

**PLUG CONNECTOR 7-225550-7
(Ref)**

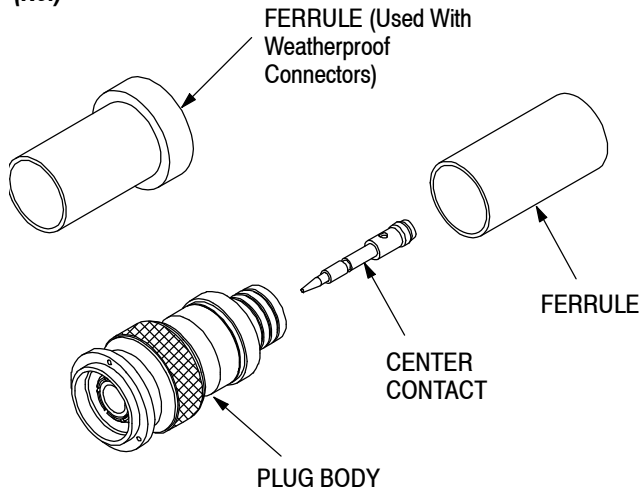


Figure 1

1. INTRODUCTION

This Instruction Sheet covers the assembly of COAXICON 50-Ohm TNC Mil-Type Plug Connectors 225345-[], 225550-[], 225399-[], and 225555-[]. The plug connectors accept a wide range of coaxial cables and are interchangeable with industry standard connectors designed to MIL-C-39012 specifications. The connectors can be crimped using various CERTI-CRIMP* Hand Tools such as: 220045-2 (408-2336) and 220015-1 (408-2331).

Catalog 82074 provides a guide for cable-to-connector selection and recommended crimping tools. For cable sizes and connectors not referenced in the catalog, contact TE Connectivity Product Engineering for connector recommendations. For detailed crimping procedures, refer to the instructions packaged with the appropriate crimping tool.

NOTE Dimensions in this instruction 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 (Figure1)

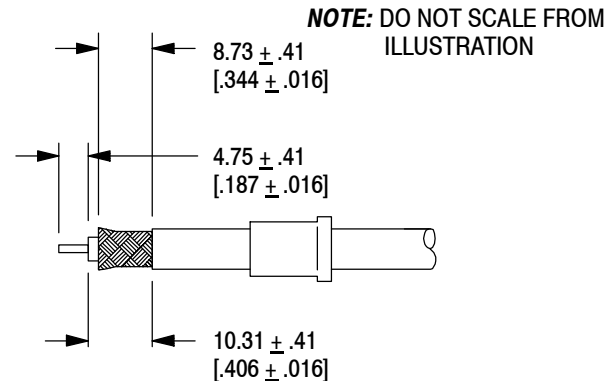
The plug connectors consist of a plug body, a center contact, and a ferrule, and are available in both standard and weatherproof versions. The weatherproof connectors include a ferrule with a rubber seal and a plug body with a rubber seal over

the support sleeve. For part availability, refer to the Customer Drawing. Details concerning product specifications are available in 108-12001.

3. ASSEMBLY PROCEDURE

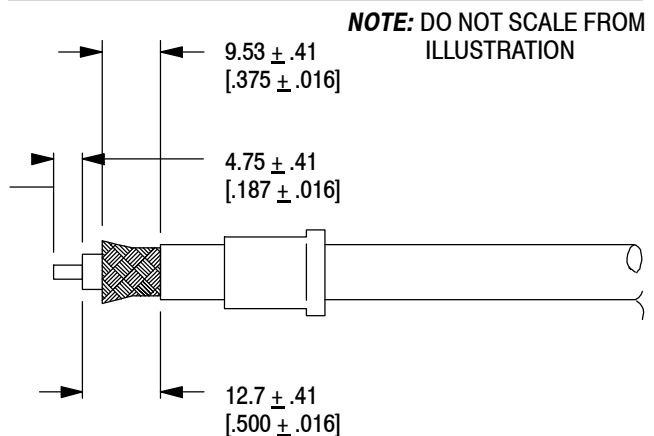
1. Slide ferrule onto unstripped cable; then strip cable using the appropriate strip-length dimensions provided in Figures 2, 3, 4, or 5. To select the appropriate strip-length dimensions, cross-reference the RG/U cable number or cable manufacturer to the appropriate figure, or refer to the Customer Drawing. If the cable type is not referenced, contact TE Product Engineering for connector recommendations.

NOTE Do not nick or cut the cable braid. The center conductor must be straight and free of burrs.



