

AMP

AMP INCORPORATED
HARRISBURG, PA 17105

AMP* TNC SERIES SINGLE CRIMP 50-OHM PLUGS

IS 9566

CUSTOMER HOTLINE
1 800 722-1111

RELEASED
12-7-90

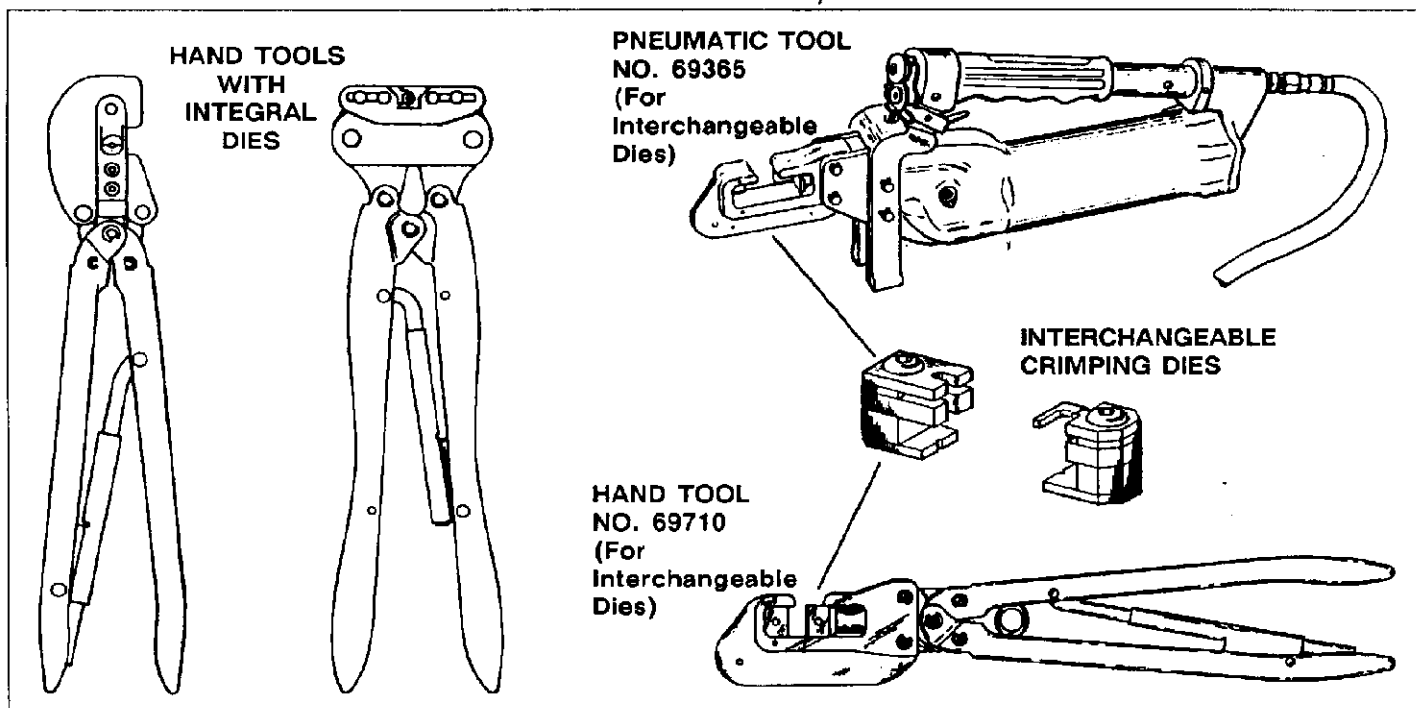


Fig. 1

1. INTRODUCTION

This Instruction Sheet (IS) contains information necessary for the selection of TNC connectors and tools, as well as cable stripping dimensions for all connectors. (Only typical tools and dies are shown.)

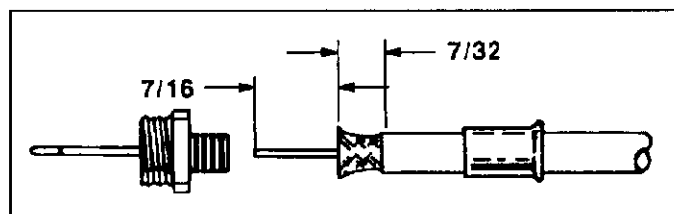


Fig. 2

2. DESCRIPTION

TNC connectors include body, seal, ferrule, and crimp end. Sealed TNC connectors include body, crimp end, and ferrule.

