

AMPAMP INCORPORATED
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CUSTOMER HOTLINE

1 800 722-1111

AMP* TNC SERIES
SINGLE CRIMP
50-OHM JACKS**IS 9565**

RELEASED

12-5-90

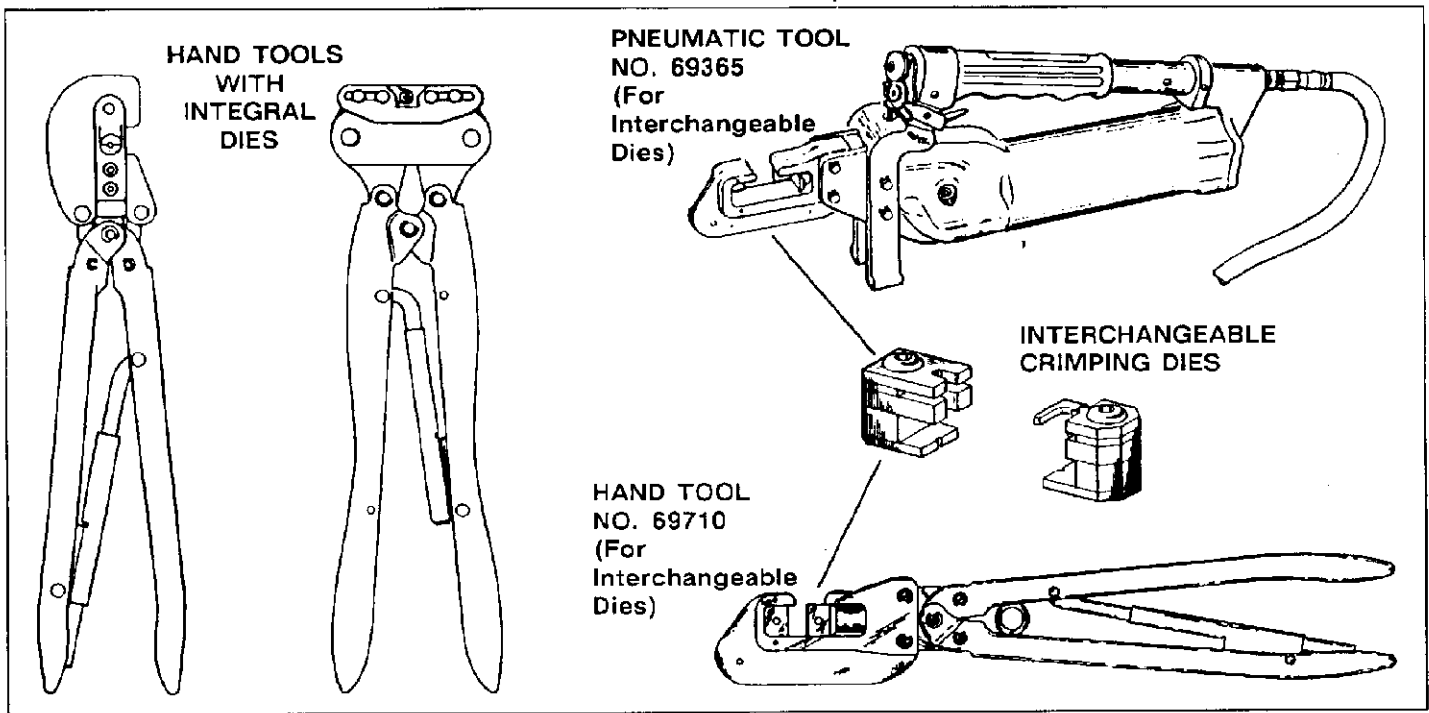


Fig. 1

1. INTRODUCTION

This Instruction Sheet (IS) contains information necessary for the selection of TNC connectors and tools, as well as cable stripping dimensions for all connectors. (Only typical tools and dies are shown.)

NOTE

All dimensions on this sheet are in inches. Illustrations are for reference only and are not drawn to scale.

2. DESCRIPTION

TNC connectors include body, seal, ferrule, and crimp end. Sealed TNC connectors include body, crimp end, and ferrule.

NOTE

Crimp end should not be assembled to connector body until crimp is completed.

