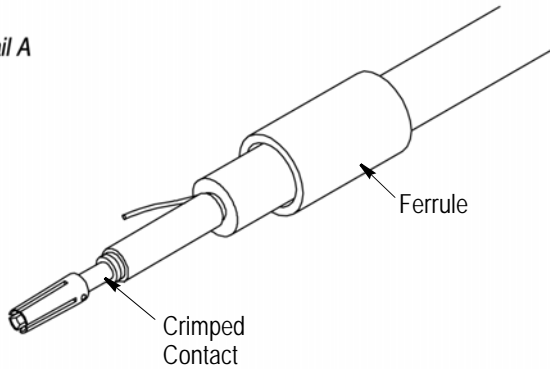


NOTE: Not to Scale

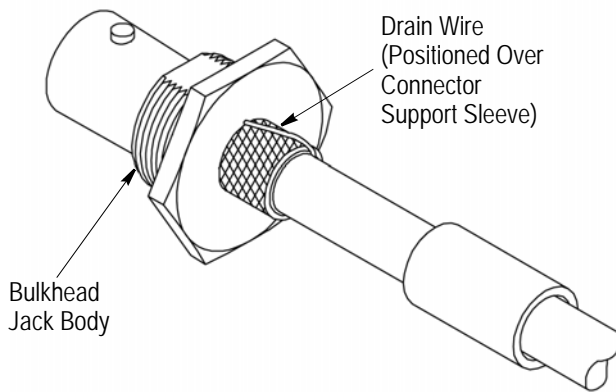
Figure 4

Coaxial Ribbon Cable Assemblies

Detail A



Detail B



Detail C

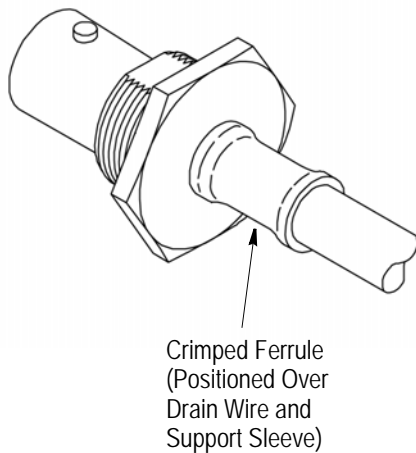


Figure 5

3. Insert center conductor into contact; then crimp contact using the appropriate crimping tool. See Figure 5, Detail A.

4. Insert center contact into bulkhead jack body, making sure that the drain wire is doubled over the connector support sleeve. See Figure 5, Detail B.

5. Slide ferrule over drain wire and support sleeve; then crimp the ferrule using the appropriate crimping tool. See Figure 5, Detail C.

4. PANEL MOUNTING

1. Make a cutout in the panel using the appropriate dimensions provided in Figure 6.

2. Assemble gasket onto connector assembly; then insert assembly into panel cutout, as shown in Figure 6.

3. Install lockwasher and jam nut to secure connector to panel.

5. REVISION SUMMARY

Since the previous release of this instruction sheet, the new company logo was applied.

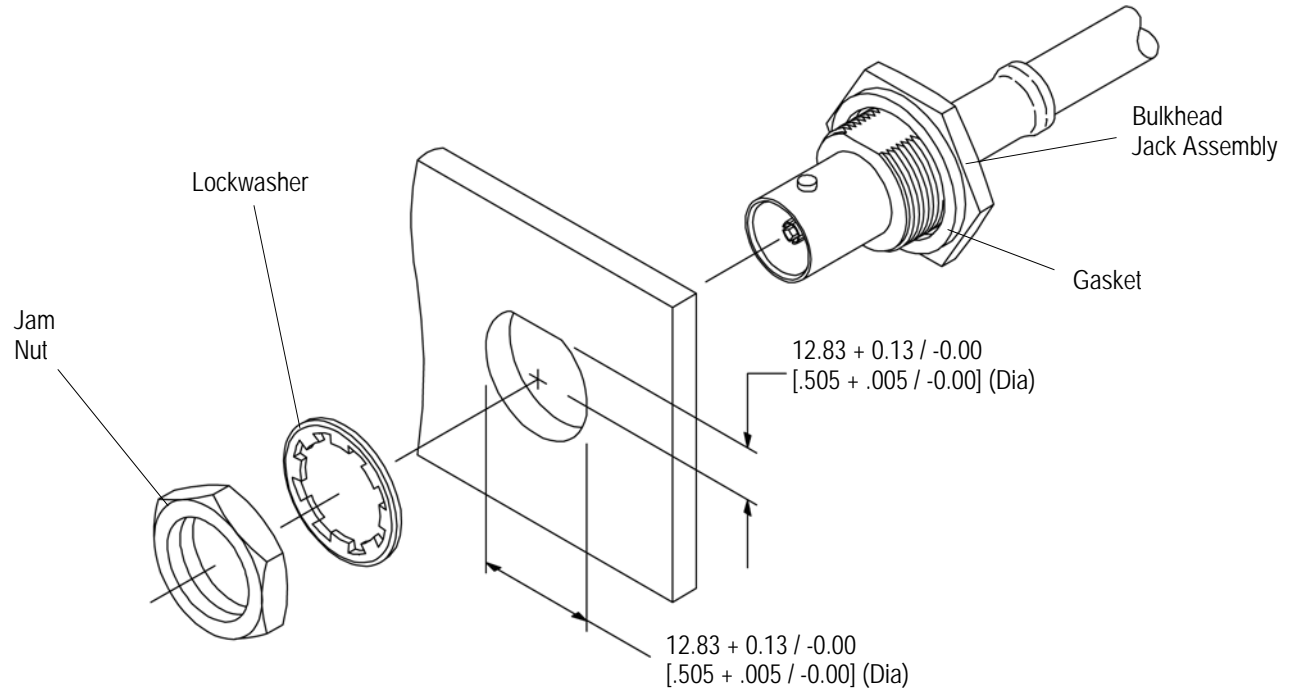


Figure 6