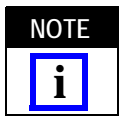


NOTE: Some Standard type Connectors are Supplied with a Step-Down Ferrule.

Figure 1

1. INTRODUCTION

This instruction sheet covers the selection and assembly of COAXICON 50-Ohm RF Series BNC Plug Connectors. Read these instructions thoroughly before starting assembly.



Dimensions on this sheet are in millimeters [with inches in brackets].

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

2. DESCRIPTION (Figure 1)

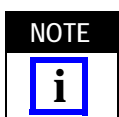
The BNC plug connector series features two types of connectors; the standard connector and the weatherproof connector. The standard connector consists of a plug body, a gasket, a crimp end, and ferrule. The weatherproof connector consists of a plug body, a gasket, a seal, a crimp end, and a ferrule.

Refer to Table 1 and Table 2 for the selection of cable sizes, BNC connectors, and recommended crimping tools.

3. ASSEMBLY PROCEDURES (Figure 2)

Determine type of connector; then refer to the appropriate table for the selection of cable sizes and connector part number. Proceed as follows:

1. Slide ferrule onto the cable; then strip cable according to the dimensions shown in the appropriate figure (referenced in the table).



When assembling connectors containing a step-down ferrule, be sure the larger diameter end of the ferrule faces the crimp end, as shown in Figure 1.

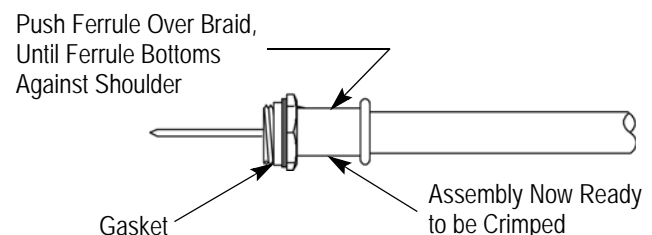
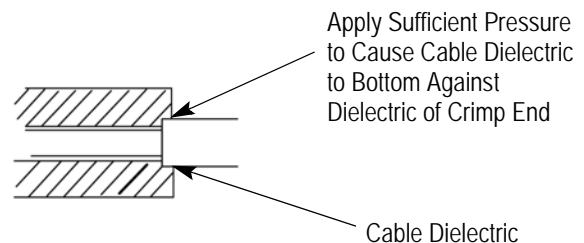
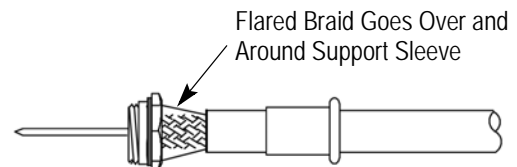
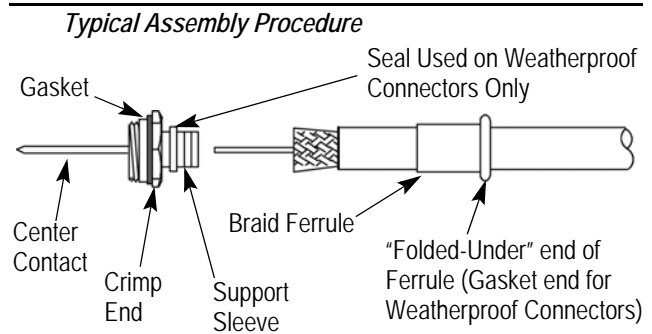


Figure 2

2. Insert stripped conductor into center contact on the crimp end. Twist the crimp end slightly to ease entry of the wire.

3. Push crimp end under the flared braid so that the braid goes over and around the support sleeve. Apply sufficient pressure to cause the cable dielectric to bottom against the dielectric of the crimp end. Twist crimp end slightly to ensure bottoming.

4. Slide ferrule forward and over the braid until ferrule bottoms against the shoulder of the crimp end.

5. Crimp the ferrule and contact portion of the connector simultaneously with the appropriate crimping tool. Refer to Table 1 or Table 2 for the appropriate crimping tool.

NOTE For information concerning crimping procedures, refer to the tool instruction sheet packaged with the tool.

6. After the ferrule and contact portion are crimped, assemble crimp end into the connector body. See Figure 3.

7. Tighten the crimp end to 1.69 to 2.26 N•m [15 to 20 in./lb].

NOTE Make sure the gasket is assembled between the plug body and crimp end for the assembly of weatherproof type connectors.

