Crimping outer conductors

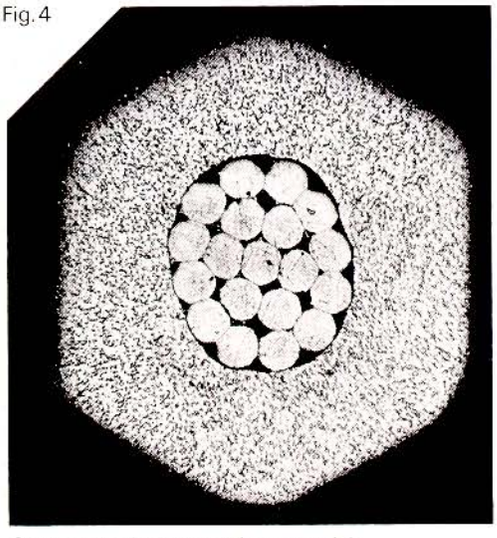
This means a considerably greater pressure effect on the conductor to be connected, a better cold welding and therefore a connection of higher reliability.
Fig. 4 shows microsections of hexagonal and square crimpings (RG 58 C/U, BNC) which were both dimensioned according to the law of equal periphery. The force necessary for crimping is in both cases 320 kp.

In Fig. 5 are shown the results of a series of tests on crimped inner conductors of series N connectors and RG 214/U cable. The relationship of crimp recesses to the uncrimped pin circumferences are given as percentages, and are shown relative to the pull out force. Optimum results are achieved with circumference ratios of 100% to 104%.

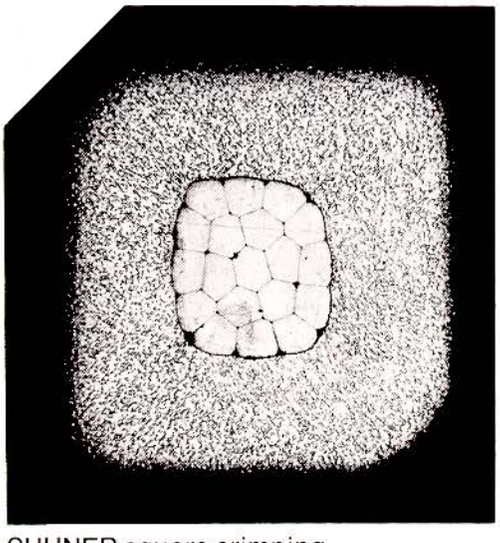
Here the same points of view apply. The wires of the cable screen are pressed on to the crimp spigot by means of an additional ferrule (Fig. 6). The crimp spigot must be of sufficient strength not to be deformed or flattened under the crimping pressure.

For obvious reasons, hexagonal crimping is used exclusively. The law of equal periphery is again valid for dimensioning. It is especially advantageous to provide the crimp spigot with a knurl in order to obtain an additional form of locking.

Fig. 4

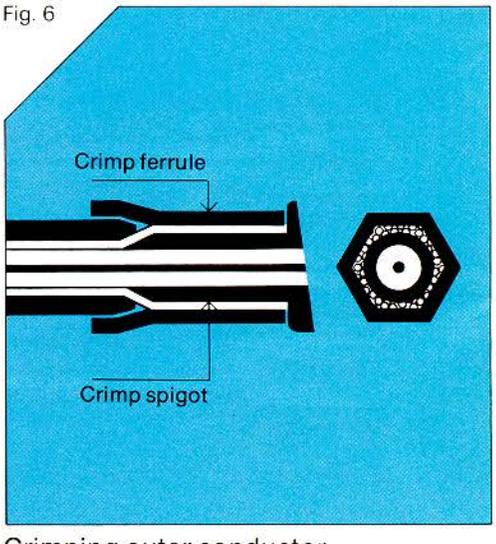


Crimping in accordance with MIL-C-39012, Category D, Pin 16–10
Pull-out force: 7 kp



SUHNER square crimping
Pull-out force: 12 kp

Fig. 6



Crimping outer conductor

Fig. 5

Results of crimping tests on Series N inner conductors and RG 214/U cable