3. RECOMMENDED TOOLS AND DIES

Use either the hand tools listed or the interchangeable dies in appropriate tools. Interchangeable dies are used in AMP Hand Tool No. 69710 or AMP Pneumatic Tool No. 69365. See Figure 1.

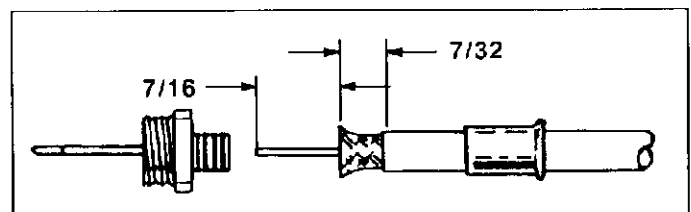


Fig. 2

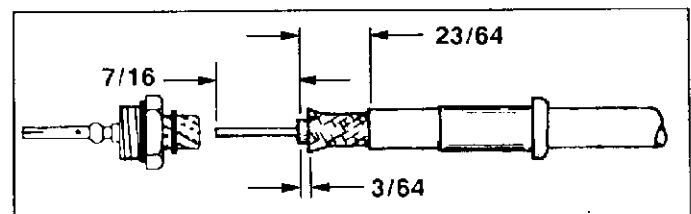


Fig. 3

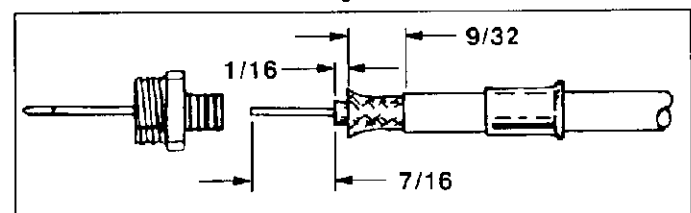
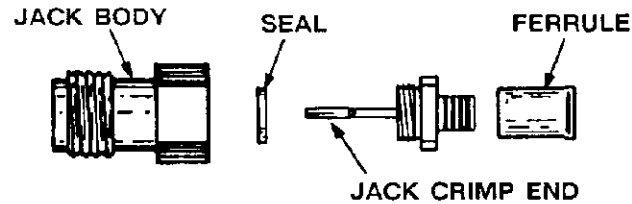
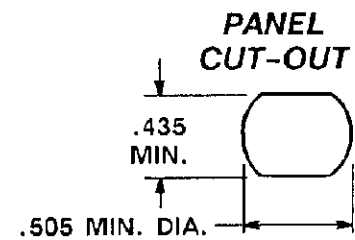
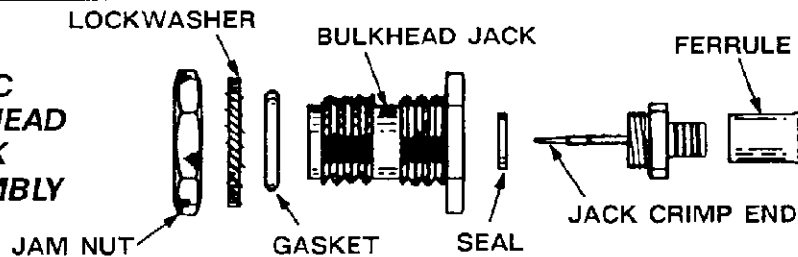


Fig. 4

TNC JACK ASSEMBLY

CABLE	ASSEMBLY NUMBER	CRIMPING TOOL NUMBER	CRIMPING DIE NUMBER	CABLE STRIP DIM.
59, 59A, 59B, 62, 62A, 62B, 124, 140, 210	331125	69141-1, 69141-1 Mod. W	69224-1	FIG. 2
161, 179, 187	413444-1	69245-1, 69245-1 Mod. P	69408	
180, 180A, 195	331129	69246-1, 69246-1 Mod. P	69423	
71, 71A, 71B	331126	69141-2, 69141-2 Mod. P	69425	
174, 188	331127	69245-2, 69245-2 Mod. N	69422	
AMPHENOL 21-597	331130	69246-2, 69246-2 Mod. R	69423-1	
178, 196	331132	69245-4, 69245-4 Mod. L	69471	
122	331131	69246-1, 69246-1 Mod. P	69423	FIG. 4
BELDEN 8281, W.E. 724 & 3049	332418	69652	220000	

