

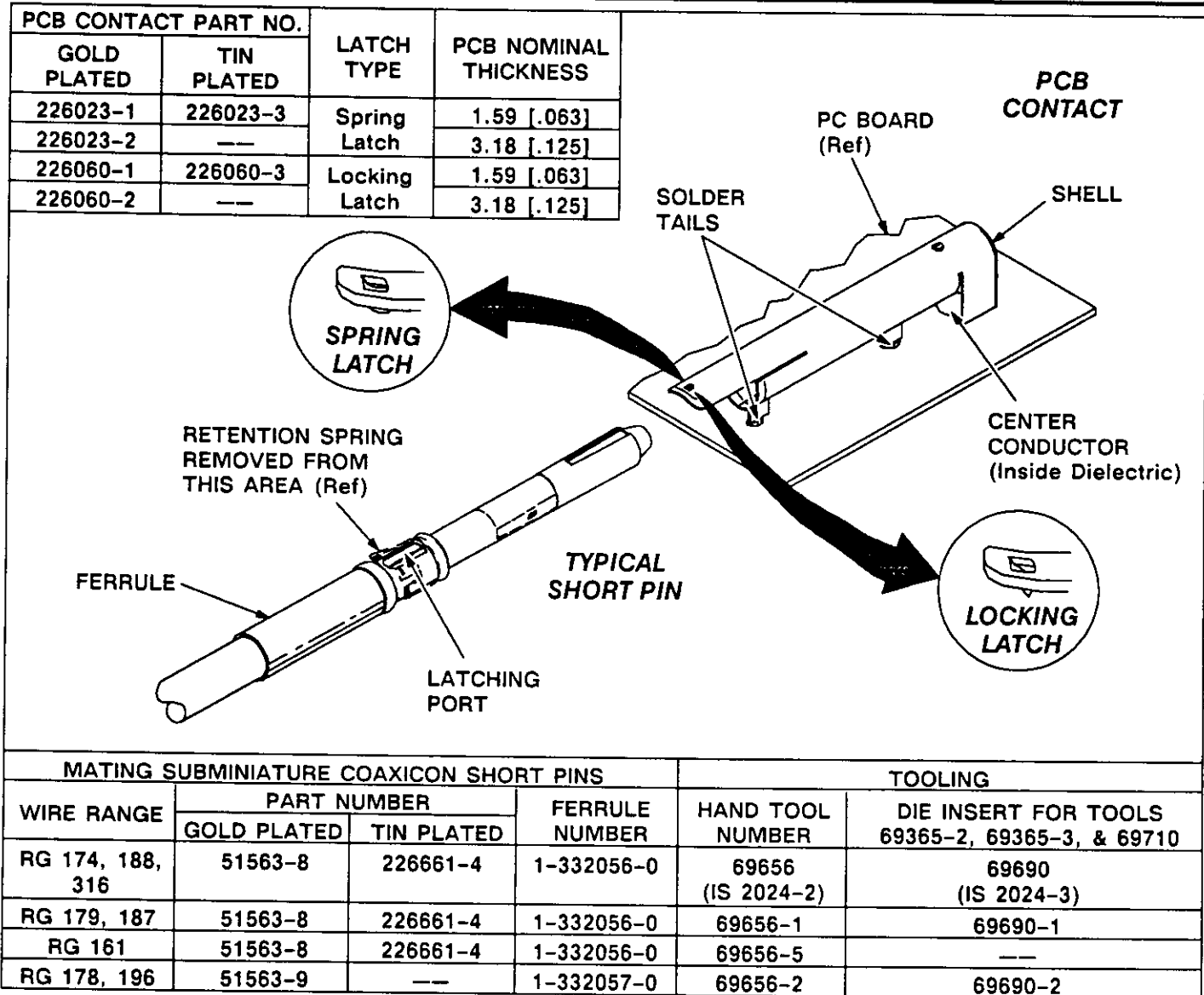
**AMP**AMP INCORPORATED  
HARRISBURG, PA 17106AMP\*  
SUBMINIATURE  
COAXICON\* PCB CONTACTS**IS 2430**CUSTOMER HOTLINE  
1 800 722-1111RELEASED  
7-1-91

Fig. 1

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**1. INTRODUCTION**

This instruction sheet (IS) covers the placement of AMP Subminiature COAXICON Printed Circuit Board (PCB) Contacts. How to prepare the board, and how to mate and unmate free-hanging pins to the contacts are also discussed.

Read these instructions carefully before starting any work.

**NOTE**

Dimensions are in millimeters [with inches in brackets].

**2. DESCRIPTION (Figure 1)**

The contacts and their center conductors are brass per MIL-C-50 and QQ-B-626. The shell is plated with  $3.81\mu$  [150 mil] tin lead per ASTM-B-571. The center conductor is plated with  $0.76\mu$  [30 mil] gold per MIL-G-45204 over copper per MIL-C-14550, and surrounded by a glass-filled polyester dielectric.

