

Figure 1

## 1. INTRODUCTION

This instruction sheet covers assembly of 50-Ohm RF Series BNC Right-Angle Dual Crimp Plug Connectors 225973-[ ], 225974-[ ], and 415023-[ ]. The connectors are crimped onto various sizes of RG/U cable using Hand Tool 69477-2 (408-2329) and PRO-CRIMPER\* III Frame Assembly 354940-1 (408-9930).

Catalog 82074 provides cross-reference of hand tool-to-die assembly for the frame assembly, product application requirements, and cable selection.

**NOTE**



Dimensions in this instruction 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 plug body, a center contact, and a ferrule (some ferrules are designed with a flange). The center contact is crimped onto the cable center conductor and assembled onto 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 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

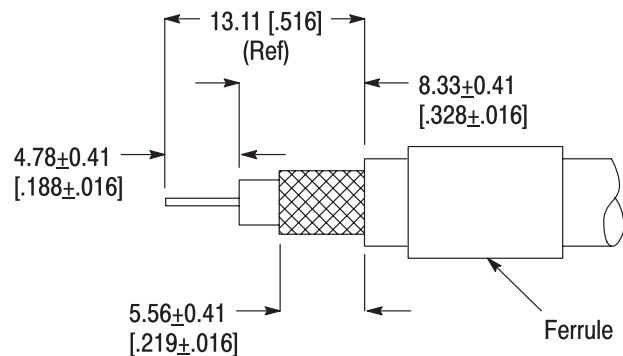
- Slide the ferrule onto an unstripped cable; then strip the cable using the dimensions provided in Figure 2. DO NOT nick or cut cable braid. The center connector must be straight and free of burrs.

**NOTE**



If using a step-down ferrule, slide it onto the cable with the small opening first. When assembling the step-down ferrule over the cable braid, make sure the large diameter end faces the plug body.

### Recommended Cable Strip Length



Note: Not to Scale

Figure 2

- For connectors supplied with tubing, slip the tubing over the cable dielectric before applying the center contact. Refer to Figure 3.
- Insert the cable center conductor into the center contact. The shoulder of the center contact must be positioned against the cable dielectric as shown in Figure 3. Be sure the cable insulation does not enter the center contact.
- Crimp the center contact with the recommended frame assembly fitted with the appropriate die assembly.
- Flare the cable braid to allow the support sleeve of the plug body to pass under the cable braid. Refer to Figure 3.

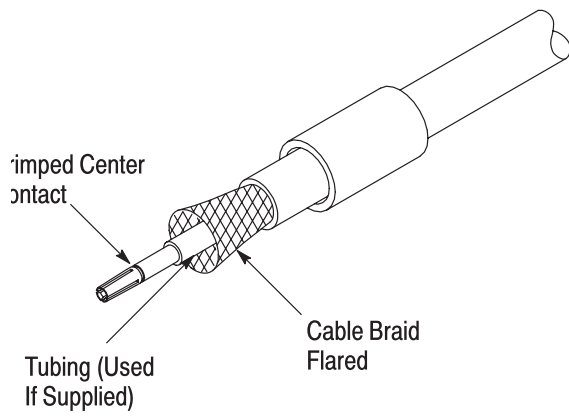


Figure 3

6. Insert the center contact into the plug body. The cable braid must be positioned over the support sleeve of the plug body. See Figure 4, Detail A.

7. Slide the ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the plug body. See Figure 4, Detail B.

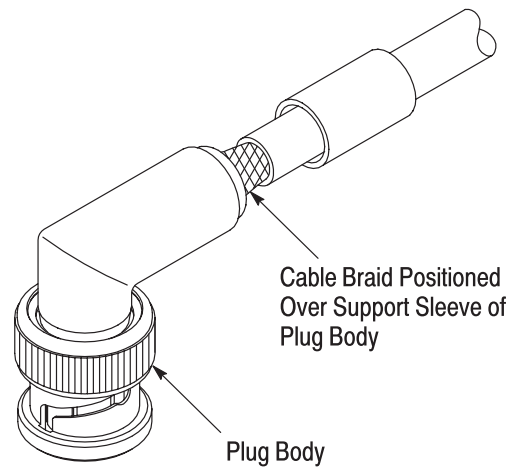
8. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 4, Detail B.

#### 4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements

Detail A



Detail B

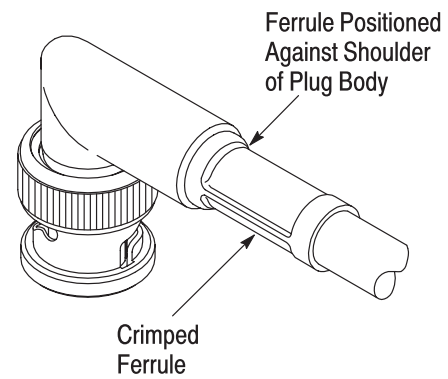


Figure 4