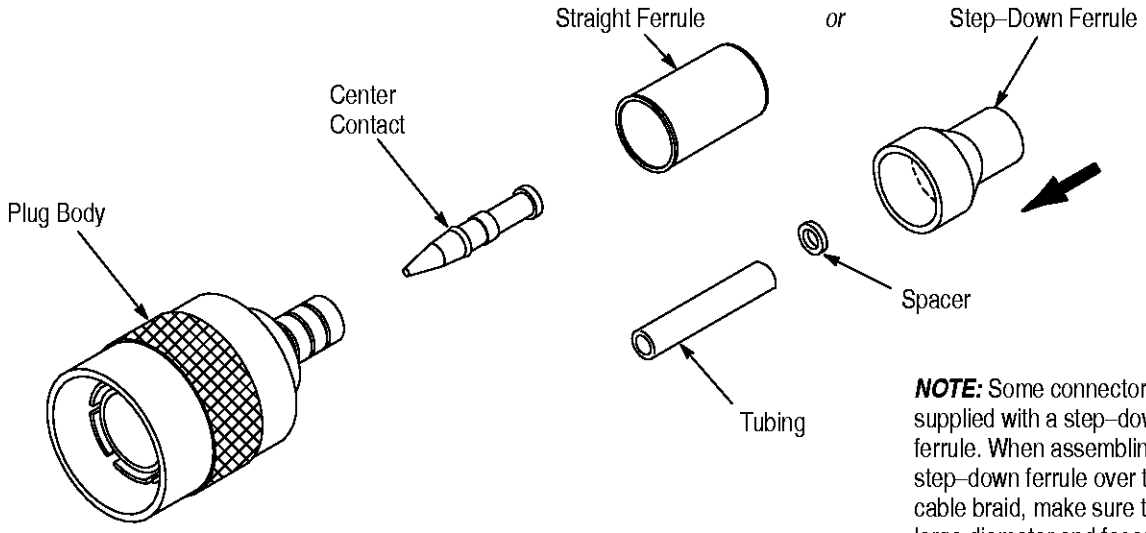
COAXICON* 50–Ohm TNC Commercial Plug Connectors 227000–[ ] (Dual Crimp Type)



NOTE: Some connectors are supplied with a step–down ferrule. When assembling the step–down ferrule over the cable braid, make sure the large diameter end faces the plug body.

Figure 1

1. INTRODUCTION

AMP* COAXICON 50–Ohm TNC Commercial Plug (Dual Crimp Type) Connectors 227000–[ ] are crimped onto a wide range of coaxial cables using Hand Crimping Tool 220187–1 (408–2774), PRO–CRIMPER* II Hand Tool Frame 354940–1 (408–9930) fitted with appropriate die assembly, Hand Crimping Tool 69710–1 (408–2095), or 626 Pneumatic Tooling Assemblies 189721–[ ] or 189722–[ ] fitted with appropriate tool holder or adapter, crimping head, an die set (409–5862).

For a cross–reference of connector–to–cable and applicable tools and die assemblies, refer to AMP Catalog 82074. For detailed information on the tooling, refer to the applicable instructions (408– or 409–series).

NOTE *Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.*

Reasons for reissue are provided in Section 4, REVISION SUMMARY.

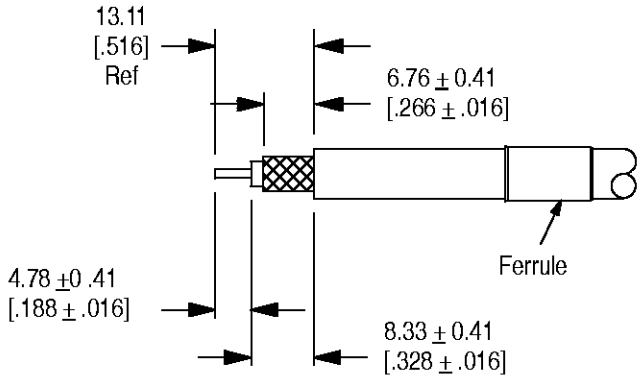
2. DESCRIPTION (Figure 1)

The plug connectors consist of a plug body, a center contact, and a ferrule. Some connectors are supplied with a step–down ferrule, tubing, and a spacer. The tubing is slipped over the cable dielectric before the center contact is crimped. In this use, the tubing compensates for small diameter cable dielectrics. Also, a spacer is provided with connectors which use air core dielectric cable.

