

AMP

AMP INCORPORATED
HARRISBURG, PA 17105

AMP*

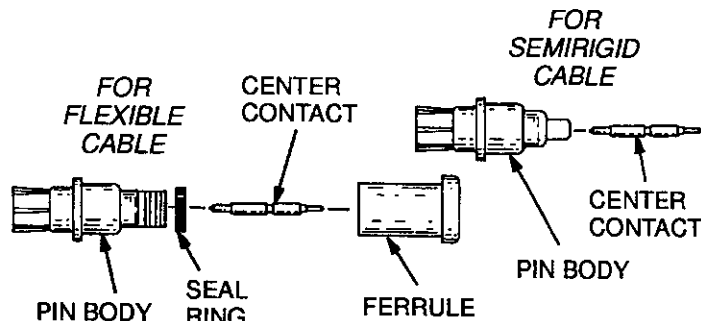
**SIZE 1 COAXIAL CONNECTORS
FOR ARINC CONNECTOR APPLICATIONS**

IS 2348-2

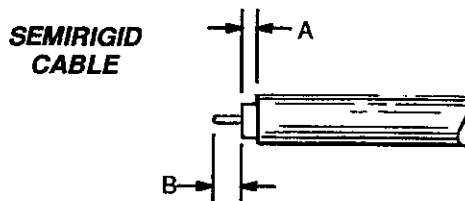
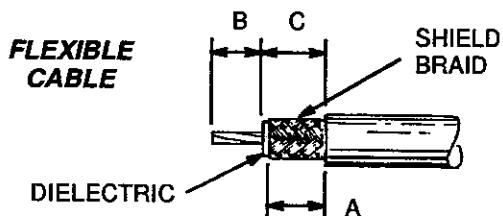
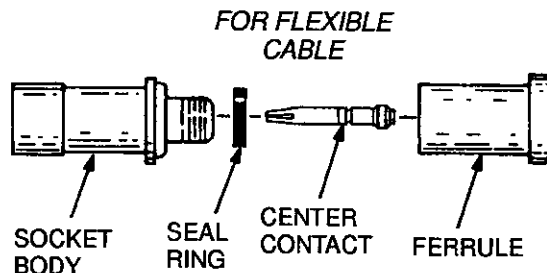
TOOLING ASSISTANCE 1 800 722-1111
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RELEASED
6-25-92

PIN ASSEMBLIES



SOCKET ASSEMBLIES



CONNECTORS		CABLE				CENTER CONTACT CRIMPING TOOL		FERRULE CRIMPING TOOL	TOOLING INSTRUCTION SHEET
PART NO.	TYPE	TYPE	STRIP DIM. mm [in.]			TOOL	POSITIONER		
			A	B	C				
225837-1	PIN	3.58 mm [.141 in.] DIA SEMIRIGID	1.98 [.078]	4.74 [.187]	---	M22520/2-01*	K350*	220066-1 (DIE B)	IS 2347
								220066-2 (DIE B)	IS 6692
225831-1	SOCKET	RG-214	12.7 [.500]	4.74 [.187]	12.7 [.500]	220015-1	---	220015-1	IS 2331
225831-3	SOCKET	RG-142 RG-142A RG-142B	8.73 [.344]	4.74 [.187]	10.31 [.406]	220045-2	---	220045-2	IS 2336
225831-4	SOCKET	RG-225	12.7 [.500]	4.74 [.187]	12.7 [.500]	220015-1	---	220015-1	IS 2331
225831-5	SOCKET	FILECA F1703-63	7.92 [.312]	4.74 [.187]	11.09 [.437]	220045-2	---	220045-2	IS 2336
225831-6	SOCKET	RG-393	12.7 [.500]	4.74 [.187]	12.7 [.500]	220015-1	---	220015-1	IS 2331

* M22520/2-01 TOOL AND K350 POSITIONER CAN BE ORDERED FROM: DANIELS MANUFACTURING COMPANY, BLOOMFIELD HILLS, MI 48013

Fig. 1

73-111A

1. INTRODUCTION

This Instruction Sheet (IS) covers AMP Size 1 coaxial connectors (pin and socket assemblies) listed in Figure 1, which can be used in any ARINC 404 (IS 7482), ARINC 600 (IS 6762), or MIL-C-81659 connector containing an insert for Size 1 coaxial connectors. For information on the

use of tooling, see the AMP Instruction Sheet supplied with the tooling, as listed in Figure 1.

NOTE

All dimensions are in metric units [with inch equivalents in brackets].

2. ASSEMBLING CONNECTORS

A. Semirigid Cable

1. Strip the cable to the dimensions shown in Figure 1.
2. Crimp the center contact to the cable conductor using the tool listed in Figure 1.
3. Seat the crimped center contact in the body, then crimp the back shell with the tool listed in Figure 1.

B. Flexible Cable

1. Slide the ferrule onto the cable. Strip the cable to the dimensions shown in Figure 1.
2. Crimp the center contact to the cable conductor using the tool listed in Figure 1.
3. Slide the seal ring onto the back shell until it bottoms on the shoulder of the body.

4. Flare the shield slightly so it will go OVER the back shell and not into it.

5. Insert the crimped contact into the body until the dielectric bottoms on the back shell.

6. Make sure the braid is spread evenly over the back shell, then slide the ferrule forward until it butts against the body.

7. Crimp the ferrule using the hand tool listed in Figure 1.

3. CUSTOMER SERVICE

To order AMP products, please contact your customer service representative through normal channels, or call 1 800 525-5142 or send a facsimile of your purchase order to 1 717 986-7605. You may also mail your order to:

CUSTOMER SERVICE (38-35)
AMP INCORPORATED
P.O. BOX 3608
HARRISBURG, PA 17105-3608