

AMP
AMP INCORPORATED
HARRISBURG, PA 17105

**AMP* 50-OHM RF SERIES
BNC RIGHT-ANGLE PLUG
HEX CRIMP CONNECTORS 413959-[]**

IS 9778

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RELEASED
4-24-92

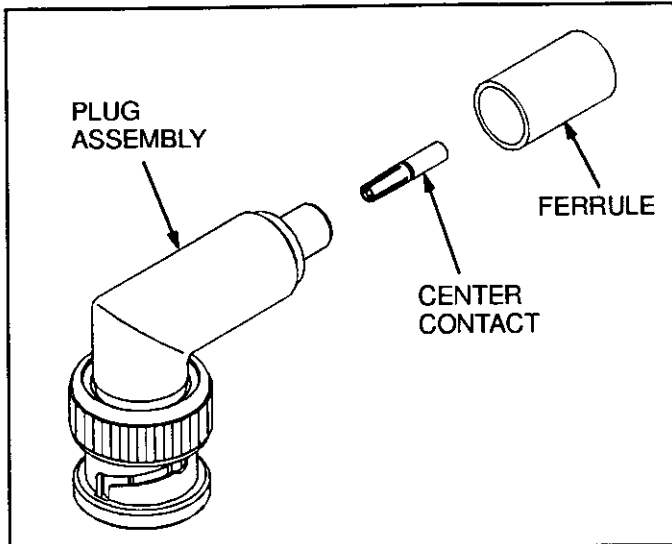


Fig. 1 cad

1. INTRODUCTION

This Instruction Sheet (IS) covers the assembly of AMP 50-Ohm RF Series BNC Right-Angle Plug Hex Crimp Connectors 413959-[]. The connectors are terminated with AMP Hand Tool 220190-1 which accepts interchangeable crimping dies. Die set numbers for the hand tool, cable sizes, and connector part numbers are available in AMP Catalog 82074. For application and maintenance procedures of the hand tool, refer to IS 2901.

NOTE

Dimensions are in millimeters [followed by inches in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

2. DESCRIPTION

The right-angle plug connector consists of a ferrule, a center contact, and a plug assembly. A spacer and plastic tubing are also provided with connectors which use air core dielectric cable (see AMP Customer Drawing for part availability). Details concerning product specifications are available in AMP Catalog 82074.

3. ASSEMBLY PROCEDURE

Determine cable type for your application; then select the appropriate connector (see AMP Customer Drawing). Proceed as follows:

1. Slide ferrule over the end of the cable; then strip cable using the recommended strip-length dimensions. See Figures 2 and 3.

