

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly of 75-Ohm TNC Hex Crimp Plug Connectors 413591-1 and 5413591-1. These connectors are crimped onto various sizes of RG/U cable using PRO-CRIMPER\* III Frame Assembly 354940-1, which accepts interchangeable crimping die assemblies.

Catalog 1307191 provides die assembly part numbers for the frame assembly, product application requirements, cable selection, and product part number information. For information not listed, contact Tyco Electronics Engineering for recommendations. Refer to Instruction Sheet 408-9930 for procedures concerning the operation of the frame assembly.

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

## 2. DESCRIPTION (Figure 1)

Each connector consists of a plug body, a center contact, and a ferrule. The center contact is crimped onto the cable center conductor and assembled into the plug body. The ferrule is then crimped onto the cable braid and plug body to complete the assembly.

Some connectors are supplied with a step-down ferrule, a plastic spacer, and a brass tubing. The plastic spacer and brass tubing are slipped over the cable dielectric before the center contact is crimped. In this use, the spacer and tubing compensate for small diameter cable dielectrics.

## 3. ASSEMBLY PROCEDURE

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

**NOTE** Refer to Figure 3 for orientation of step-down ferrule. For connectors supplied with spacer and tubing, slip tubing (flared end first), then spacer over the cable dielectric, as shown in Figure 3.

### Recommended Cable Strip Length

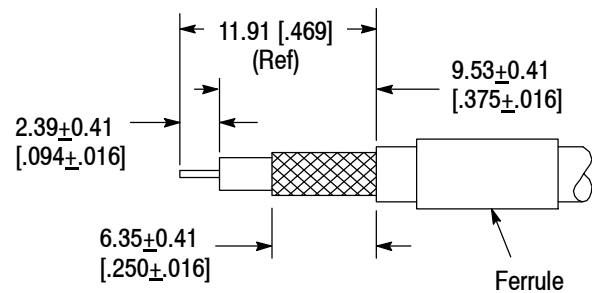


Figure 2

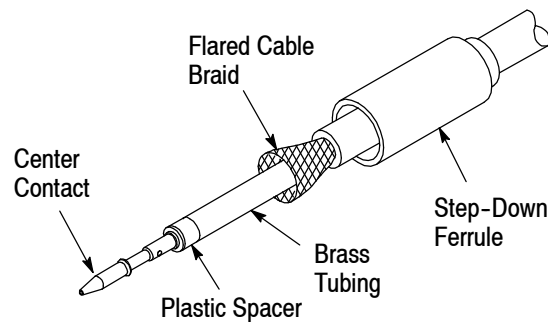


Figure 3

2. Insert center conductor into center contact. The center contact shoulder must be positioned against the cable dielectric, as shown in Figure 4. Be sure the cable insulation does not enter the center contact wire barrel.
3. Crimp the center contact with the recommended frame assembly fitted with the appropriate die assembly.

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

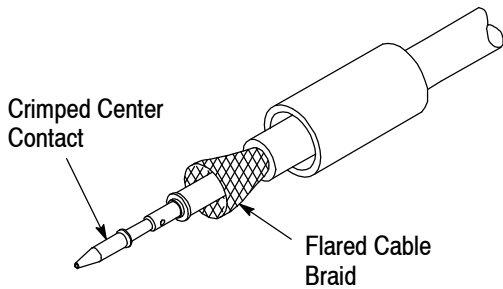


Figure 4

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

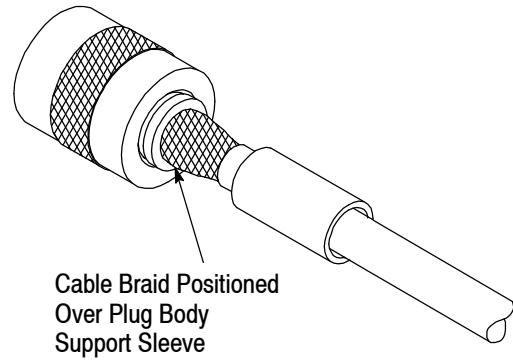
6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the plug body. See Figure 5, Detail B.

7. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 5, Detail C.

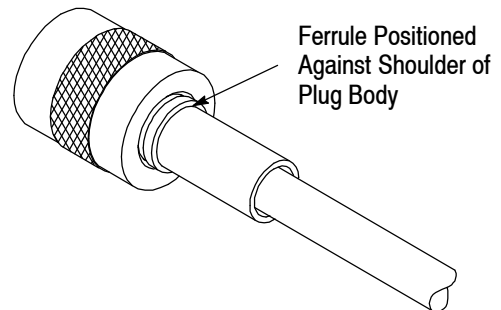
#### 4. REVISION SUMMARY

- Updated document to corporate requirements
- Changed part numbers in title and Section 1, INTRODUCTION
- Deleted obsolete information in Figure 2

#### Detail A



#### Detail B



#### Detail C

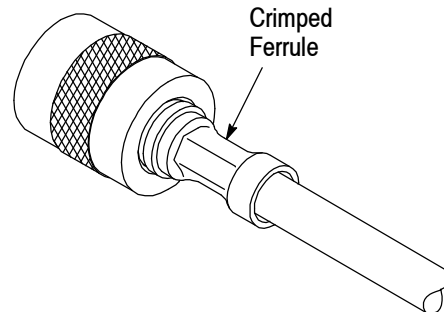


Figure 5