

Figure 1

## 1. INTRODUCTION

AMP\* 75-Ohm RF Series BNC Right-Angle Dual Crimp Plug Connector 221402-[ ] accepts a wide range of coaxial cables and are crimped with AMP PRO-CRIMPER\* II Hand Crimping Tool Frame Assembly 354940-1 when fitted with the appropriate die assembly.

Refer to AMP Catalog 82074 for cables sizes, connectors specifications, and die assembly selection. For cable sizes not listed in the catalog, contact AMP Product Engineering for connector recommendations. Details concerning the operation of the hand tool are available in AMP Instruction Sheet 408-9930.

**NOTE**

Dimensions on this sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

## 2. DESCRIPTION

This connector consists of a plug assembly with a knurled coupling sleeve, a contact, and depending on connector selection, a straight ferrule or a step-down ferrule. See Figure 1. The connector features provide quick connect/disconnect coaxial connections and, with the dual crimp termination, insures positive insulation grip.

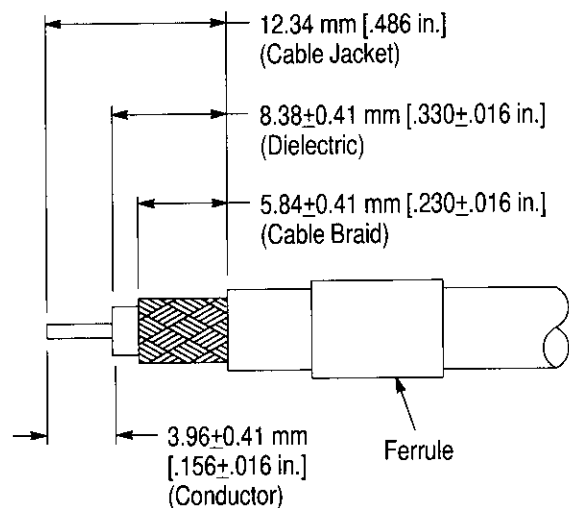
## 3. ASSEMBLY PROCEDURE

1. Slide ferrule over the end of the cable; then strip the cable using the recommended strip-length dimensions shown in Figure 2. Flare cable braid making sure that the center conductor is straight and free of burrs.

**NOTE** If using the step-down ferrule, slide it onto the cable with the small opening first.

2. Insert center conductor into contact; then crimp the contact using the hand crimping tool with the appropriate die assembly. See Figure 3.

### Recommended Strip-Length Dimensions



Note: Not to Scale

Figure 2

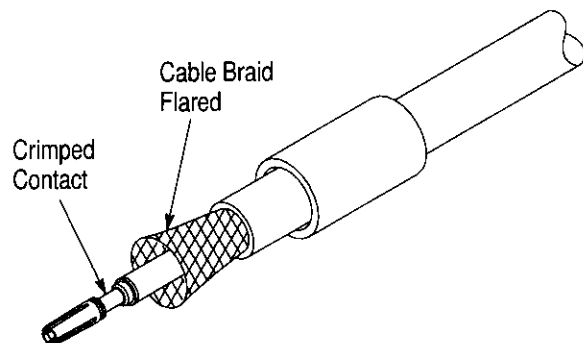
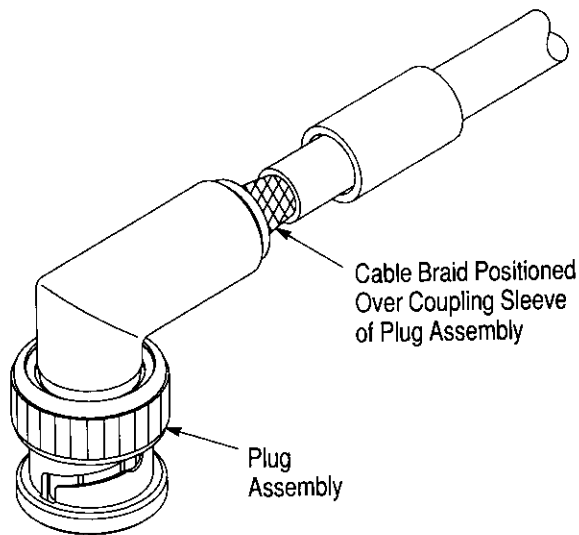
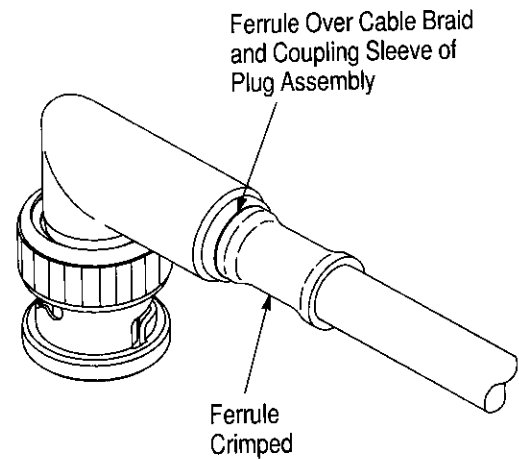


Figure 3

*Figure 4*

3. Insert crimped contact into plug assembly, making sure that the cable braid is positioned over the coupling sleeve of the plug assembly. See Figure 4.

4. Slide ferrule over cable braid and coupling sleeve of the plug assembly. Crimp the ferrule using the hand crimping tool with the appropriate die assembly. See Figure 5.

*Figure 5*

#### 4. REVISION SUMMARY

Revisions to this instruction sheet include:

Per EC 0990-0586-96:

- Changed jacket, dielectric, and braid strip length in Figure 2
- Replaced Hand Crimping Tool 220190-1 and reference to 408-2901 with Frame Assembly 354940-1 and reference to 408-9930
- Updated format
- Added step-down ferrule
- Added NOTE to Section 3, Step 1