

**AMP**

AMP INCORPORATED  
HARRISBURG, PA 17105

AMP\* 50-OHM RF SERIES  
BNC PLUG CONNECTORS 221265-[ ]  
(Field Serviceable Type)

**IS 6851**

TOOLING ASSISTANCE 1 800 722-1111  
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RELEASED  
8-11-92

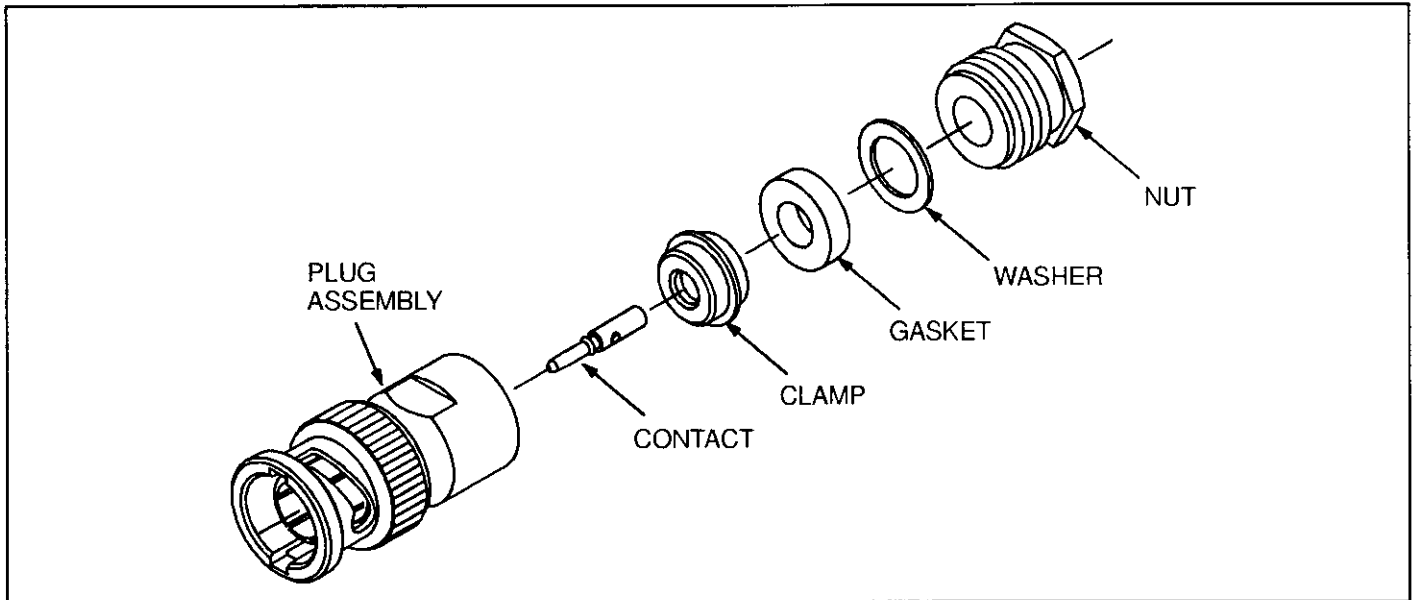


Fig. 1

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**1. INTRODUCTION**

This Instruction Sheet (IS) provides assembly procedures for AMP 50-Ohm RF Series BNC Plug Connectors 221265-[ ] designed for field service applications. Connector part numbers and cable sizes are available in AMP Catalog 82074. For cable sizes not listed in the catalog, contact AMP Product Engineering for connector recommendations.

**2. DESCRIPTION**

The connector consists of a plug assembly, a contact, a clamp, a gasket, a washer, and a nut. Details concerning product specifications are available in AMP Catalog 82074.

**3. ASSEMBLY PROCEDURE**

1. Slide nut, washer, and gasket over cable end; then strip outer cable jacket using the recommended strip-length dimension in Figure 2.
2. Slide clamp over cable braid and position it against the cable jacket. After clamp is properly positioned, comb out the braid. See Figure 3.

**NOTE**

*Measurements are in Metric units [followed by U.S. Customary units in brackets]. Illustrations are for identification only and are not drawn to scale.*

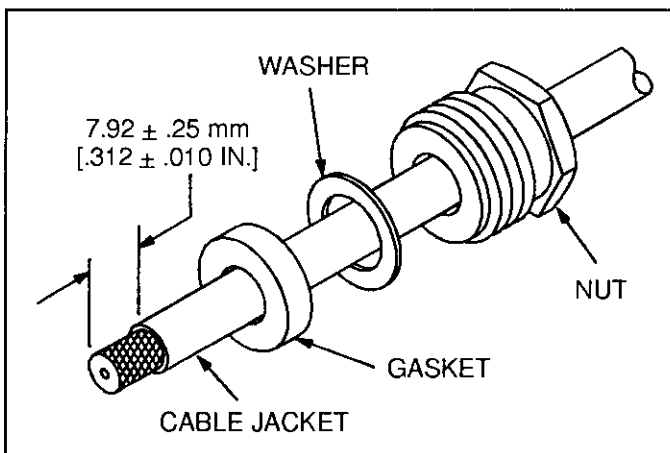


Fig. 2

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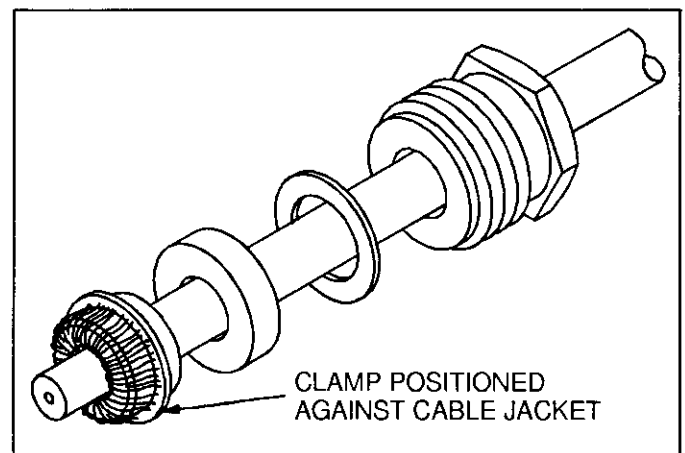


Fig. 3

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3. Fold cable braid over clamp and trim it so that it is positioned against the clamp collar. See Figure 4.

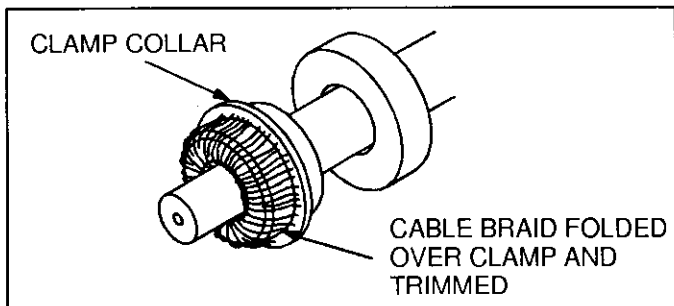


Fig. 4

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4. Using the dimension in Figure 5, strip dielectric to expose center conductor. If applicable, tin the center conductor.

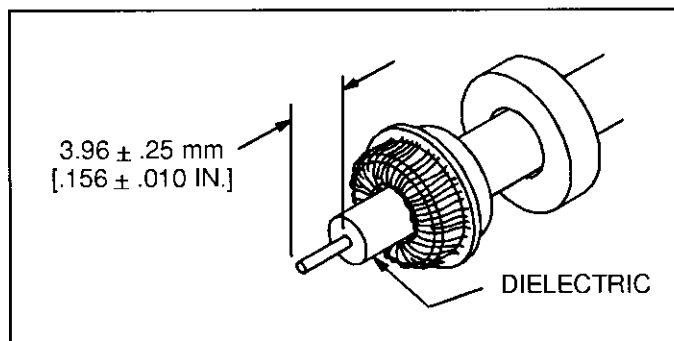


Fig. 5

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5. Solder contact to conductor (using standard soldering techniques), making sure contact is bottomed on cable dielectric. See Figure 6.