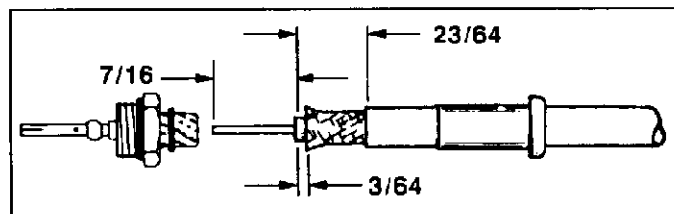


Fig. 3

NOTE

Crimp end should not be assembled to connector body until crimp is completed.

3. RECOMMENDED TOOLS AND DIES

Use either the hand tools listed or the interchangeable dies in appropriate tools. Interchangeable dies are used in AMP Hand Tool No. 69710 or AMP Pneumatic Tool No. 69365. See Figure 1.

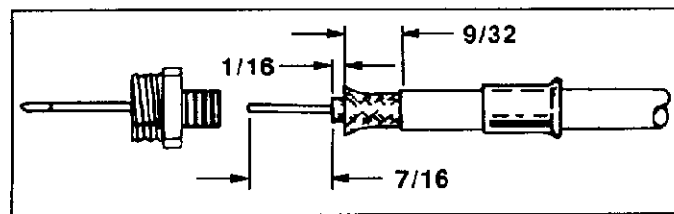


Fig. 4

<p>TNC PLUG ASSEMBLY</p>				
CABLE	ASSEMBLY NUMBER	CRIMPING TOOL NUMBER	CRIMPING DIE NUMBER	CABLE STRIP DIM.
59, 59A, 59B, 62, 62A, 62B, 124, 140, 210	331100	69141-1, 69141-1 Mod. R	69224-1	FIG. 2
161, 179, 187	331103	69245-1, 69245-1 Mod. P	69408	

Table 1 - TNC PLUGS

<p>WEATHERPROOF TNC PLUG ASSEMBLY</p>				
CABLE	ASSEMBLY NUMBER	CRIMPING TOOL NUMBER	CRIMPING DIE NUMBER	CABLE STRIP DIM.
58, 58B	330953	69376-3	69815	FIG. 3
55, 55A, 55B, 223	2-330953-3	69376-3	69815	
141, 141A	2-330953-1	69376-3	69815	
142, 142A, 142B	2-330953-2	69376	69493-1	

Table 2 - WEATHERPROOF TNC PLUGS

<p>WEATHERPROOF TNC RIGHT ANGLE PLUG ASSEMBLY</p>				
CABLE	ASSEMBLY NUMBER	CRIMPING TOOL NUMBER	CRIMPING DIE NUMBER	CABLE STRIP DIM.
58, 58B	1-332292-3	69376-3	69815	FIG. 3
58C	1-332292-3	69811	220006-1	
55, 55A, 55B, 223	1-332292-1	69376-3	69815	
141, 141A	1-332292-5	69376-1	69493	
142, 142A, 142B	332292	69376	69493-1	

Table 3 - WEATHERPROOF TNC RIGHT ANGLE PLUGS

4. CRIMP END ASSEMBLY

NOTE

Assembly procedure is the same for all connectors.

To assemble crimp end, proceed as follows.

1. Slip ferrule on cable, then strip cable and flare braid as shown in Figures 2, 3, and 4.
2. Insert stripped conductor into wire barrel on crimp end. Twist crimp end slightly to ease entry of wire.
3. Push crimp end back under braid so that braid passes over and around support sleeve. Apply sufficient pressure to cause cable dielectric to bottom against dielectric of crimp end. See Figure 5. Twist crimp end slightly to assure bottoming.
4. Slide ferrule forward and over braid on crimp end as far as it will go. See Figure 5. Crimp end is now ready to be crimped.