Table 1 — TNC JACKS

TNC BULKHEAD JACK ASSEMBLY

CABLE	ASSEMBLY NUMBER	CRIMPING TOOL NUMBER	CRIMPING DIE NUMBER	CABLE STRIP DIM.
59, 59A, 59B, 62, 62A, 62B, 124, 140, 210	331235	69141-1, 69141-1 Mod. W	69224-1	FIG. 2
161, 179, 187	331238	69245-1, 69245-1 Mod. P	69408	
180, 180A, 195	331239	69246-1, 69246-1 Mod. P	69423	
71, 71A, 71B	331236	69141-2, 69141-2 Mod. P	69425	
174, 188	331237	69245-2, 69245-2 Mod. N	69422	
AMPHENOL 21-597	331240	69246-2, 69246-2 Mod. R	69423-1	
178, 196	331243	69245-4, 69245-4 Mod. L	69471	
122	331242	69246-1, 69246-1 Mod. P	69423	FIG. 4
RAYCHEM 22-704	50479	69246-2, 69246-2 Mod. R	69423-1	

Table 2 — TNC BULKHEAD JACKS

CABLE	ASSEMBLY NUMBER	CRIMPING TOOL NUMBER	CRIMPING DIE NUMBER	CABLE STRIP DIM.
58, 58B	331325	69376-3	69815	FIG. 3
58C	331325	69376-1	69815	
55, 55A, 55B, 223	1-331325-3	69376-3	69815	
141, 141A	1-331325-1	69376-3	69815	
142, 142A, 142B	1-331325-2	69376	69493-1	

Table 3 — WEATHERPROOF TNC BULKHEAD JACKS

4. CRIMP END ASSEMBLY

NOTE

Assembly procedure is the same for all connectors.

To assemble crimp end, proceed as follows.

1. Slip ferrule on cable, then strip cable and flare braid as shown in Figures 2, 3, and 4.
2. Insert stripped conductor into wire barrel on crimp end. Twist crimp end slightly to ease entry of wire.
3. Push crimp end back under braid so that braid passes over and around support sleeve. Apply sufficient pressure to cause cable dielectric to bottom against dielectric of crimp end. See Figure 5. Twist crimp end slightly to assure bottoming.
4. Slide ferrule forward and over braid on crimp end as far as it will go. See Figure 5. Crimp end is now ready to be crimped.

5. CRIMPING PROCEDURE

Several of the hand tools contain a "quick take-up" device, or handle, on the CERTI-CRIMP® Ratchet Assembly. To close tool handles, the small handle on the ratchet assembly is pulled toward the tool handle. See Figure 6. Both tool handles are then closed to complete crimp.

