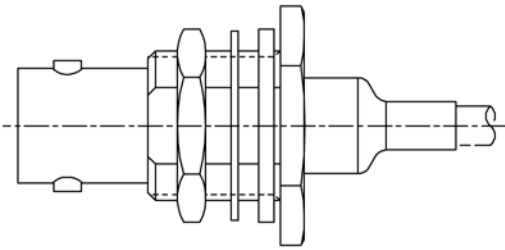


Twin BNC Series COAXICON Plug Connector



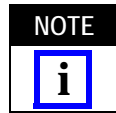
Twin BNC Series COAXICON Bulkhead Jack Connector

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the selection and assembly of the Twin BNC Series Connectors in Figure 1. The connectors are designed for field service applications. A bulkhead jack adapter is also covered on this sheet.

Please read these instructions thoroughly prior to assembly



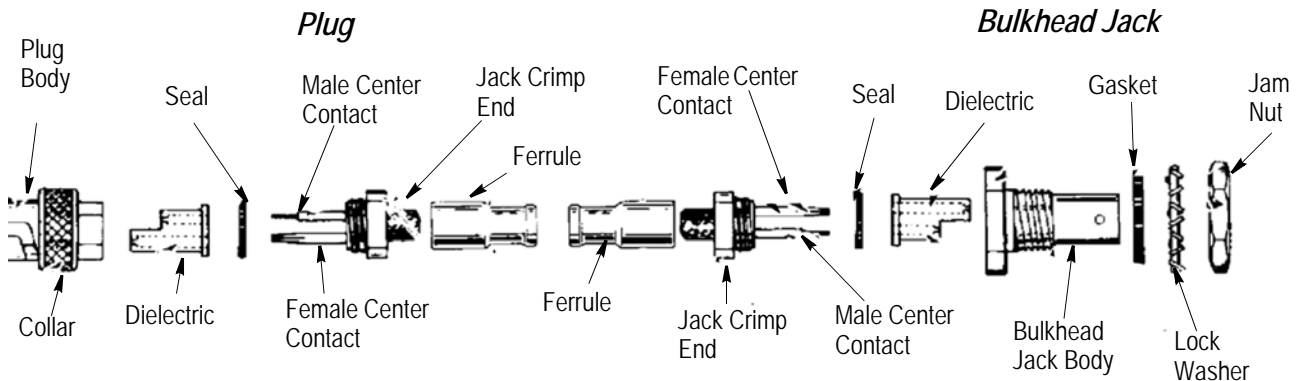
*Dimensions on this instruction sheet are in metric units [with inch equivalents in brackets].*

Reasons for revision can be found in Section 5, REVISION SUMMARY.

## 2. DESCRIPTION

Basic descriptions, as well as plug and bulkhead jack part numbers, corresponding cable sizes and corresponding crimp tooling can be found in Figure 2.

The twin BNC connectors combine the quick connect/disconnect features of a bayonet locking connector with dual signal carrying capabilities.



| PLUG CONNECTOR | BULKHEAD JACK CONNECTOR | CABLE NUMBER      | HAND CRIMPING TOOL     | CRIMPING DIES         |
|----------------|-------------------------|-------------------|------------------------|-----------------------|
| 332225         | 332342                  | 108 and 108A      | 354940-1<br>(408-9930) | 91909-1<br>(408-8580) |
| 332225-1       | --                      | Raychem 7824D0130 |                        |                       |
| 332225-5       | --                      | 108 and 108A      |                        |                       |
| 332225-6       | --                      | ROLM 49D2401      |                        |                       |

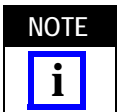
Figure 2

Some basic features of the twin-type connectors are as follows:

- **Plug Connector** -- The connector includes a plug body with a collar, a dielectric, a seal, two center contacts (male and female), a plug crimp end and a ferrule.
- **Bulkhead Jack Connector** -- The connector includes a bulkhead jack body, a dielectric, a seal, two center contacts (male and female), a jack crimp end and a ferrule. A gasket, lock, washer and jam nut are also included with the jack body.

### 3. CRIMP END ASSEMBLY

Determine the cable size and the connector type needed for your application. Then refer to the table in Figure 2 and select the appropriate connector, tooling and dies.



*For specific information on crimping tools, refer to the publications listed in Figure 2.*

Proceed as follows

1. Slide the ferrule onto the cable prior to stripping the cable.
2. Strip the cable according to the dimensions in Figure 3.

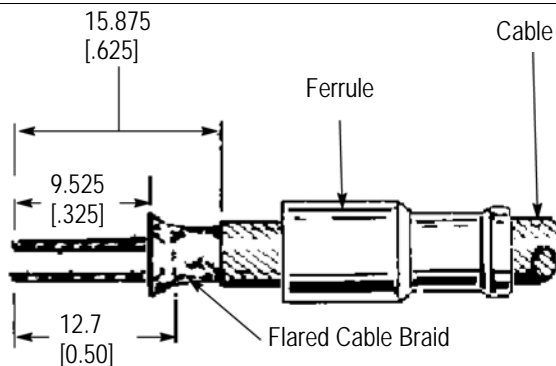


Figure 3

3. Flare the cable braid, but do NOT comb the braid.
4. Hold the ferrule in place and insert the stripped conductors into the center contacts on the crimp end. See Figure 4.

The braid passes over and around the support sleeve. See Figure 5.

5. Push the crimp end back under the braid. Apply sufficient pressure to cause the cable dielectric to bottom against the dielectric of the crimp end. Twist the crimp end slightly to ensure bottoming.

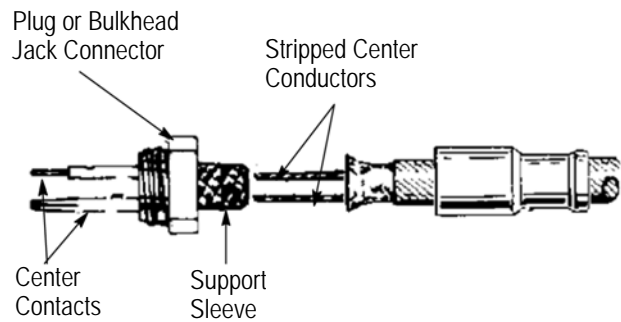


Figure 4

The Flared Braid Passes Over and Around the Support Sleeve

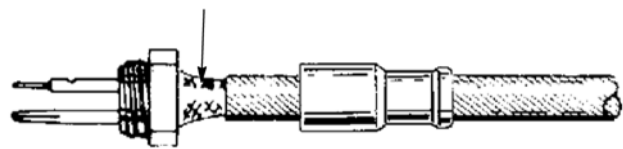
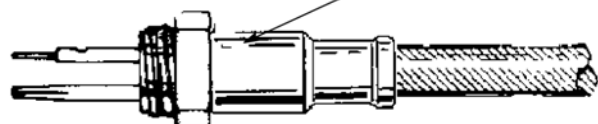


Figure 5

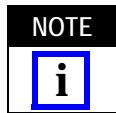
6. Slide the ferrule forward and over the support sleeve on the crimp end as far as it will go. The crimp end is now ready to be crimped. Refer to Figure 6.

Push the Ferrule Over the Braid. Ferrule Bottoms Against the Shoulder.



*The Assembly is Now Ready to be Crimped.*

Figure 6



*Refer to the instructions packaged with the crimp die assemblies for specific information on crimping procedures.*

### 4. ASSEMBLY PROCEDURE

The following is a general assembly procedure for the Twin BNC COAXICON connectors covered by this instruction sheet.

#### 4.1. BNC Plug Connector Assembly (Figure 7)

1. To begin assembling the plug, slide the seal over the contacts.

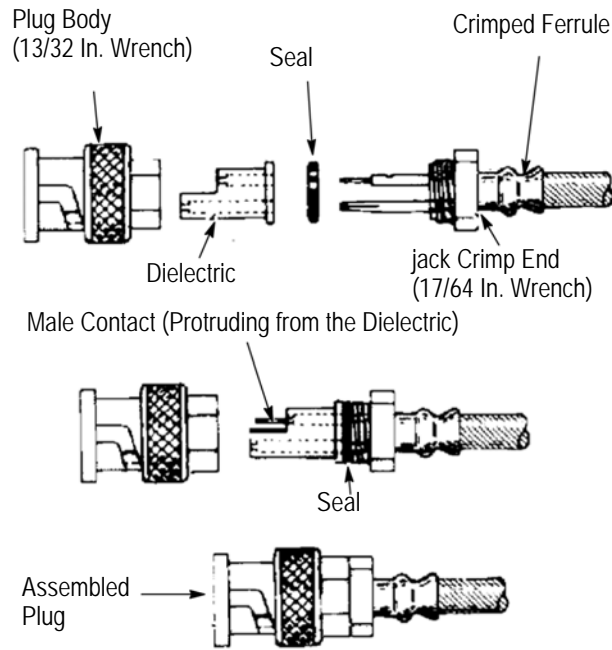


Figure 7

2. Insert the contacts into the dielectric, making sure that the male contact is allowed to protrude as shown in Figure 7.
3. Thread the body onto the crimp end.
4. Tighten the components by using a wrench on the flats. A torque of 15 to 20 inch-pounds is recommended.

**NOTE** Use a 0.266 inch (17/64 inch) wrench

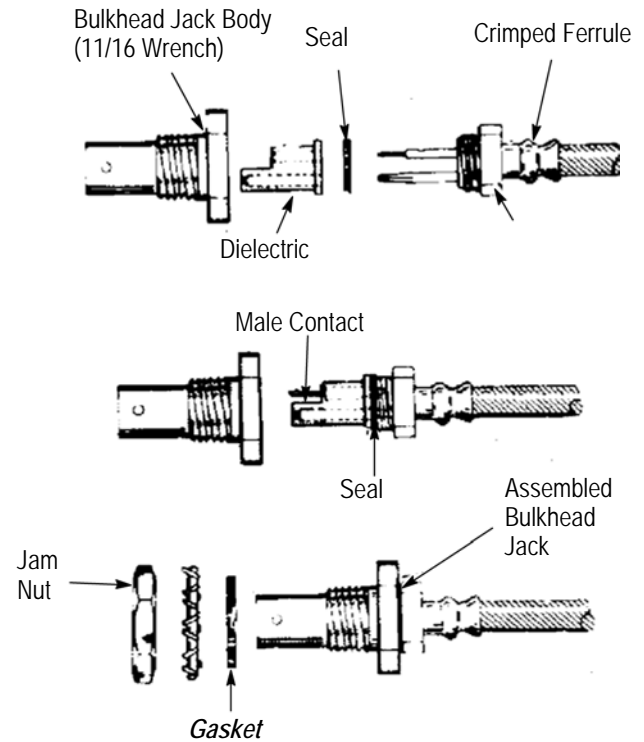


Figure 8

This completes the plug assembly procedure.

#### 4.2. Bulkhead Jack Connector Assembly (Figure 8)

To assemble the bulkhead jack:

1. Slide the seal over the contacts.
2. Insert the contacts into the dielectric, making sure that the male contact is permitted to protrude. See Figure 8.
3. Thread the body unto the crimp end.
4. Tighten the components using a wrench on the flats of the jack. A torque of 15 to 20 inch-pounds is recommended.
5. Slide the gasket over the jack body and into the groove.
6. If the panel has not already been cut, cut it to the dimensions in Figure 9.

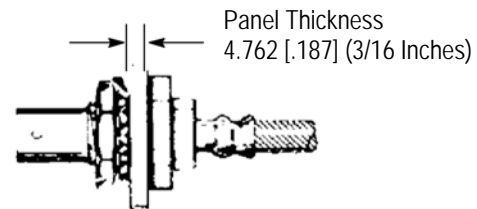


Figure 9

7. Insert the bulkhead jack through the hole in the panel.
8. Assemble the lock washer and jam nut to the bulkhead jack to complete the assembly.

### 4.3. Bulkhead Jack Adapter

Use the adapters as required in either free-hanging or panel mounted applications.

1. The bulkhead jack adapter can be mounted to the panel using the cutout shown in Figure 10.

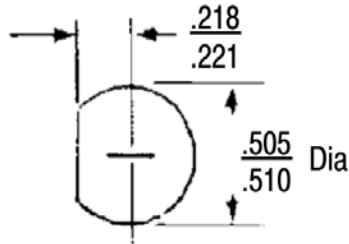


Figure 10

2. Assemble the gasket over the body and into the groove provided.
3. Insert the bulkhead jack adapter through the hole in the panel. See Figure 10.
4. Assemble the lock washer and jam nut to complete the assembly. See Figure 11.

### 4.4. Plug and Jack Coupling

The following procedure will be required to provide proper alignment of the dielectric in the plug and panel or bulkhead jack when coupling the two parts.

1. Align the slots in the plug collar with the lugs on the jack. See Figure 12.
2. Push the plug over the jack until the ends of the dielectric butt.

Bulkhead Jack Adapter  
(11/16 In. Wrench)

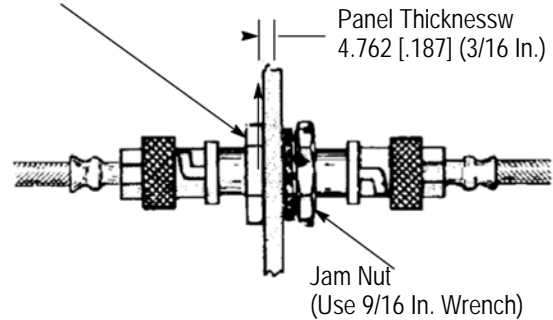


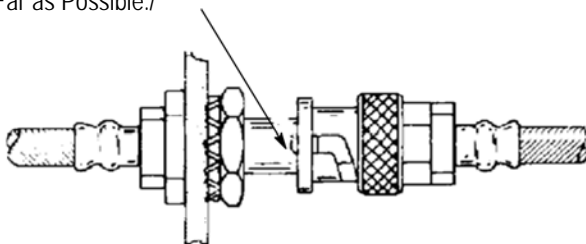
Figure 11

3. In a certain number of connectors, the dielectric will already be properly aligned and permitting the collar to be pushed over the jack and into the lock position.
4. For those connectors with misaligned dielectric, grasp the rear of the plug over the flats and twist the plug while applying slight pressure.
5. As the dielectric comes into alignment, the collar will be allowed to slide forward over the lugs and into the locked position.

### 5. REVISION SUMMARY

Since the previous release of this document, the new company logo has been applied.

Align the Slots in the Plug Collar with the Lugs on the Jack. Push the Plug forward as Far as Possible./



Grasp the Plug Over the Flats and Twist While Applying Pressure. When the Dielectric Becomes Aligned, the Plug Can Be Locked Into Position.

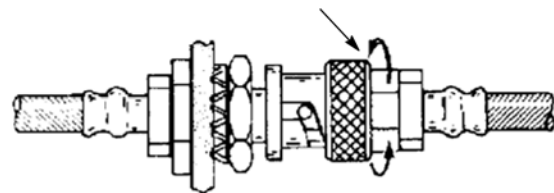


Figure 12