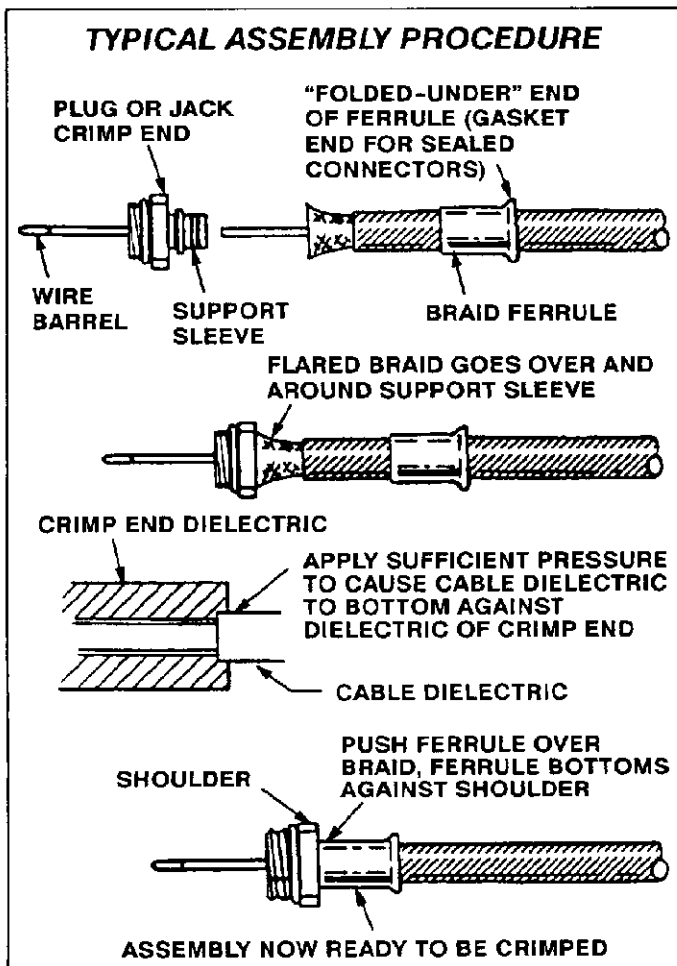


Fig. 5

5. CRIMPING PROCEDURE

Several of the hand tools contain a "quick take-up" device, or handle, on the CERTI-CRIMP[®] Ratchet Assembly. To close tool handles, the small handle on the ratchet assembly is pulled toward the tool handle. See Figure 6. Both tool handles are then closed to complete crimp.

NOTE

The crimping tools, dies, and crimping procedures are similar regardless of the type connector to be crimped.

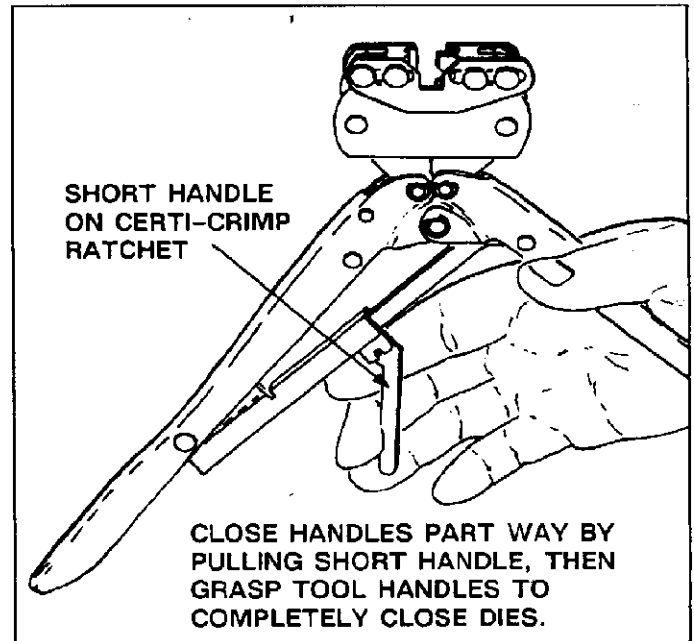


Fig. 6

5.1. HAND TOOLS WITH INTEGRAL DIES

NOTE

The crimping tools have multiple sets of dies. See Figures 7 and 8 to crimp the braid ferrule and wire barrel of crimp end. Ferrule and wire barrel are crimped at the same time.

1. Open crimping dies by closing tool handles until CERT-CRIMP ratchet releases. Note that once ratchet is engaged, the handles cannot be opened until they are fully closed.
2. Place the crimp end in crimping dies as shown.
3. Make certain that wire barrel and braid ferrule of crimp end are resting firmly on crimping dies. See Figures 7 and 8.
4. Close handles part way by pulling short handle on CERTI-CRIMP ratchet (for tools containing this feature), then grasp and close tool handles to complete crimp.

