

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP® COAXICON 50-Ohm HN Series RF Straight and Right-Angle Plug Connectors which are crimped onto various sizes of RG/U cable. Catalog 82074 provides a guide for cable-to-connector selection. For cable sizes and connectors not referenced in the catalog, contact AMP Product Engineering for recommendations.

NOTE

Dimensions are in millimeters [followed by inch equivalents in brackets]. Figures are for identification only and are not drawn to scale.

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

2. DESCRIPTION

Each straight and right-angle connector features a plug body, center contact, and three ferrules. Because two types of cable (coaxial and armored) can be used with certain connectors, three different ferrules are supplied with each connector. See Figure 1.

For application to armored cable, the braid ferrule is required for the cable's inner braid, and the armor ferrule is used for the cable's armor. The third ferrule is discarded. For application to coaxial cable, the

ferrule containing the rubber seal is used, while the other two ferrules are discarded.

3. ASSEMBLY PROCEDURE

3.1. COAXIAL CABLE

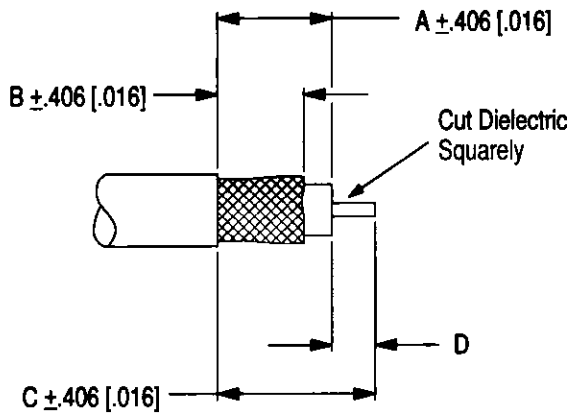
1. Slide the ferrule over the cable, and strip the cable according to the dimensions shown in Figure 2.
2. Crimp the center contact using the appropriate hand tool.
3. Insert the center contact into the plug body. See Figure 3, Detail A. Make sure the cable's braid is over the support sleeve of plug body. See Figure 3, Detail B. Lightly pull back to make sure the center contact is held securely by the plug body's internal locking feature.

NOTE

When using connectors designed for small cable sizes, for example RG58 and RG59, inserting the center contact with too much force will allow it to pass beyond the plug body's internal locking feature. If this occurs, pull back on the cable to properly locate the center contact.

4. Slide ferrule forward over braid and support sleeve. See Figure 3, Detail C.
5. Crimp the ferrule using the appropriate hand tool.

Stripping Coaxial Cable



RG/U CABLE TYPE	STRIPPING DIMENSIONS			
	A	B	C	D
8,8A,213,393	17.48 [.688]	9.53 [.375]	22.23 [.875]	4.78 [.188] (Ref)
9,9A,9B,149, 214,391,393		12.70 [.500]		
58,59,302	9.53 [.375]	6.35 [.250]	14.30 [.563]	
59■	10.31 [.406]		14.30 [.563] (Ref)	3.96 ± .406 [.156 ± .016]
142 B/U	12.70 [.500]	9.53 [.375]	17.48 [.688] (Ref)	4.78 ± .406 [.188 ± .016]

■ For connector part number 414725-1 only.

Figure 2

3.2. Armored Cable

- Slide the armor ferrule over the cable. Pull the cable's armor back so that 38.10 [1.500] of the cable jacket is exposed. Wrap the end with tape to hold it in place. See Figure 4. Then, strip the cable to the dimensions shown in Figure 4.
- Crimp the center contact using the appropriate hand tool. See Figure 5, Detail A.
- Slide the braid ferrule over the cable jacket. See Figure 5, Detail B.
- Slide plug body over crimped contact, and insert the support sleeve under the cable's braid until the plug body dielectric bottoms against the cable dielectric. Refer to Figure 5, Detail C.
- Lightly pull back on the cable to make sure the center contact is held securely by the plug body's internal locking feature.