Any pcb contact listed in Figure 1 will accept any Subminiature COAXICON Short Pin. The pins listed do not have retention springs and are specifically intended for mating with the pcb contacts. Other available short pins will mate only if you first remove their retention springs.

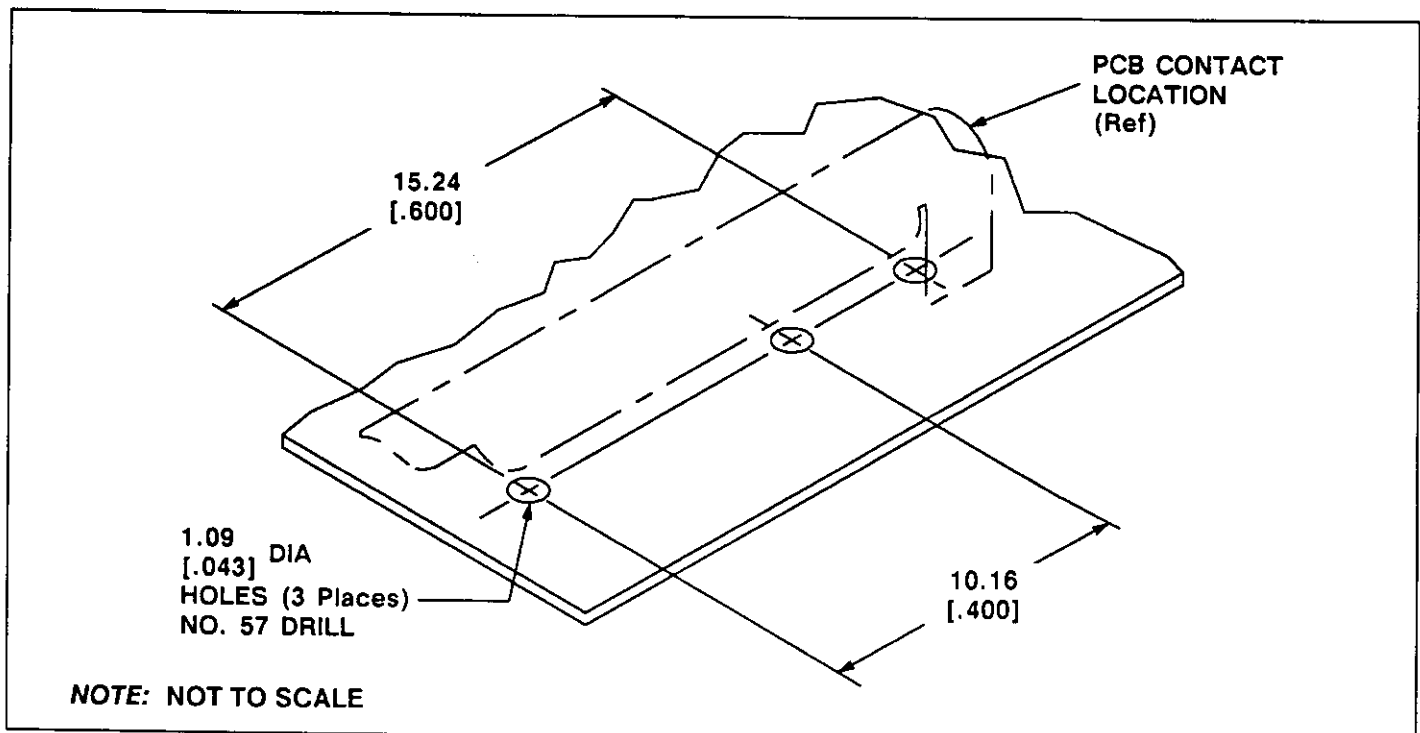


Fig. 2

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### 3. PREPARING BOARD

Board thicknesses are listed for the pcb contacts in the table in Figure 1. Figure 2 shows the hole layout and dimensions. After drilling board and seating contact, solder contact tails and center conductor according your company specifications.

If no specifications are available, ask your AMP representative for AMP Corporate Bulletin No. 52. This document outlines recommended soldering techniques and contains problem-solving information to aid in soldering.

#### CAUTION

*Avoid damage to mating pins or crimped wires: solder only UNMATED pcb contacts.*

### 4. MATING SHORT PIN

#### A. Preparing and Inserting Pin

1. Before crimping, be sure pin has no retaining spring. If there is one, it must be removed before continuing.
2. Crimp pin and ferrule according to the instructions packaged with the tooling or product. Hand tools with integral dies will include IS 2024-2; tools using die inserts will include IS 2024-3.
3. Align one of the two latching ports on the pin to the latching feature of the pcb contact. This is especially important for contacts with locking latches. Insert pin until it latches.

#### B. Removing Pin

1. Rotate pin approximately 1/8 turn either direction from the pcb contact latching port. This step is especially important for contacts with locking latches; the rotation disengages the latch.
2. Pull pin straight out of contact. Use a slight rotating motion if necessary to free pin.