

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP 50-Ohm RF Series TNC Right-Angle Dual Crimp Plug Connectors 414173-[]. The connector is crimped onto various sizes of RG/U cable using AMP PRO-CRIMPER* II Frame Assembly 354940-1, which accepts interchangeable crimping die assemblies.

AMP Catalog 82074 provides die assembly part numbers for the frame assembly, product application requirements, cable selection, and product part number information. For information not listed, contact AMP Engineering for recommendations. Refer to instruction sheet 408-9930 for procedures concerning the operation of the frame assembly.

NOTE Dimensions are in millimeters [followed by inches in brackets].

2. DESCRIPTION (Figure 1)

Each connector consists of a plug body, a center contact, and a ferrule (some ferrules are designed with a flange). The center contact is crimped onto the cable center conductor and assembled onto the plug body. The ferrule is then crimped onto the cable braid and plug body to complete the assembly.

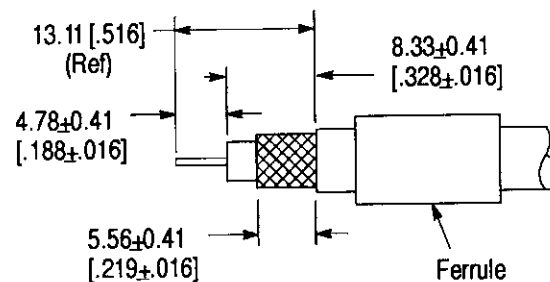
Some connectors are supplied with a step-down ferrule and a tubing. The tubing is slipped over the cable dielectric before the center contact is crimped. In this use, the tubing compensates for small diameter cable dielectrics.

3. ASSEMBLY PROCEDURE

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

Recommended Cable Strip Length



Note: Not to Scale

Figure 2

NOTE For connectors supplied with tubing, slip tubing over the cable dielectric.

- Insert center conductor into center contact. The center contact shoulder must be positioned against the cable dielectric, as shown in Figure 3. Be sure the cable insulation does not enter the center contact wire barrel.
- Crimp the center contact with the recommended frame assembly fitted with the appropriate die assembly.
- Flare cable braid to allow the support sleeve of the plug body to pass under the cable braid. Refer to Figure 3.

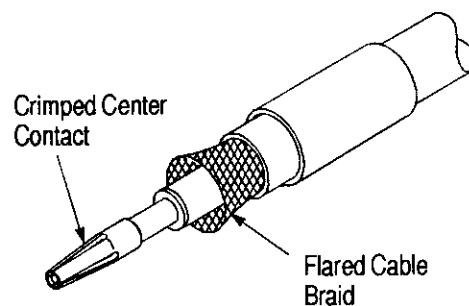
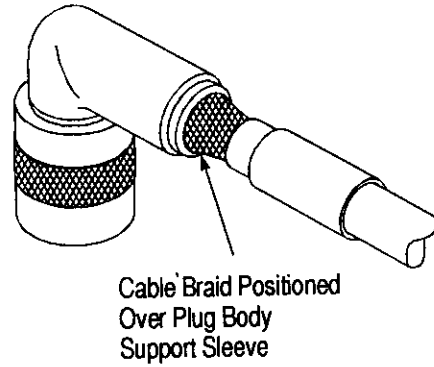
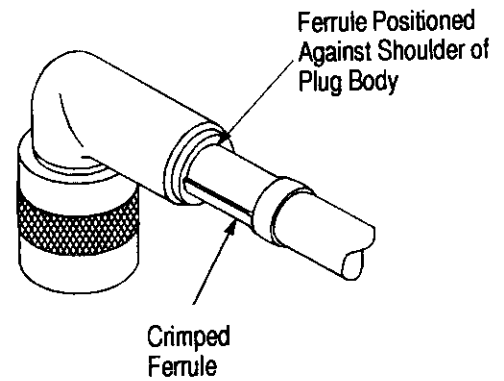


Figure 3

5. Insert center contact into plug body. The cable braid must be positioned over the plug body support sleeve. See Figure 4, Detail A.
6. Slide ferrule forward over cable braid and support sleeve until it is positioned against the shoulder of the plug body. See Figure 4, Detail B.
7. Crimp the ferrule using the recommended frame assembly fitted with appropriate die assembly. See Figure 4, Detail B.

Detail A**Detail B****Figure 4**