- Slide the braid ferrule over the cable's braid and the plug body's support sleeve until ferrule butts against plug body. Refer to Figure 5, Detail D.
 - Crimp braid ferrule using the appropriate hand tool.
 - Remove the tape and push the cable's armor over crimped braid ferrule. Refer to Figure 5, Detail E.
- NOTE** Trim off any excess cable braid that would prevent the armor ferrule from bottoming against plug body.
- Slide the armor ferrule over cable's armor and against the plug body. Refer to Figure 5, Detail F.
 - Crimp armor ferrule with the appropriate hand tool.

Connector Assembly for Coaxial Cable

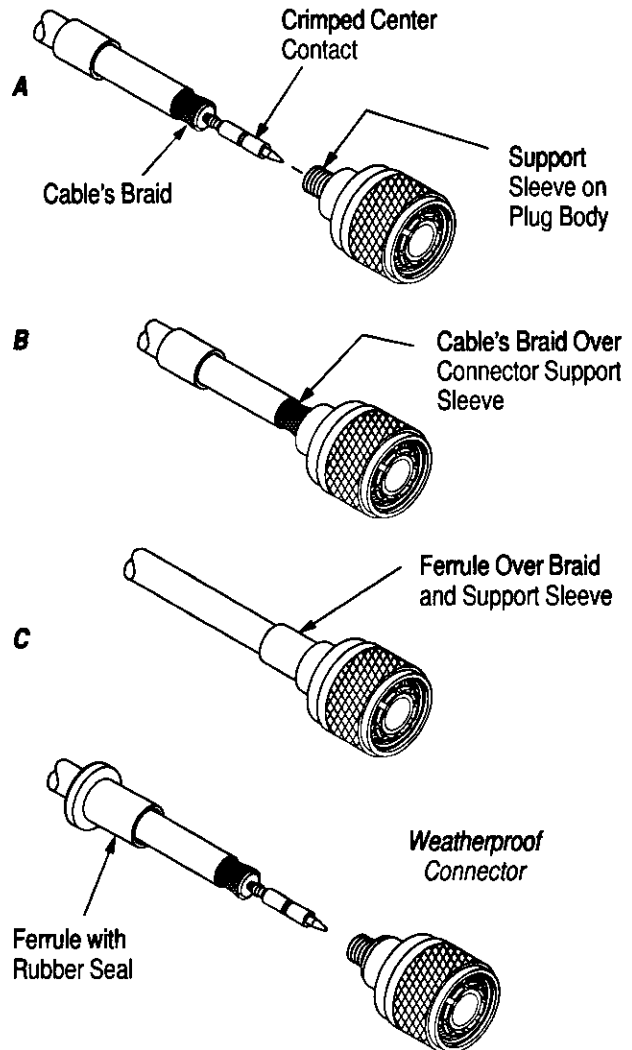


Figure 3

Stripping Armored Cable

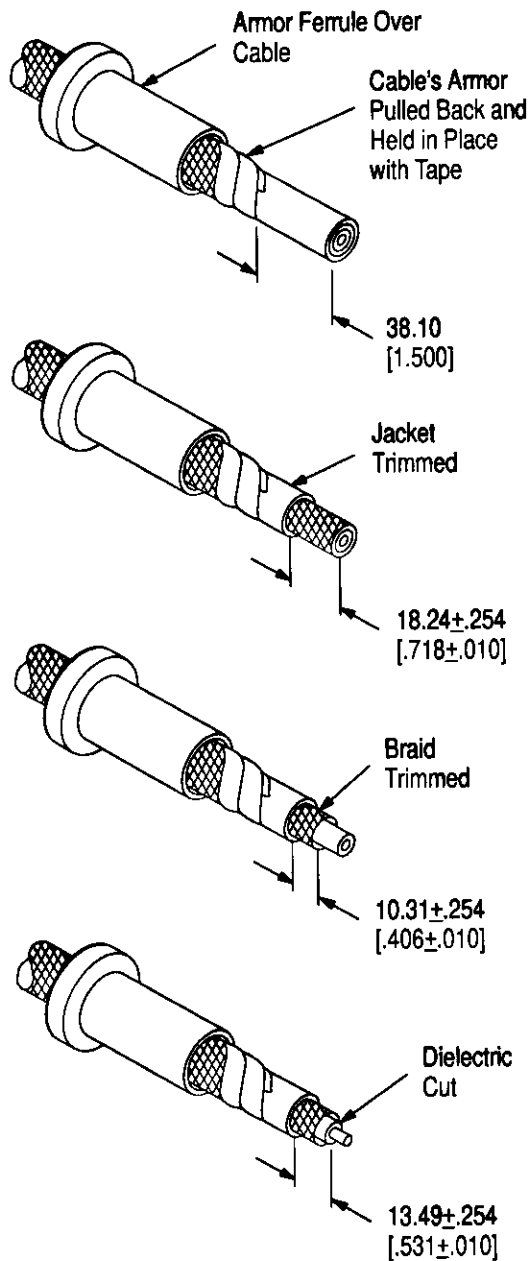


Figure 4

Connector Assembly for Armored Cable

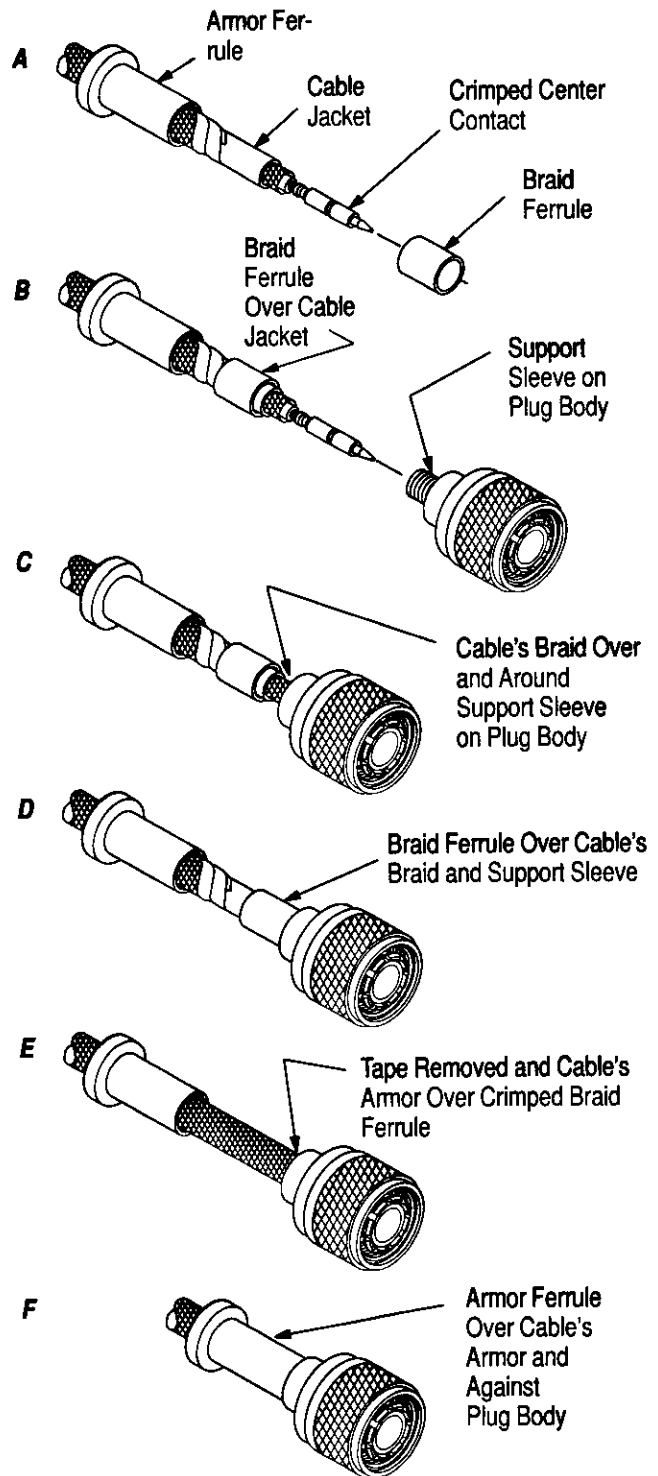


Figure 5

4. REVISION SUMMARY

Revisions to this document include:

Per EC 0990-0988-96:

- Changed strip dimension "D" in Figure 2 from .396 to 3.96