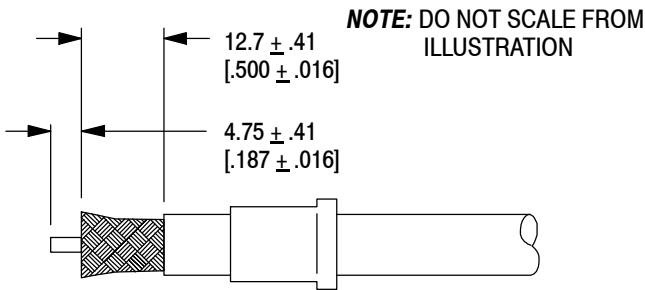
NOTE: For cable types - RG-55A, 223, 58A, 58, 141, 141A, 142, 142A, 142B, 302, Times AA2141, 180/U, 180A/U, and 180B/U.

Figure 2



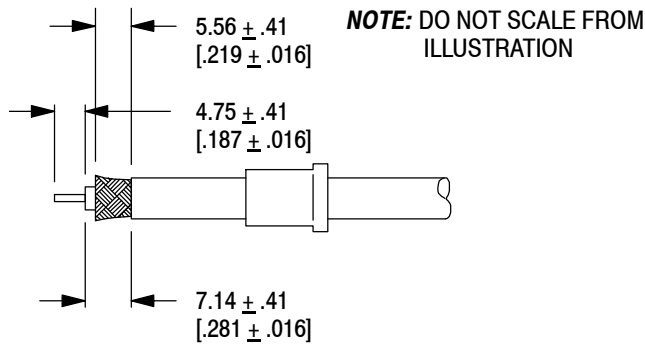
NOTE: For cable types - RG-8, 8A, 213, Microdot 250-4171, Microdot 250-4172.

Figure 3



NOTE: For cable types - RG-9, 9A, 214, 115A, 225, 393, F.E.P. 115A (Times MI 5164), Times M-5888, Times AA-5886, and Times AA-5887.

Figure 4



NOTE: For cable types - RG-58, 59A, 59B, 62, 62A, 62B, 71B, and BSX-7002-59/U.

Figure 5

2. Flare cable braid and insert center conductor into contact. The shoulder of the contact should rest against the cable dielectric, as shown in Figure 6.

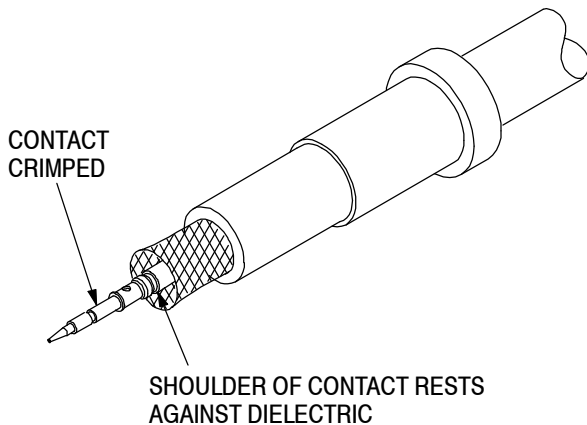


Figure 6

3. Crimp center contact using the recommended crimping tool. Refer to the instruction sheet (packaged with the tool) for specific crimping procedures. See Figure 6.

4. Insert center contact into plug body, making sure the cable braid is positioned over the connector support sleeve. See Figure 7. Pull back gently on the cable to ensure that the contact is held in place by the internal locking feature.

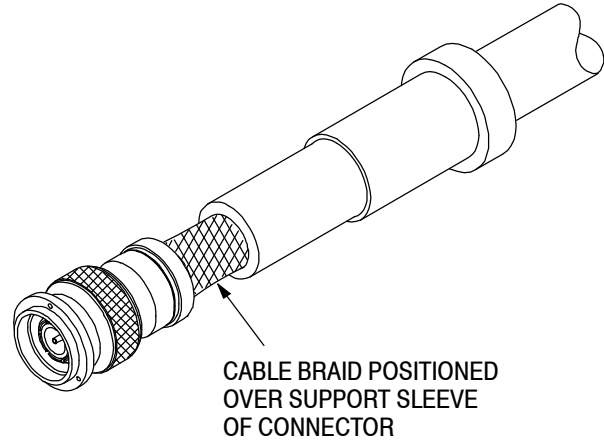


Figure 7

5. Slide ferrule forward over the cable braid until it is positioned against the shoulder of the plug body. Crimp the ferrule using the recommended crimping tool. Refer to the instructions (packaged with the tool) for specific crimping procedures. See Figure 8.

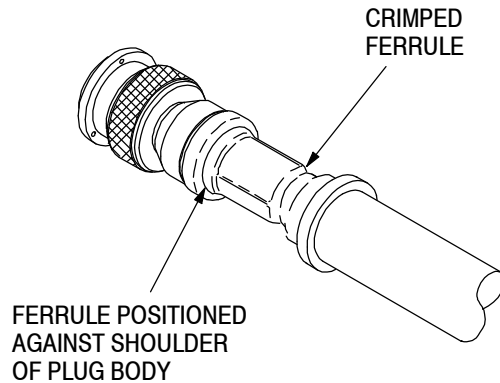


Figure 8

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements.