

AMP

AMP INCORPORATED
HARRISBURG, PA 17105

AMP* 50-OHM
N SERIES HEX CRIMP PLUG CONNECTORS
414160-[]

IS 9791

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RELEASED
5-18-92

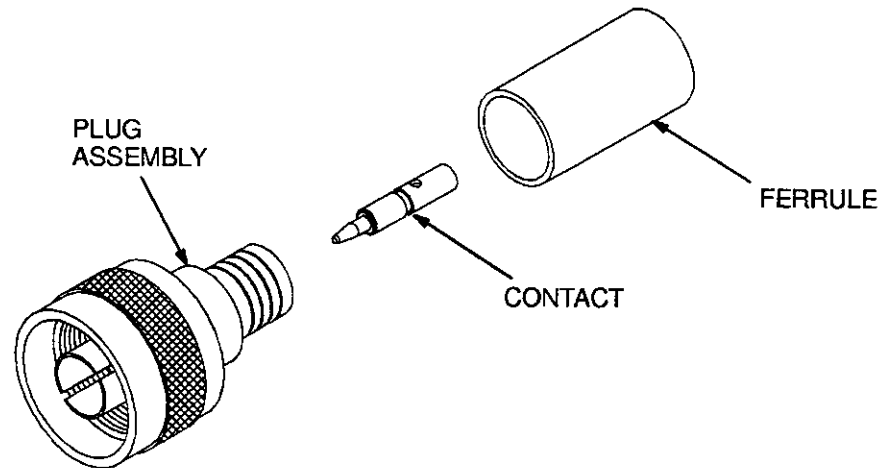


Fig. 1

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1. INTRODUCTION

This Instruction Sheet (IS) covers the assembly of AMP 50-Ohm N Series Hex Crimp Plug Connectors 414160-[]. The connectors are terminated with AMP Pro-Crimper Frame Assembly 58434-1 and die assemblies 58485-1 or -2 (purchased separately). To select the appropriate tool-to-die combination and cable size, refer to the AMP Customer Drawing. Operation and maintenance procedures for the Pro-Crimper tool are available in IS 9134.

NOTE

Measurements are in millimeters [followed by inches in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

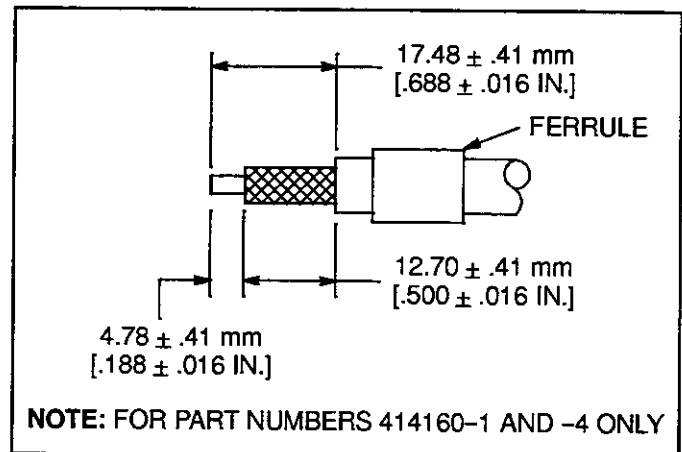


Fig. 2

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2. DESCRIPTION

The connector consists of a plug assembly, a center contact, and a ferrule. For details concerning product specifications, refer to AMP Catalogs 82677 and 82074.

3. ASSEMBLY PROCEDURE

- Slide ferrule over the end of the cable; then strip cable using the appropriate strip-length dimensions provided in Figure 2, 3, or 4. Flare cable braid, making sure center conductor is straight and free of burrs.

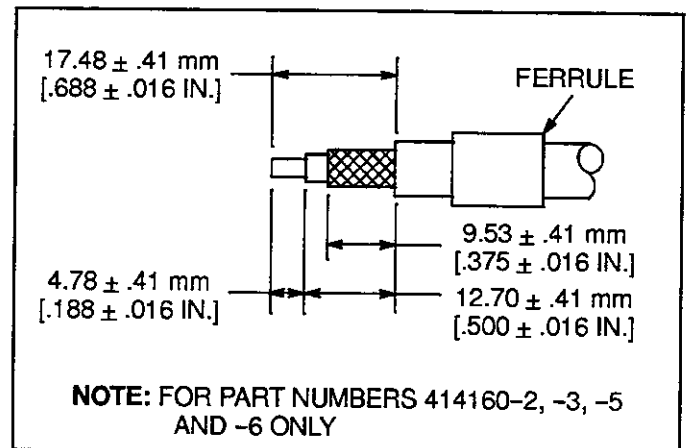


Fig. 3

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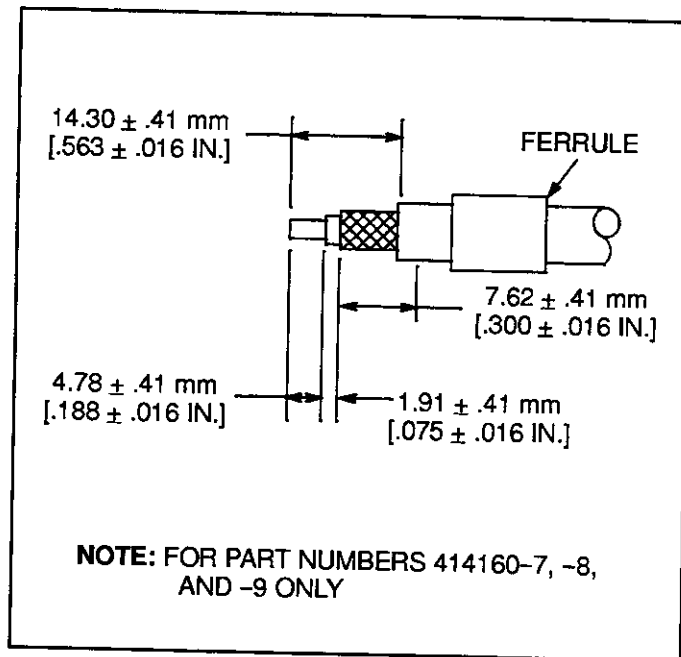


Fig. 4

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2. Insert center conductor into contact; then crimp contact using the Pro-Crimper tool (fitted with the appropriate die assembly). See Figure 5.