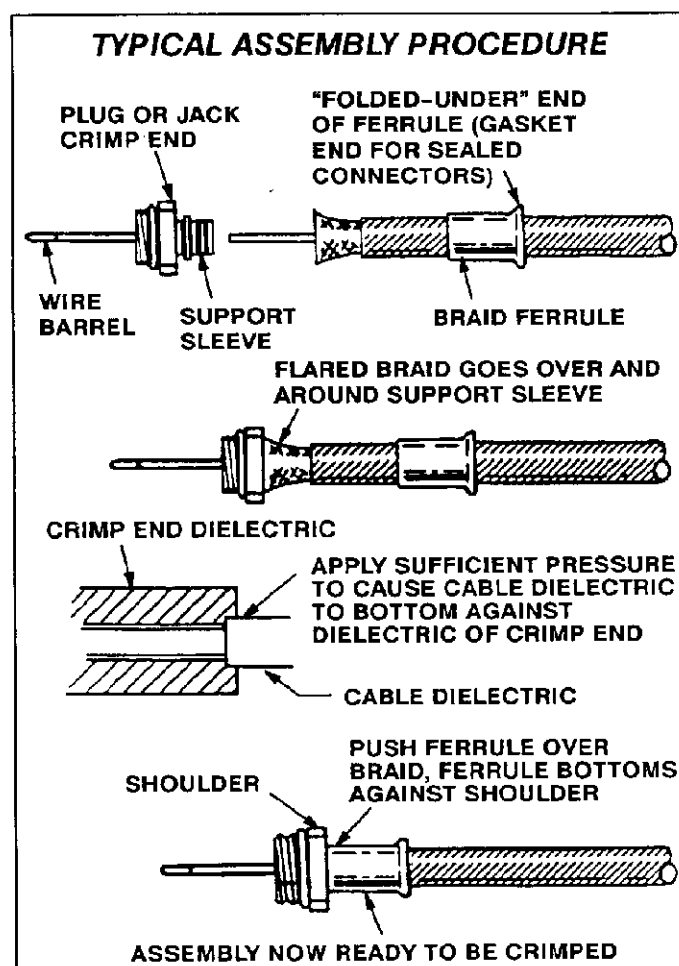


Fig. 5

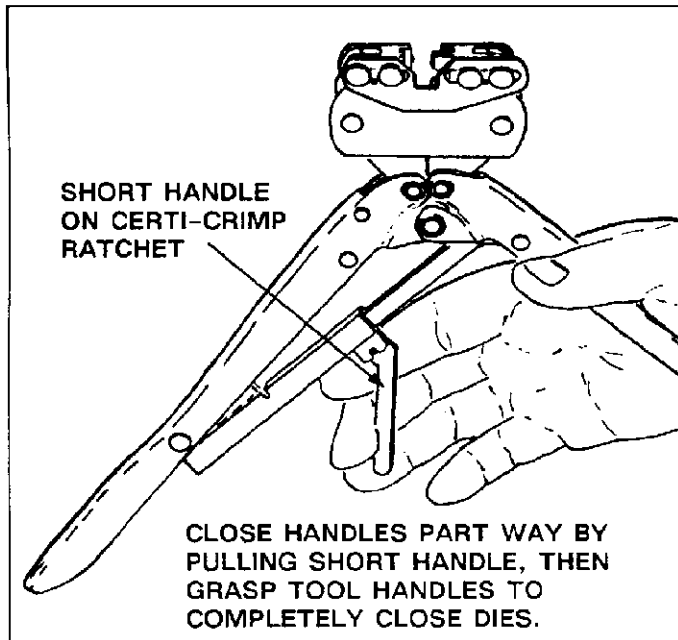


Fig. 6

NOTE

The crimping tools, dies, and crimping procedures are similar regardless of the type connector to be crimped.

5.1. HAND TOOLS WITH INTEGRAL DIES**NOTE**

The crimping tools have multiple sets of dies. See Figures 7 and 8 to crimp the braid ferrule and wire barrel of crimp end. Ferrule and wire barrel are crimped at the same time.

1. Open crimping dies by closing tool handles until CERT-CRIMP ratchet releases. Note that once ratchet is engaged, the handles cannot be opened until they are fully closed.
2. Place the crimp end in crimping dies as shown.
3. Make certain that wire barrel and braid ferrule of crimp end are resting firmly on crimping dies. See Figures 7 and 8.
4. Close handles part way by pulling short handle on CERTI-CRIMP ratchet (for tools containing this feature), then grasp and close tool handles to complete crimp.

5.2. INTERCHANGEABLE DIES

AMP TNC Series COAXICON® Crimping Dies are used in AMP Tools No. 69710 and 69365. Read the instructions shipped with tools for information concerning die insertion and general tool performance. Refer to

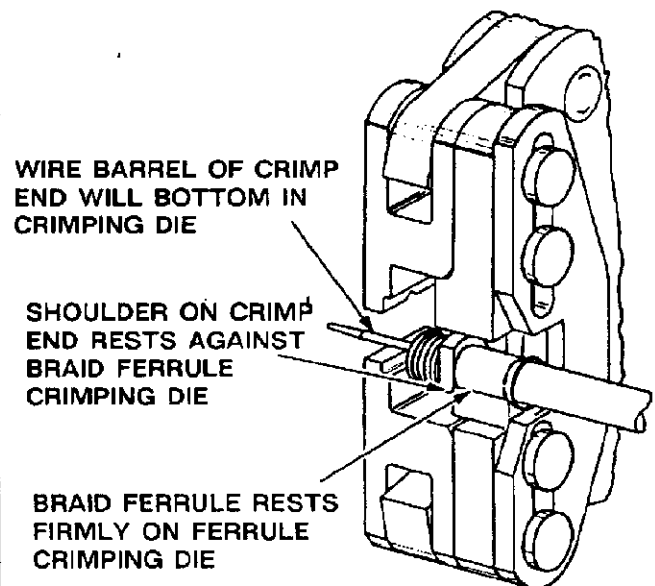
TYPICAL CRIMPING TOOL

Fig. 7

WIRE BARREL OF CRIMP
END WILL BOTTOM IN
CRIMPING DIE

BRAID FERRULE
RESTS FIRMLY ON
UPPER BRAID
FERRULE
CRIMPING DIE

SHOULDER ON CRIMP
END RESTS AGAINST
BRAID FERRULE
CRIMPING DIE

Fig. 8

selection charts for proper connectors and cables to use. Then proceed as follows:

1. Place crimping dies in tool. The die assemblies have multiple sets of crimping dies similar to those in hand tools. See Figure 9.

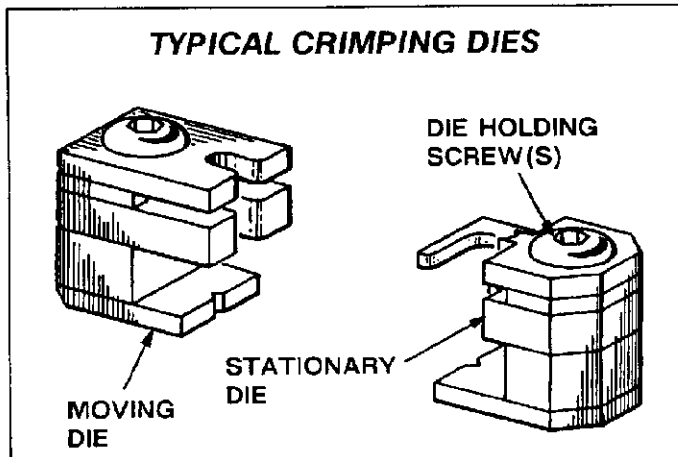


Fig. 9

2. Place the crimp end in crimping dies as shown in Figure 10.
3. Make certain that wire barrel and braid ferrule of crimp end are resting firmly on crimping dies. See Figure 10. Hold assembly in place and complete crimp.

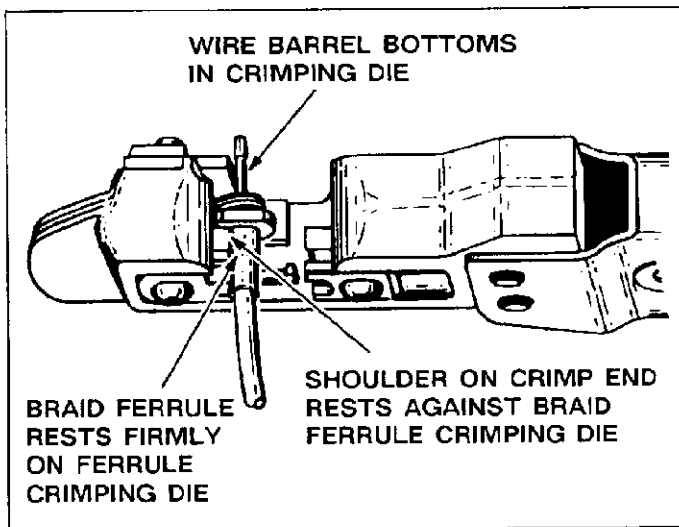


Fig. 10

6. CONNECTOR ASSEMBLY

1. Assemble crimp end and connector body as shown in Figure 11.
2. Assemble crimp end and sealed connector as shown in Figure 12.

