


Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly of COAXICON BNC 50-Ohm Commercial Plug (Dual Crimp) Connectors 227079-[ ]. The plug connectors accept a wide range of coaxial cables and can be crimped using the following tools: TE Connectivity CERTI-CRIMP\* Hand Tools, such as 220187-1 (408-2774), PRO-CRIMPER\* III Hand Crimping Tool Frame Assembly 354940-1 (408-9930), PRO-CRIMPER Coaxial Crimp Tool 58433-1 (408-9140), AMP-O-LECTRIC\* Terminating Machine 220152-1 (409-2627), and Single Action Hand Tool 69710-1 (408-2095). 626 C-Head Pneumatic Adapter 318161-1 (408-4190) can also be used. For specific information regarding product part numbers and crimping die numbers associated with Adapter 318161-1, refer to catalog 124208. For details concerning connector crimping procedures, refer to the instruction sheets packaged with the appropriate tool.


Read these instructions carefully before starting assembly.

**NOTE**  Dimensions on this instruction sheet are in millimeters [followed by inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.


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


## 2. DESCRIPTION (Figure 1)

The 50-ohm version dual crimp connectors feature a plug body with a bayonet locking coupling, 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.

**NOTE**  The ferrules differ with connector selection. Some connectors come with straight ferrules, while others use step-down ferrules.

## 3. ASSEMBLY PROCEDURE

**NOTE**  Catalog 82074 provides a cable-to-connector selection guide which will assist you in matching connectors with a specific cable size, crimping tool, and die assembly. For cable sizes not listed in the guide, contact TE Product Engineering for connector recommendations.

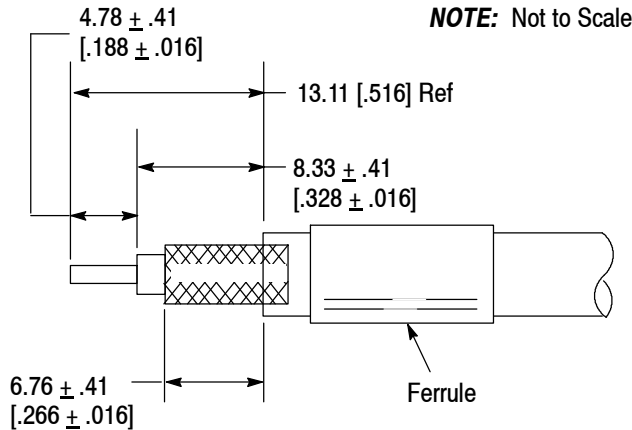
**NOTE**  If using a step-down ferrule, slide it onto the cable with the small opening first.

1. Slide ferrule onto unstripped cable; then strip cable using the appropriate dimensions in Figures 2 and 3. Do not nick or cut cable braid. Center conductor must be straight and free of burrs.



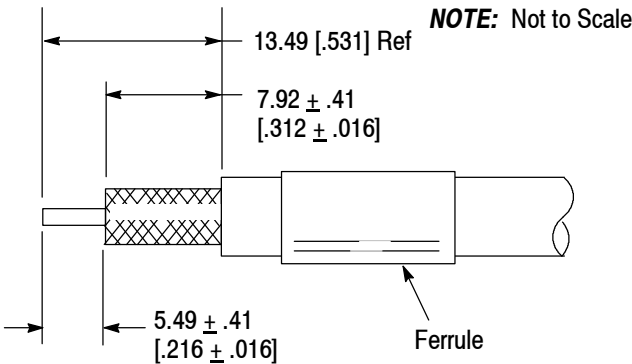
*For cables with air core dielectric, spacer must be assembled over center conductor and bottomed against the dielectric prior to assembly of the center contact. If tubing is provided with the connector, slide it over the cable dielectric prior to assembly of the center contact.*

2. Insert cable conductor into center contact. The contact shoulder must be positioned against the cable dielectric, as shown in Figure 4.



**NOTE:** Not to Scale

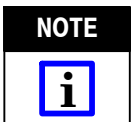
Figure 2



**NOTE:** Not to Scale

**NOTE:** For cables with air core dielectric only and used with spacer. For connectors: 227079-3, -7, -11, -49, -72, -74, -76, -81, -85, and -93.

Figure 3



*For cables with air core dielectric, spacer must be assembled over center conductor and bottomed against the dielectric prior to assembly of the center contact. If tubing is provided with the connector, slide it over the cable dielectric prior to assembly of the center contact. Refer to the Customer Drawing for part availability.*

3. Crimp the center contact with the recommended crimping tool (fitted with the appropriate die assembly). See Figure 4.

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

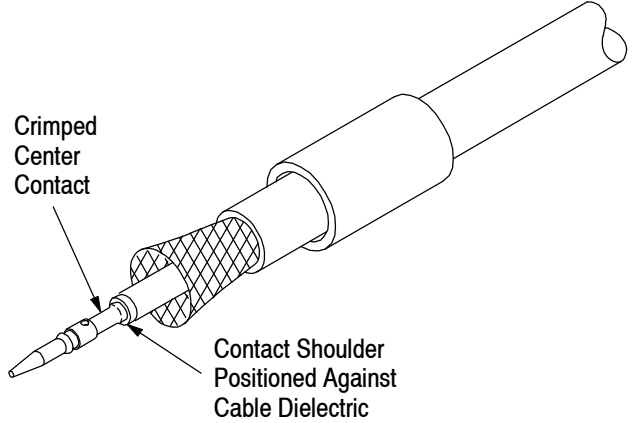
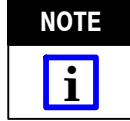


Figure 4



**NOTE:** Connectors with non-captivated contacts: 1-227079-4, -16, -20, -22, -69, -82, -88, and -90. All other connectors have captive contacts.

5. Insert center contact into plug body until it snaps into place. The cable braid must be positioned over the connector support sleeve. Pull back gently on the cable to ensure that the contact is held in place by the internal locking feature. See Figure 5.

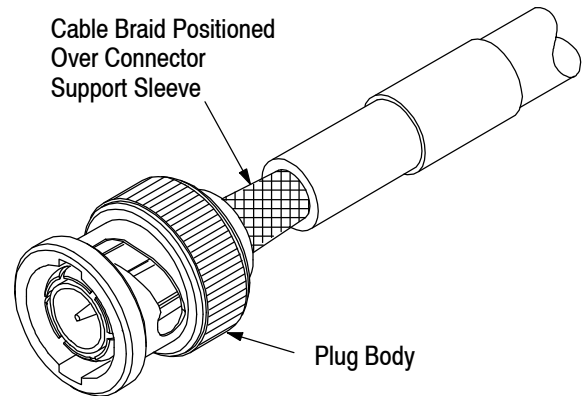
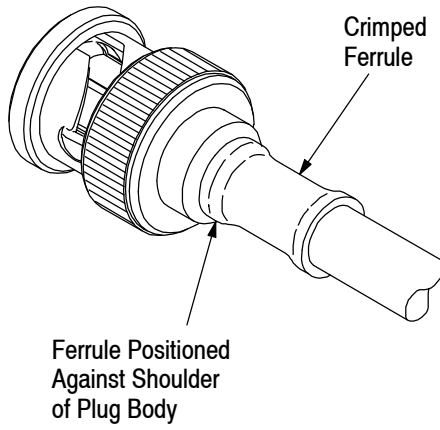


Figure 5

6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the plug body. Crimp the ferrule using the recommended crimping tool (fitted with appropriate die assembly). See Figure 6.



#### 4. REVISION SUMMARY

- Updated document to corporate requirements
- New logo

*Figure 6*