3. ASSEMBLY PROCEDURE

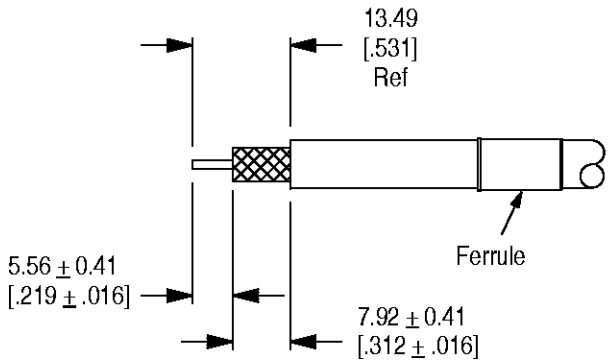
NOTE *If using a step–down ferrule, slide it onto the cable with the small opening first.*

1. Slide ferrule onto unstripped cable; then strip cable using the appropriate strip–length dimensions in Figures 2 or 3. DO NOT nick or cut the cable braid. The center conductor must be straight and free of burrs.



NOTE: Not to Scale

Figure 2



NOTE: Not to Scale

NOTE: For cables with air core dielectric only and used with spacer.

Figure 3

NOTE

For cables with air core dielectric, the spacer must be assembled over the center conductor and positioned against the dielectric before inserting the conductor into the center contact. If tubing is provided with the connector, slide it over the cable dielectric before inserting the conductor into the contact.

2. Insert center conductor into contact until the shoulder of the contact is against the inner dielectric of the cable.

3. Crimp center contact using the recommended crimping tool. See Figure 4.

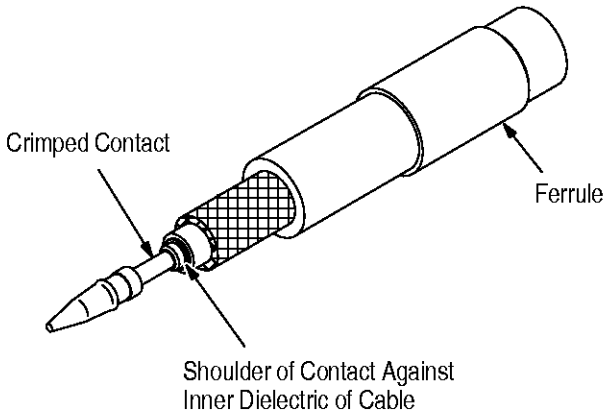


Figure 4

4. Flare cable braid to allow the support sleeve of the plug body to slide under the cable braid.

5. Insert center contact into plug body until it snaps into place. Make sure the cable braid is positioned over the connector support sleeve, as shown in Figure 5. Pull back gently on the cable to ensure that the contact is held in place by the internal locking feature.

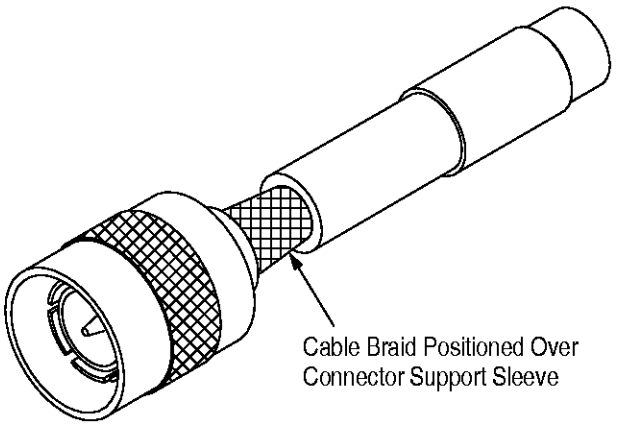


Figure 5

6. Slide ferrule forward over cable braid until it is positioned against the shoulder of the plug body. Crimp the ferrule using the recommended tooling. See Figure 6.

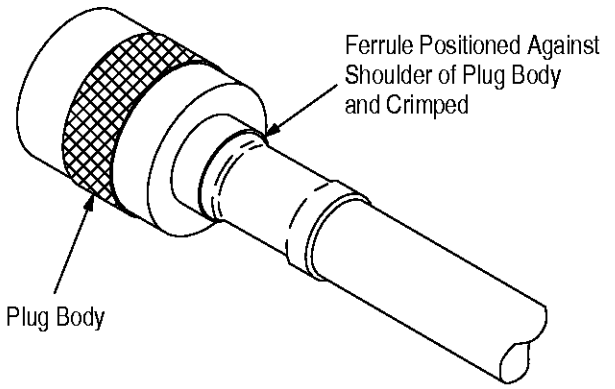


Figure 6

4. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made:

Per EC 0990–1113–98

- Added tubing, spacer, and step–down ferrule in Figure 1
- Added notes regarding tubing, spacer, and step–down ferrule to Sections 2 and 3
- Updated crimping tools in Section 1