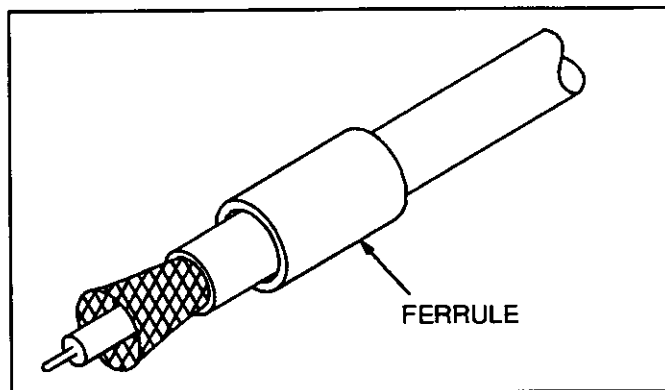


Fig. 2 cad

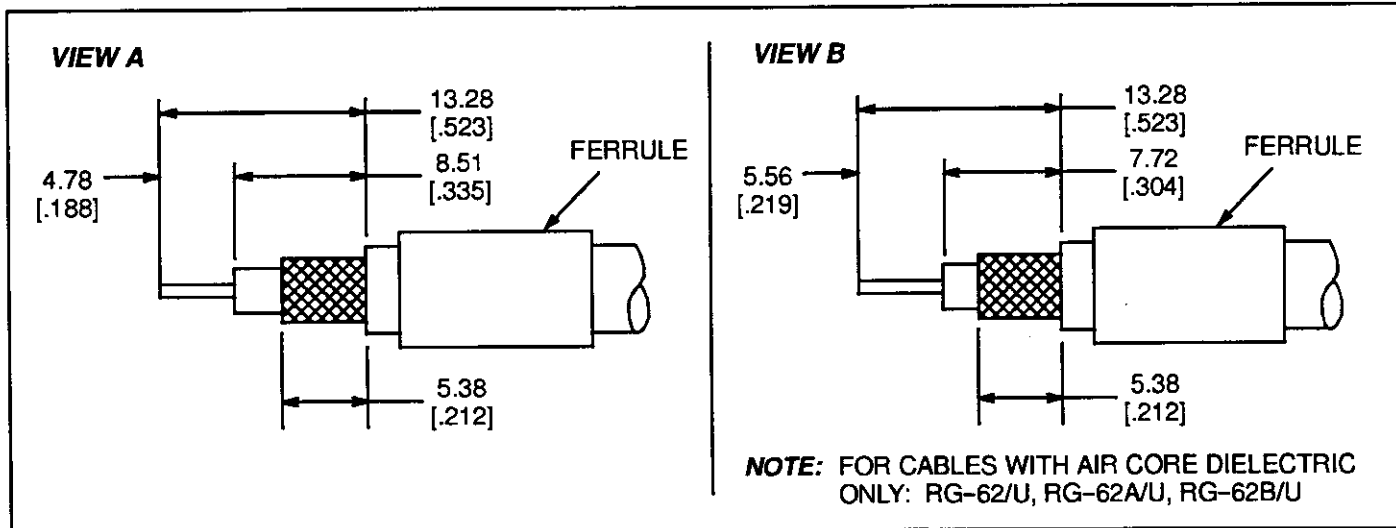


Fig. 3 cad

NOTE

If a plastic spacer and tubing are provided with the connector, they must be installed before the center contact is crimped. The spacer is positioned over the center conductor and against the air core dielectric. To install the tubing, slide it over the dielectric. For part availability, refer to the AMP Customer Drawing.

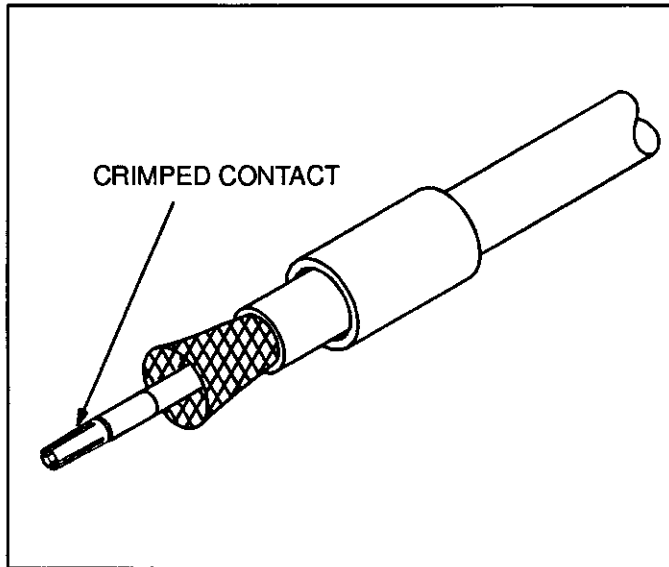


Fig. 4

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2. Position contact onto center conductor; then crimp the contact using hand tool 220190-1 (fitted with the appropriate die assembly). See Figure 4.

