

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP 75-Ohm BNC Plug Dual Crimp Connectors 221185-[]. The connectors are applied either with AMP Hand Tool 354940-1 or with AMP Pneumatic Tool 69365-3. Both tools accept interchangeable crimping dies, using different die sizes (and part numbers) according to the cable type being used with the connector. For information on die set part numbers, cable sizes, and connector part numbers, refer to AMP Catalog 82074.

NOTE

All dimensions on this sheet are in millimeters [with inch equivalents provided in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

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

2. DESCRIPTION (Figure 1)

Each connector features a center contact, a plug body, and a ferrule. The center contact is crimped to the cable's center conductor, and the ferrule is crimped onto the back of the connector, over the cable braid, to secure the cable to the plug body.

NOTE

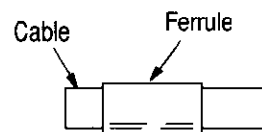
The ferrules differ with connector selection. Some connectors come with straight ferrules, while others use step-down ferrules.

Some connectors are supplied with a plastic bushing and a brass tube. The plastic bushing and brass tube are slipped over the cable dielectric before the center contact is crimped. In this use, the bushing and tube compensate for small diameter cable dielectrics.

3. ASSEMBLY PROCEDURE

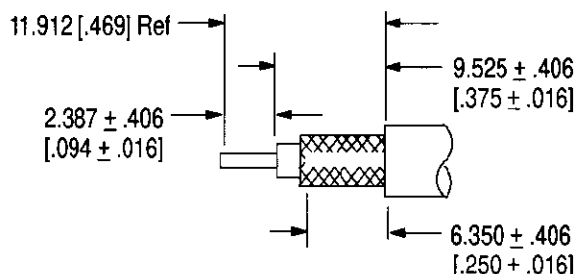
1. Determine the cable type for your application, then select an appropriate connector. Refer to AMP Catalog 82074.

2. Slide the ferrule over the cable end.



3. Strip the cable according to these dimensions:

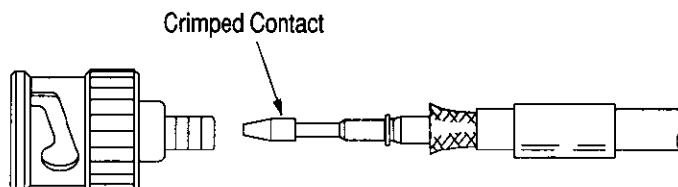
NOTE: Do not scale from illustration.



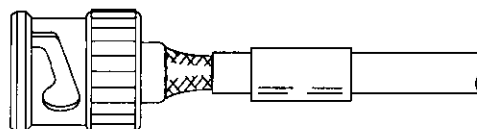
4. Crimp the center contact.

NOTE

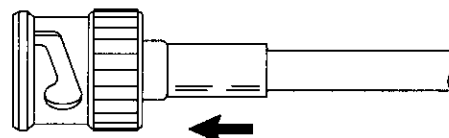
Plugs 221185-8, 1-221185-2, and 2-221185-0 come with a plastic bushing and a brass tube. The bushing and tube must be slipped over the cable dielectric (flared end first) BEFORE the center contact is crimped.



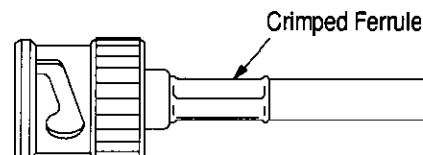
5. Insert the center contact into the plug body with the braid over the support sleeve of the plug body.



6. Slide the ferrule over the braid and support sleeve.



7. Crimp the ferrule using the appropriate tooling.



4. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made:

Per EC 0220-0150-95:

- Added plastic bushing, brass tube, and step-down ferrule to Figure 1.

Per EC 0990-0734-95:

- AMP Hand Tool 220190-1 superseded by 354940-1 in Section 1, INTRODUCTION.
- Added statements clarifying plastic bushing, brass tube, and step-down ferrule to Section 2, DESCRIPTION.
- Deleted Plug 1-22184-4 in note on page 2 because it is an incorrect part number.
- Updated format.
- Changed revision level from A to B.