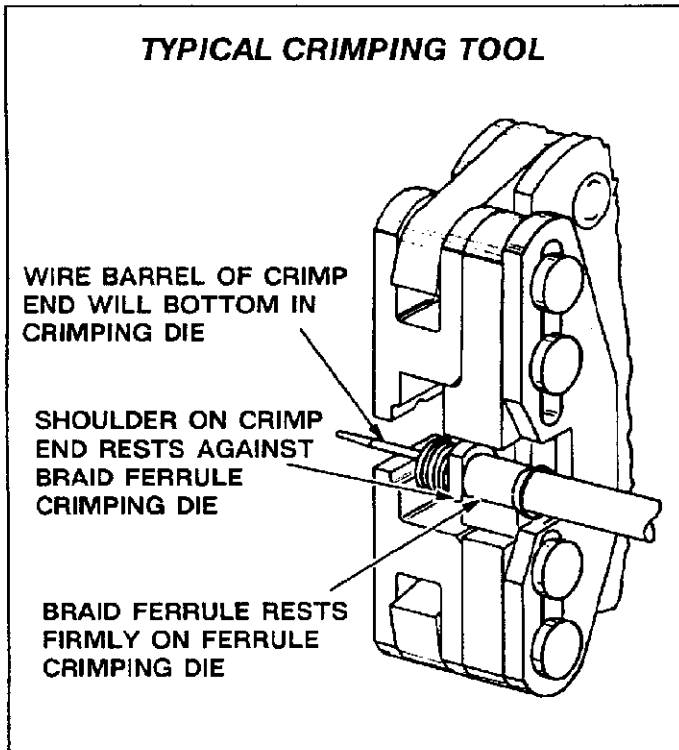


Fig. 7

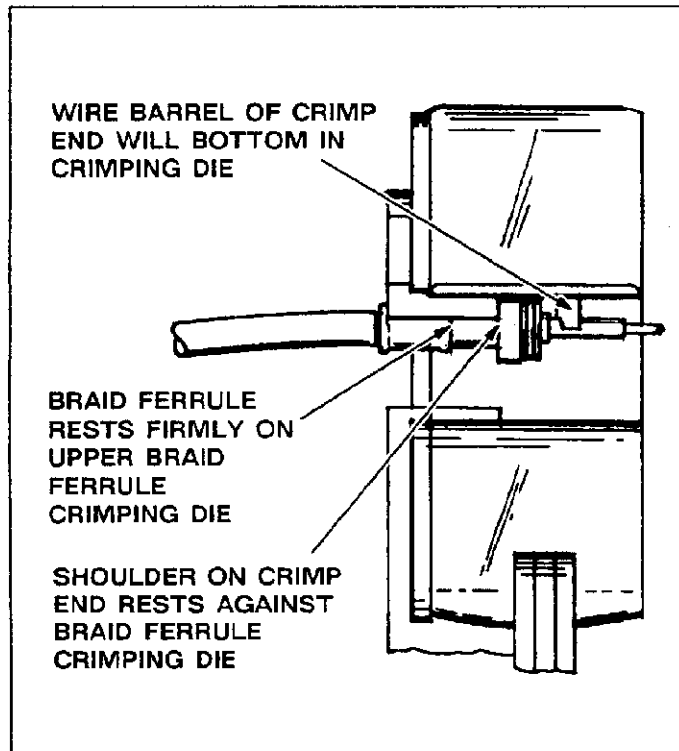


Fig. 8

5.2. INTERCHANGEABLE DIES

AMP TNC Series COAXICON* Crimping Dies are used in AMP Tools No. 69710 and 69365. Read the instructions shipped with tools for information concerning die insertion and general tool performance. Refer to selection charts for proper connectors and cables to use. Then proceed as follows:

1. Place crimping dies in tool. The die assemblies have multiple sets of crimping dies similar to those in hand tools. See Figure 9.

