

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* Consumer 50-Ohm and 75-Ohm RF Series BNC plug connectors. 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.

The AMP customer drawing 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. Refer to instruction sheet 408-9930 for procedures concerning the operation of the frame assembly.

NOTE

Dimensions are in millimeters [followed by inches in brackets].

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 with a bayonet locking coupling, a center contact, and a straight ferrule or step-down ferrule. 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.

3. ASSEMBLY PROCEDURE

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

NOTE

Slide the step-down ferrule onto the unstripped cable with the small diameter end first. Refer to Figure 3.

- 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.

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

- Flare cable braid to allow the support sleeve of the plug body to pass under the cable braid.

Note: Not to Scale

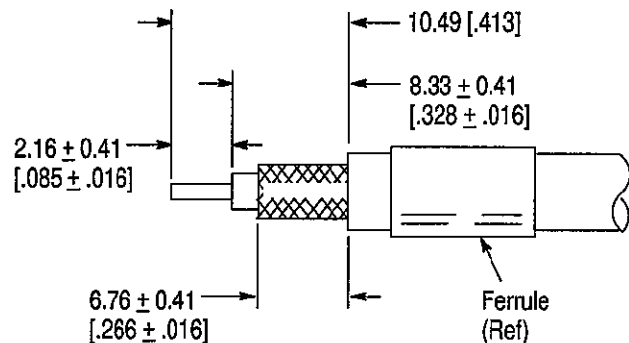


Figure 2

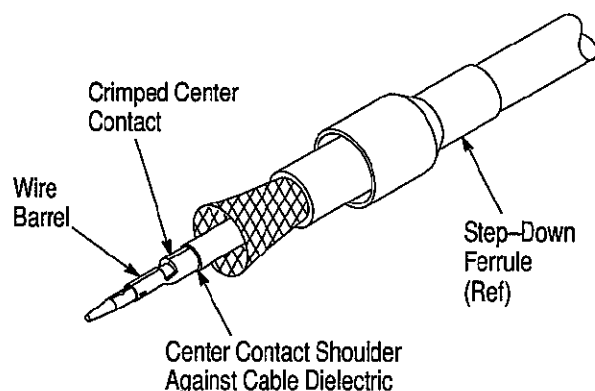


Figure 3

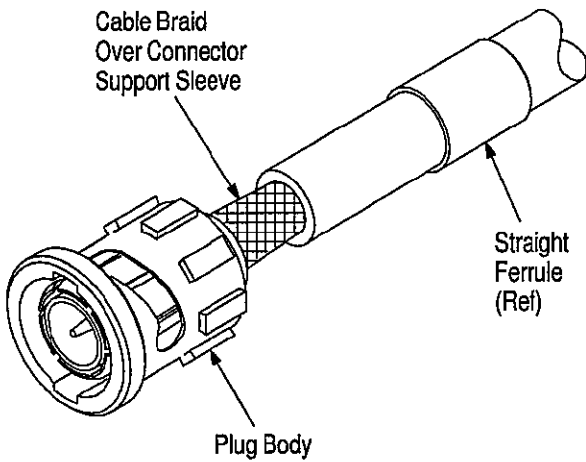


Figure 4

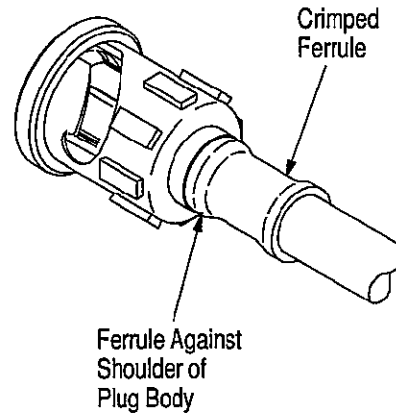


Figure 5

5. Insert center contact into plug body until it snaps into place. The cable braid must be positioned over the connector support sleeve. Pull back gently 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 plug body. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 5.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

Per EC 0990-0307-97:

- Added step-down ferrule