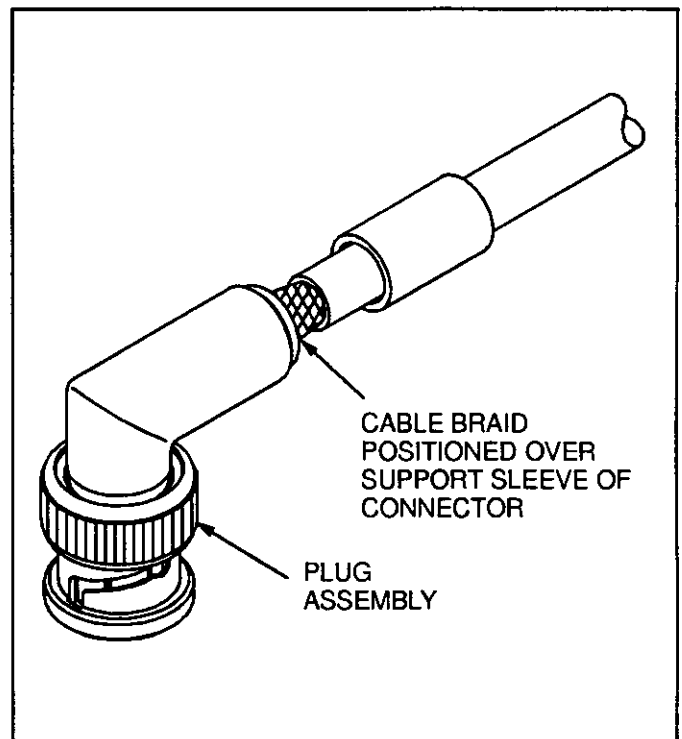


Fig. 5

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3. Insert center contact into plug assembly. Make sure the cable braid is positioned over the support sleeve of the plug assembly, as shown in Figure 5.

4. Slide ferrule forward over braid and support sleeve. Crimp the ferrule using hand tool 220190-1. See Figure 6.

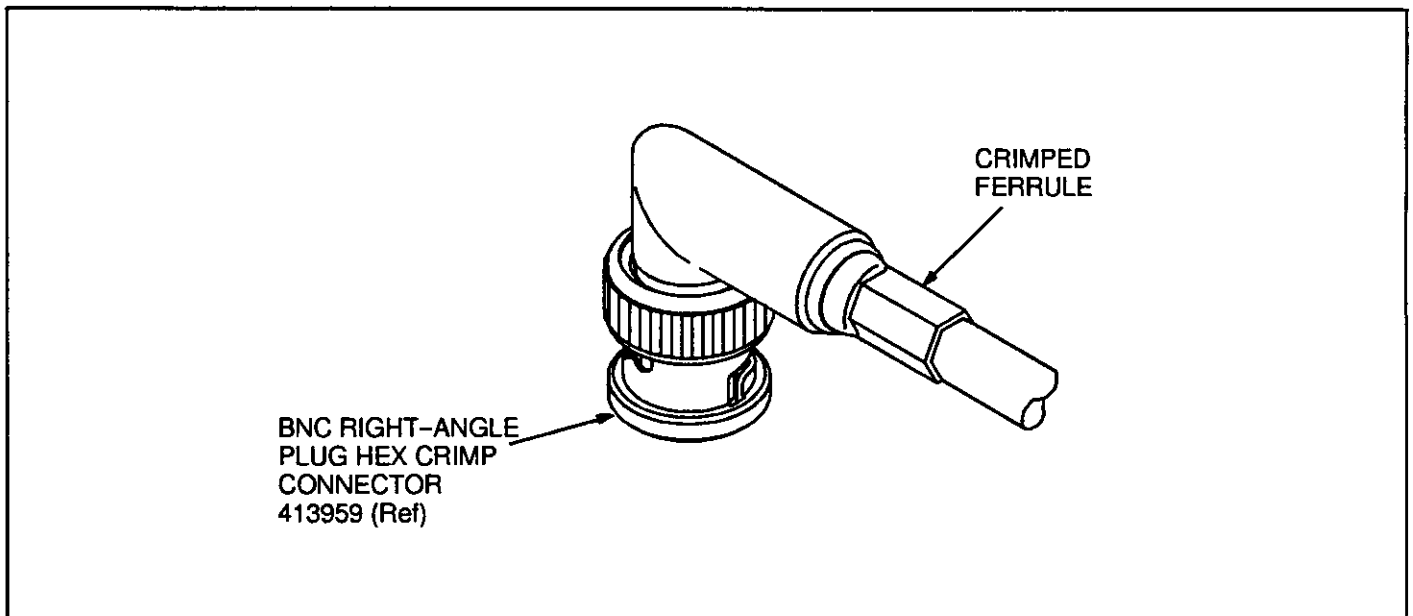


Fig. 6

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