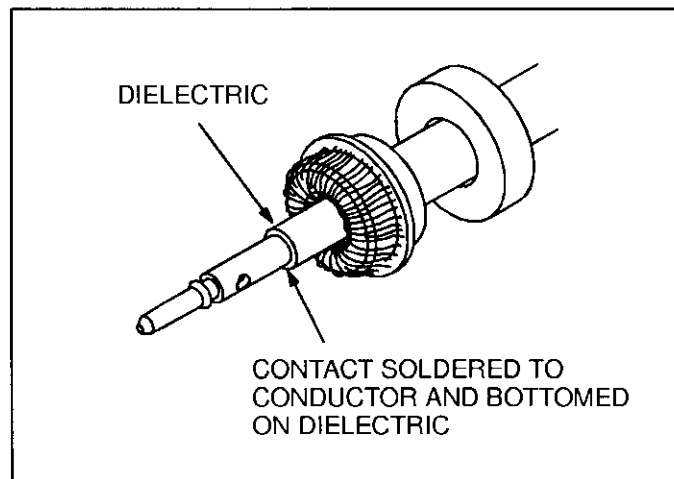


Fig. 6

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**CAUTION**

*Do not allow hot soldering iron to touch cable dielectric. Certain cable dielectric materials, such as polypropylene, will expand if they come in contact with a hot soldering iron.*

6. Insert contact into plug assembly until contact snaps into place. See Figure 7.

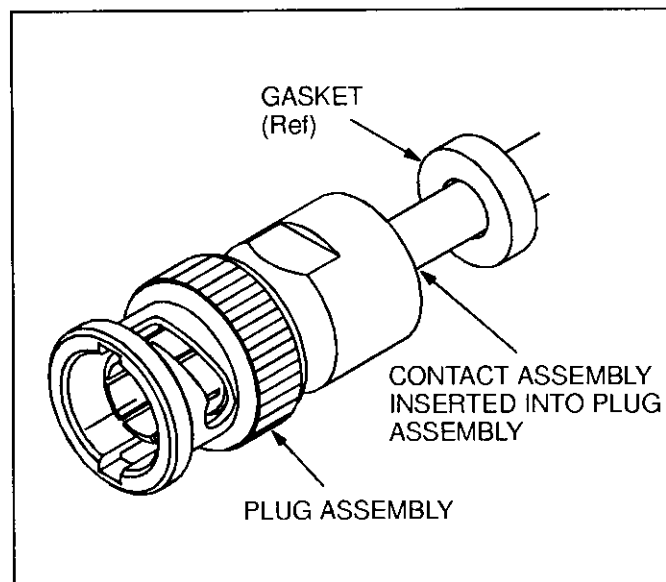


Fig. 7

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7. Thread nut into plug assembly until it is secured. Recommended cable clamp tightening torque is 2.8 - 3.4 N•m [25 - 30 in.-lb.], using a 7/16-in. wrench. See Figure 8.

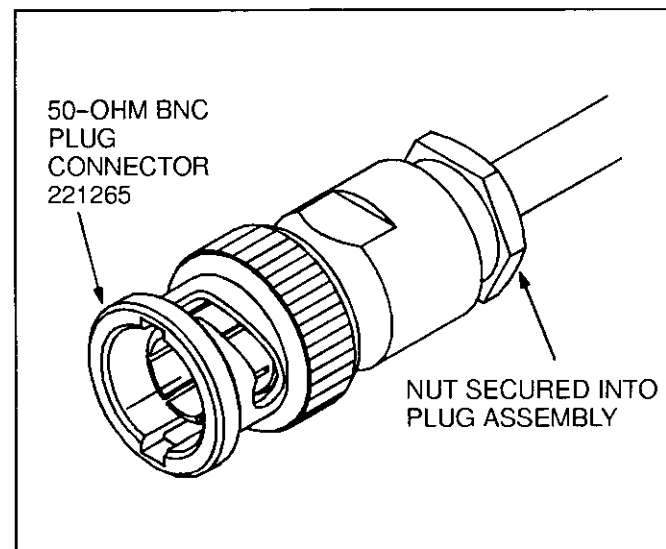


Fig. 8

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