

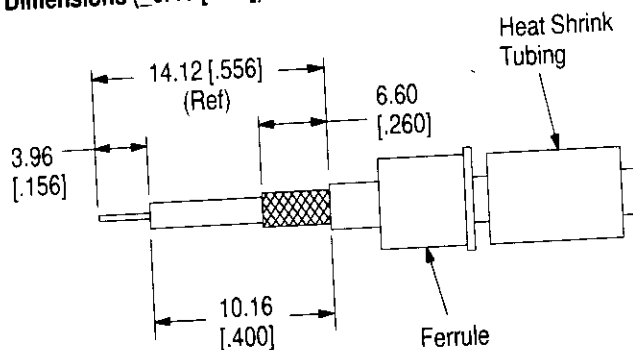
Figure 1

or cut cable braid. Center conductor must be straight and free of burrs.

NOTE

These components must be assembled onto the cable before crimping the center contact.

Recommended Strip-Length Dimensions (+0.41 [.016])



Note: Not to Scale

Figure 2

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* COAXICON 50-Ohm RF Series BNC Commercial (Polarized) O-Crimp Plug Connectors 415087-[]. The connectors are terminated onto various sizes of RG/U cable with AMP PRO-CRIMPER* II Hand Crimping Tool Frame Assembly 354940-1 when fitted with Crimping Die Assembly 220189-1.

For product application requirements, cable selection, and product part number information, contact AMP Engineering for recommendations. Refer to AMP Instruction Sheet 408-9930 for procedures concerning the operation and maintenance of the tool frame assembly and 408-2786 for the die assembly.

NOTE

Dimensions are in millimeters [followed by inches in brackets]. Figures are for identification only and 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 with a knurled coupling support sleeve, a center contact, a ferrule, and heat shrink tubing.

3. ASSEMBLY PROCEDURE

1. Slide heat shrink tubing, then ferrule over the cable end; then strip cable using the recommended strip-length dimensions in Figure 2. Do NOT nick

2. Slide the center contact over the cable center conductor until the shoulder of the center contact is positioned against the cable dielectric.

3. Crimp the center contact using the tool frame assembly fitted with the appropriate die assembly. See Figure 3.

4. Flare the cable braid, as shown in Figure 3, to allow the support sleeve of the plug body to pass under the cable braid.

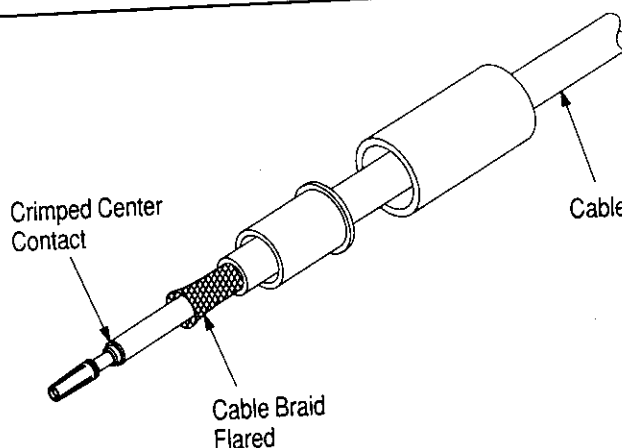


Figure 3

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

6. Slide ferrule forward over cable braid and plug body support sleeve; then crimp the ferrule using the tool frame assembly fitted with the appropriate die assembly. See Figure 4, Detail B.

7. Slide heat shrink tubing over ferrule until tubing is positioned against plug body support sleeve. Shrink tubing with an appropriate flameless heat source such as AMP Heat Gun 600655-2 or 606712-2. See Figure 4, Detail C.

DANGER

Refer to the instructions packaged with the heat gun for important safety precautions.

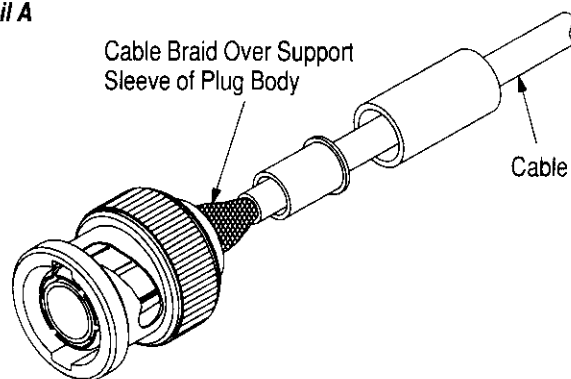
4. REVISION SUMMARY

Revisions to this instruction sheet include:

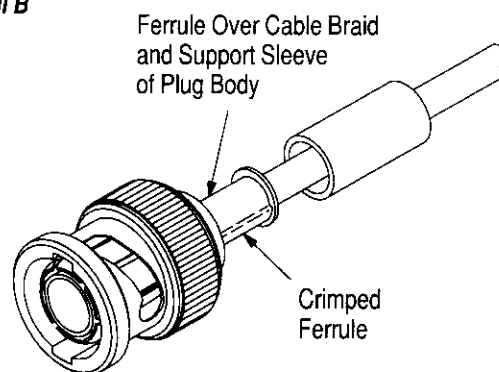
Per EC 0990-0128-96:

- Changed illustration of center contact
- Removed information from Section 3, Step 2 and added Step 3

Detail A



Detail B



Detail C

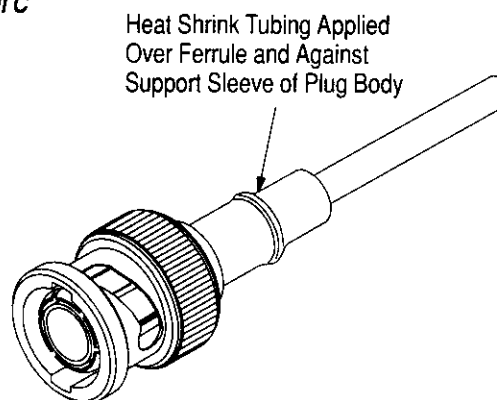


Figure 4