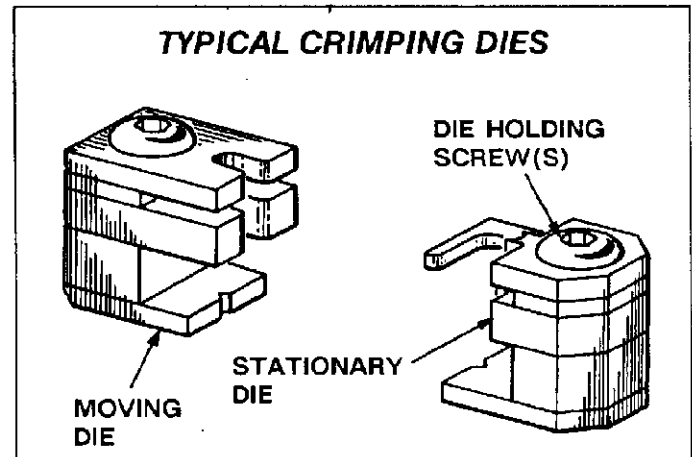


Fig. 9

2. Place the crimp end in crimping dies as shown in Figure 10.

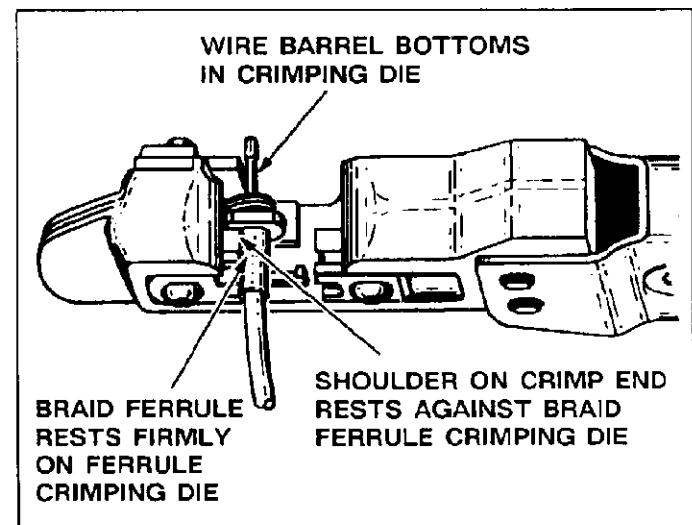


Fig. 10

3. Make certain that wire barrel and braid ferrule of crimp end are resting firmly on crimping dies. See Figure 10. Hold assembly in place and complete crimp.

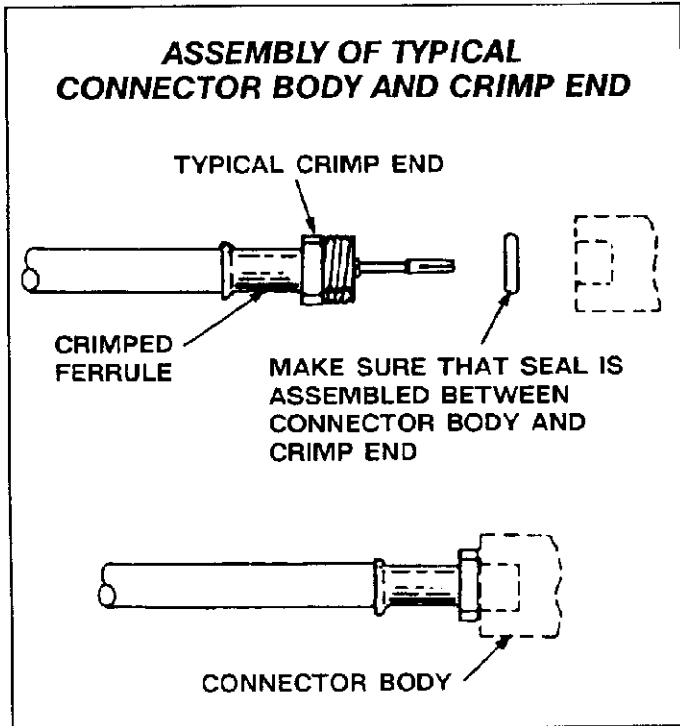


Fig. 11

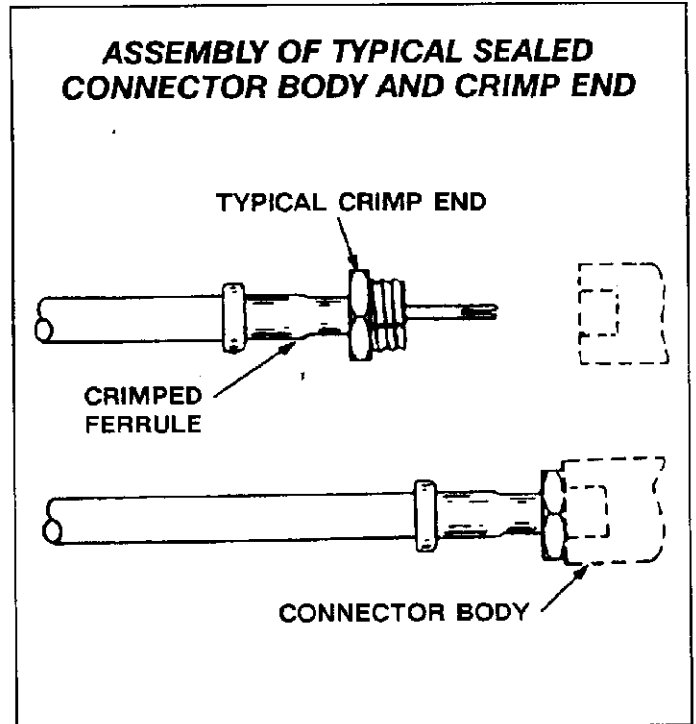


Fig. 12

6. CONNECTOR ASSEMBLY

1. Assemble crimp end and connector body as shown in Figure 11.
2. Assemble crimp end and sealed connector as shown in Figure 12.
3. Use a wrench on flats to tighten. A torque of 15 to 20 inch-pounds is suggested.