Crimp End to Connector Body

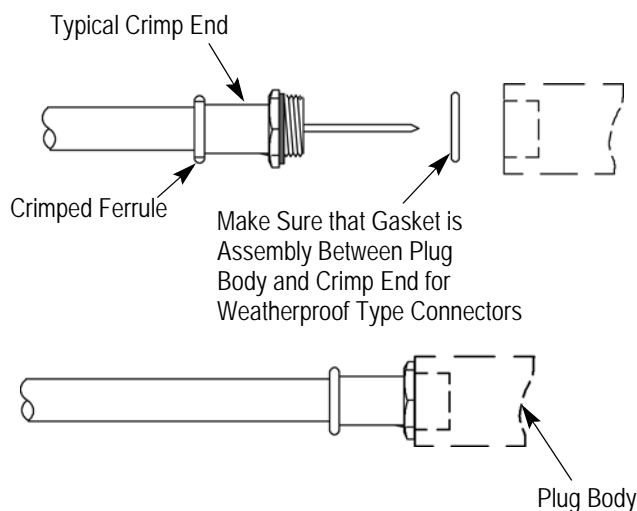
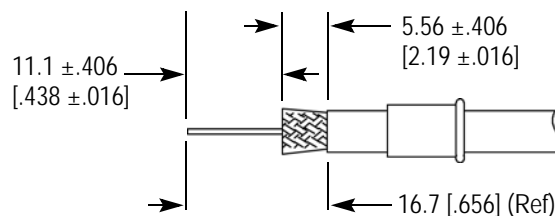
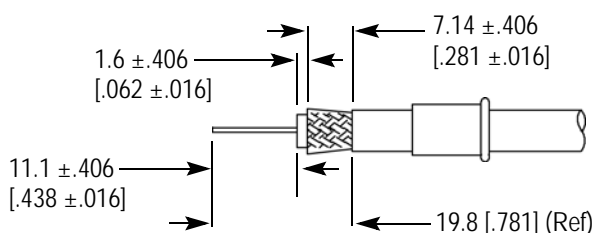


Figure 3



NOTE: Not to Scale

Figure 4



NOTE: Not to Scale

Figure 5

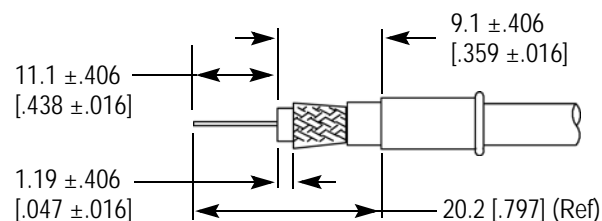


Figure 6

4. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Replaced trademark references for PTFE.
- Updated document to corporate requirements.

STANDARD BNC PLUG CONNECTORS

Cable [†]	Connector Used With Polypropylene Dielectric		Connector Used With PTFE Dielectric	Cable Strip Dimension (Figure Ref.)	Crimping Tool		Crimping Dies For Tools 189721, 189722, 69710-1	
	Silver Plated	Tarnish Resistant	Silver Plated		Part No.	408-Series Instructions	Part No.	408-Series Instructions
58, 58A 58B, 58C	-- 2-329082-1	-- --	-- 2-329444-1	Figure 4	69140-1	2340	69223-1	2496
59, 59A, 59B 62, 62A, 62B 124, 140, 210	-- 2-329083-1 --	-- -- --	-- 2-329445-1 --					
161, 179, 187	2-329084-1	--	2-329446-1	Figure 4	69245-1	2340	69408	2496
	--	--	--					
180, 180A, 195	-- --	-- --	2-329447-1 --	Figure 4	69246-1	2340	69423	2496
	--	--	--					
55, 55A 55B, 223	-- --	-- --	2-329444-2 --	Figure 4	69140-2	2340	69424	2496
	--	--	--					
71, 71A, 71B	--	--	2-329445-2	Figure 4	69141-2	2340	--	--
174, 188	2-330058-1	225527-9	2-330061-1	Figure 4	69245-1	2340	69422	2496
AMPHENOL 21-597	2-330018-1	--	--	Figure 4	69246-2	2340	69423	2496
141, 141A	--	--	2-330358-1	Figure 4	69140-1	2340	69223-1	2496
142, 142A, 142 B	--	--	2-330358-2	Figure 4	69331-1	2340	69429-1	2496
178, 196	--	--	330876	Figure 4	69245-4	2340	69471	2496
BELDEN 8281, 9141, 9231 W.E. 724, 3049, 728	330878	--	--	Figure 5	69652	--	220000	2496
	--	--	--					

[†]RG/U Coaxial Cable Manufactured in Accordance with MIL-C-17D

Table 1

WEATHERPROOF BNC PLUG CONNECTORS

Cable [†]	Connector Used With PTFE Dielectric	Cable Strip Dimension (Figure Ref.)	Crimping Tool		Crimping Dies for Tools 189721, 189722, 69710-1	
			Part No.	408-Series Instructions	Part No.	408-Series Instructions
58, 58A, 58B, 58C	330884	Figure 6	69376-3	2349	69815	2610
58C	330884	Figure 6	69376-1	2349	69493	2610
			69376-3		69815	
142, 142A, 142B	2-330884-2	Figure 6	69376	2349	69493-1	2610

[†]RG/U Coaxial Cable Manufactured in Accordance with MIL-C-17D

Table 2