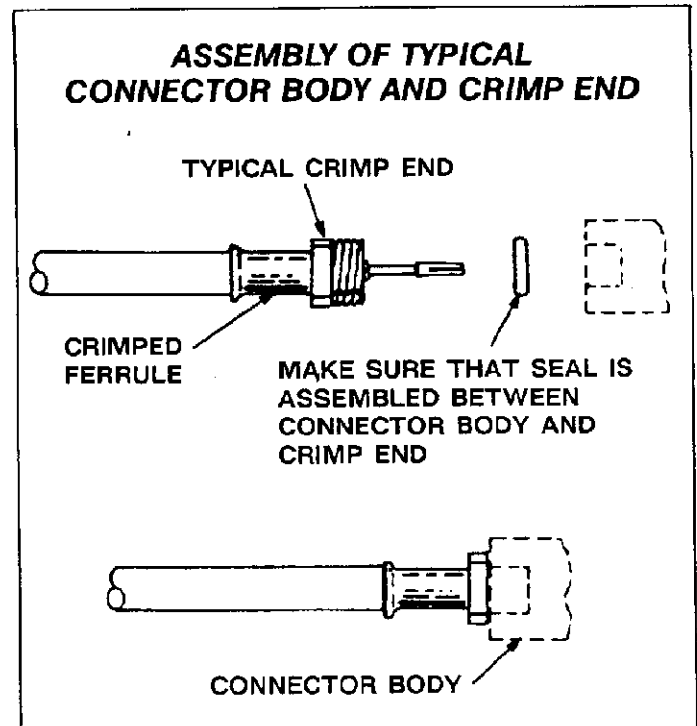


Fig. 11

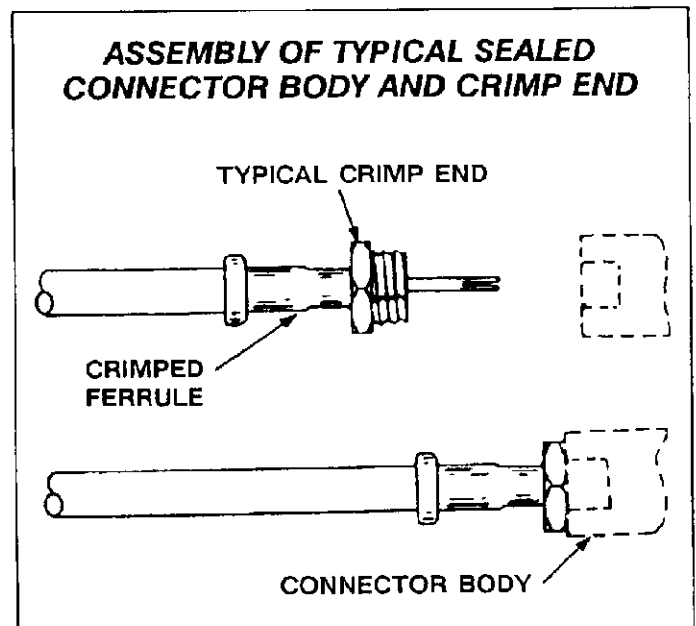


Fig. 12

3. Use a wrench on flats to tighten. A torque of 15 to 20 inch-pounds is suggested.

4. For bulkhead jacks, slide gasket over bulkhead jack and press into recess in jack. See Figure 13.

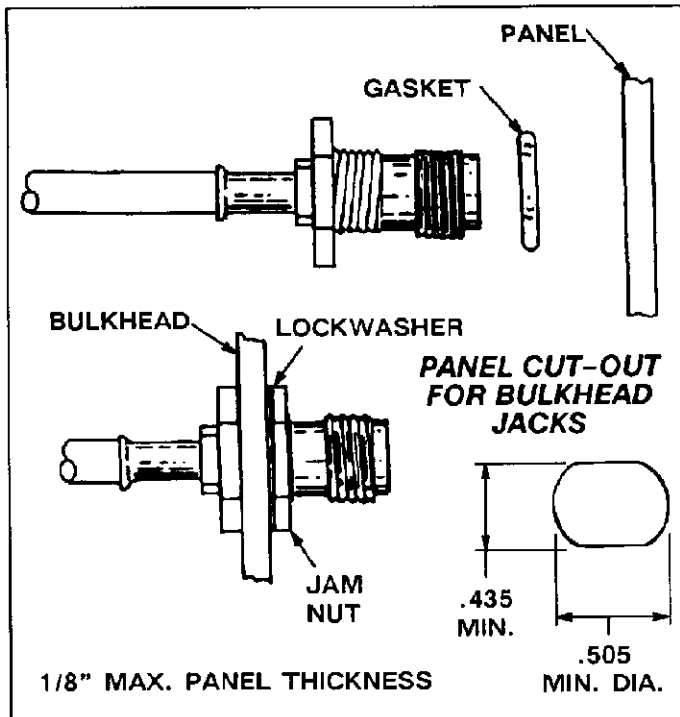


Fig. 13

5. Insert jack through hole in panel. Use dimensions shown in Figures 13 and 14 for cut-out. See Paragraph 7 if panel insulating bushing is to be used.