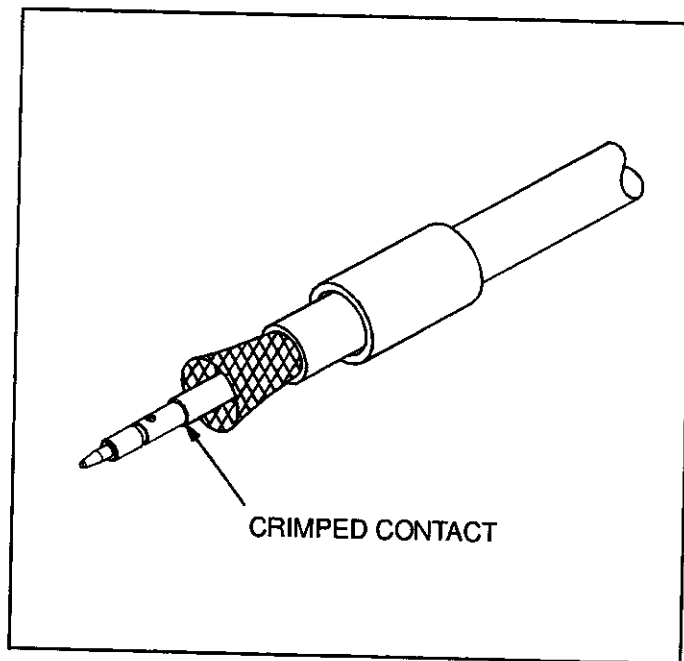


Fig. 5

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3. Insert contact into plug assembly until it snaps into place. Make sure that the cable braid is positioned over the support sleeve of the plug

assembly. Gently pull back on the cable to ensure that the contact is held in place by the internal locking feature. See Figure 6.

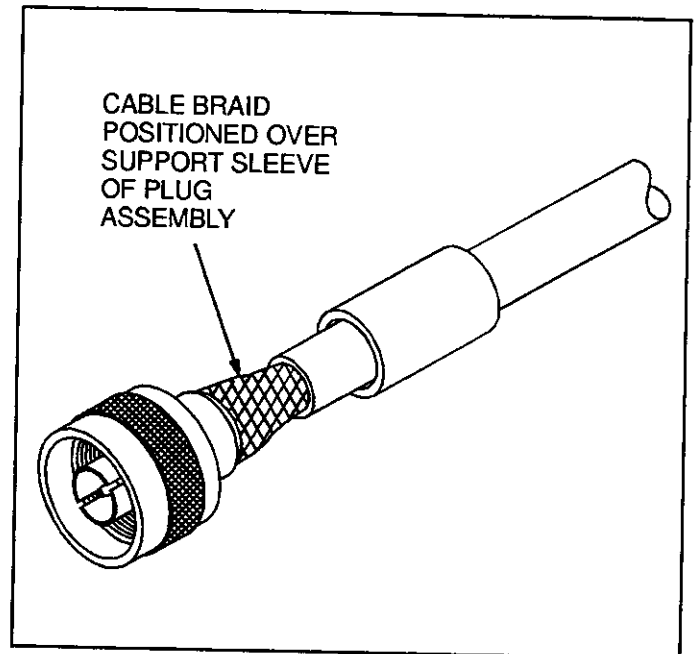


Fig. 6

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4. Slide ferrule forward over braid and support sleeve; then crimp ferrule using the Pro-Crimper tool (fitted with the appropriate die assembly). See Figure 7.

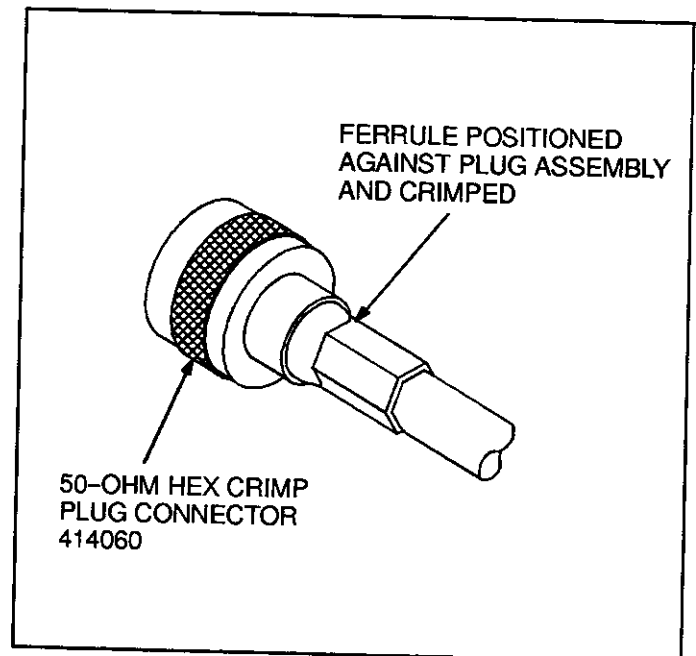


Fig. 7

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