6. Place lockwasher and jam nut on jack and tighten.

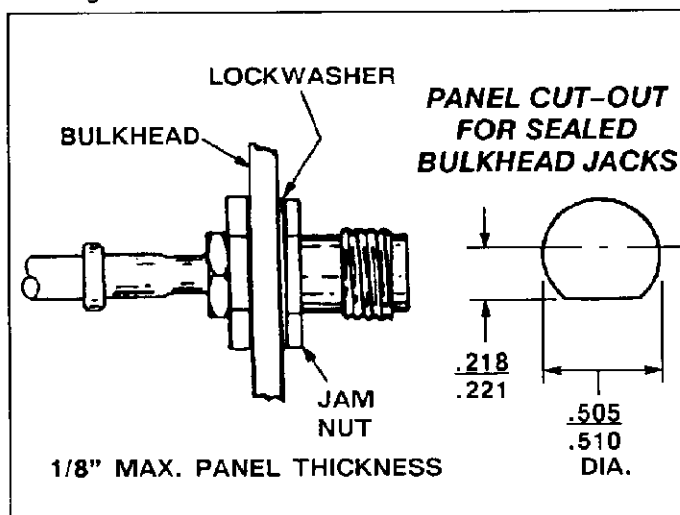


Fig. 14

7. PANEL INSULATING BUSHING

AMP Panel Insulating Bushing No. 330620 is available for use with bulkhead jacks. Refer to Figure 15 for panel cut-out dimensions. Use two bushings for each bulkhead jack. For 1/16" panel, assemble bushings as shown in View A. For 1/32" panel, assemble bushings as shown in View B.

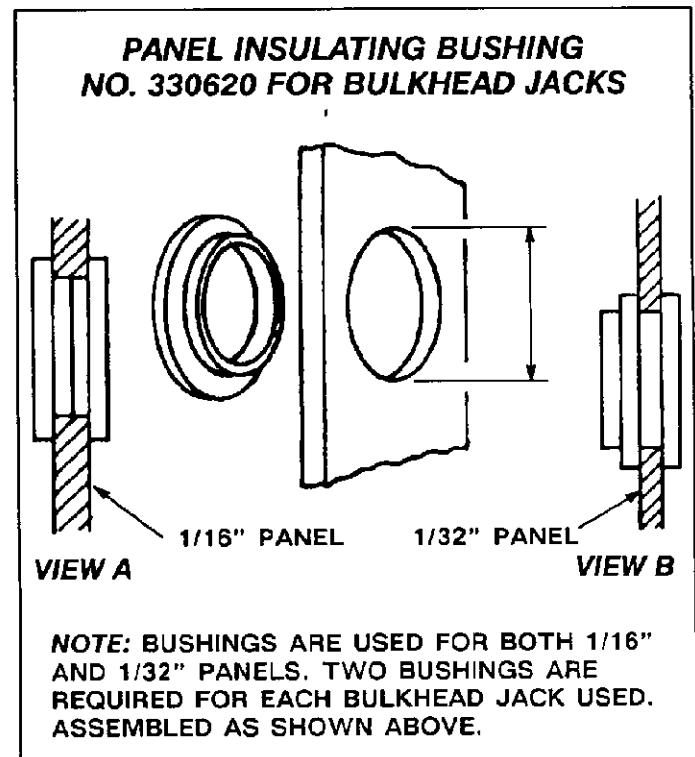


Fig. 15