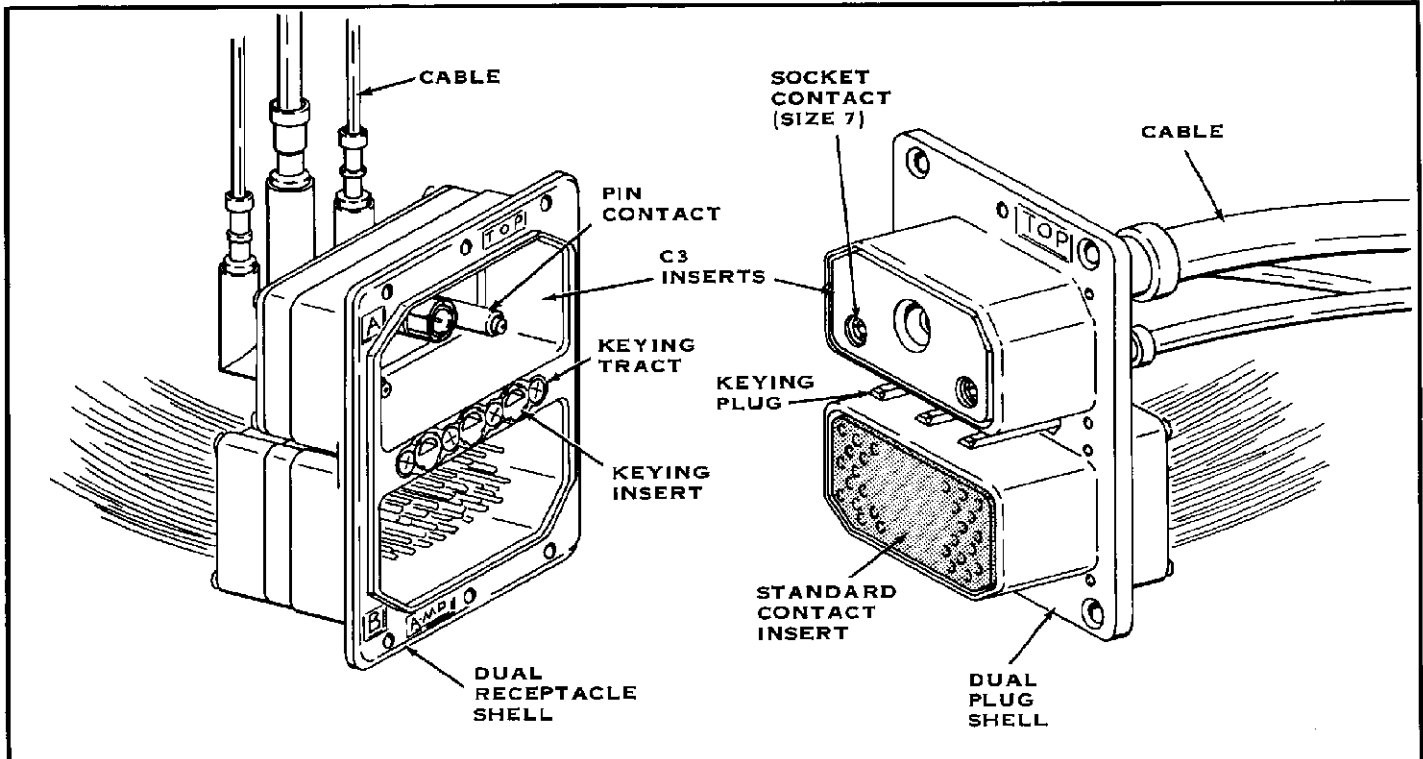




A-MP ★ RM AND RME SERIES CONNECTORS
WITH
SIZES 3 AND 7 COAXIAL CONTACTS

IS 7541	
RELEASED	4-3-72
REVISED	



CONNECTOR SERIES	INSERT TYPE	CONTACT			RG CABLE	CENTER CONTACT CRIMPING TOOL		FERRULE CRIMPING TOOL
		SIZE	TYPE	NUMBER		TOOL	POS.	
RM AND RME	CAPTIVE	3	Socket	225792-1	214	220015-1	—	220015-1
			Pin	225803-1	142, 142A, 142B	601966-1	1-601966-8	220066-1
		7	Socket	225796-1	58C	601966-1	1-601966-7	220066-1
			Pin	225814-1	188	601966-1	1-601966-7	220066-1

FIGURE 1

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1. INTRODUCTION

These instructions cover the recommended procedures for installing A-MP sizes 3 and 7 Coaxial Contacts in the A-MP RM and RME Series, ARINC Type, Rack and Panel Connectors. Read this material thoroughly before assembling these connectors.

2. DESCRIPTION

These C3 Captive Inserts prevent stresses caused by large cable from inadvertently releasing the contacts. Each Insert Assembly accepts one Size 3 and two Size 7 contacts.

The Pin Contacts and the applicable Inserts must be installed in the Receptacle Shell. The Socket Contacts and the applicable Inserts must be installed in the Plug Shell. See Figure 1.

Refer to the A-MP Instruction Sheet, IS 7482, for the Panel Cutout Dimensions, Keying Plug Arrangements and various other RM and RME Series Contact Inserts that are available.

3. INSTALLING SOCKET CONTACTS

To ease assembly, we recommend that you assemble the Rear Insert Assembly before crimping the Size 3 Contact.

Select the Plug Shell specified for your application and proceed as follows:

1. Insert the Size 3 Socket Body into the Rear Insert. Position this assembly on a horizontal support with the back of the contact resting on the support.
2. Slide the Retaining Spring over the Front of the Contact. Then, using a suitable tool, spread the Retaining Ring and slide it over the Shoulder of the Contact. Release the Ring — *make sure it is properly seated before continuing.*
3. Slide the Retaining Plate over the cable for the Size 3 Socket Contact. Then slide the Ferrule over the unstripped cable.

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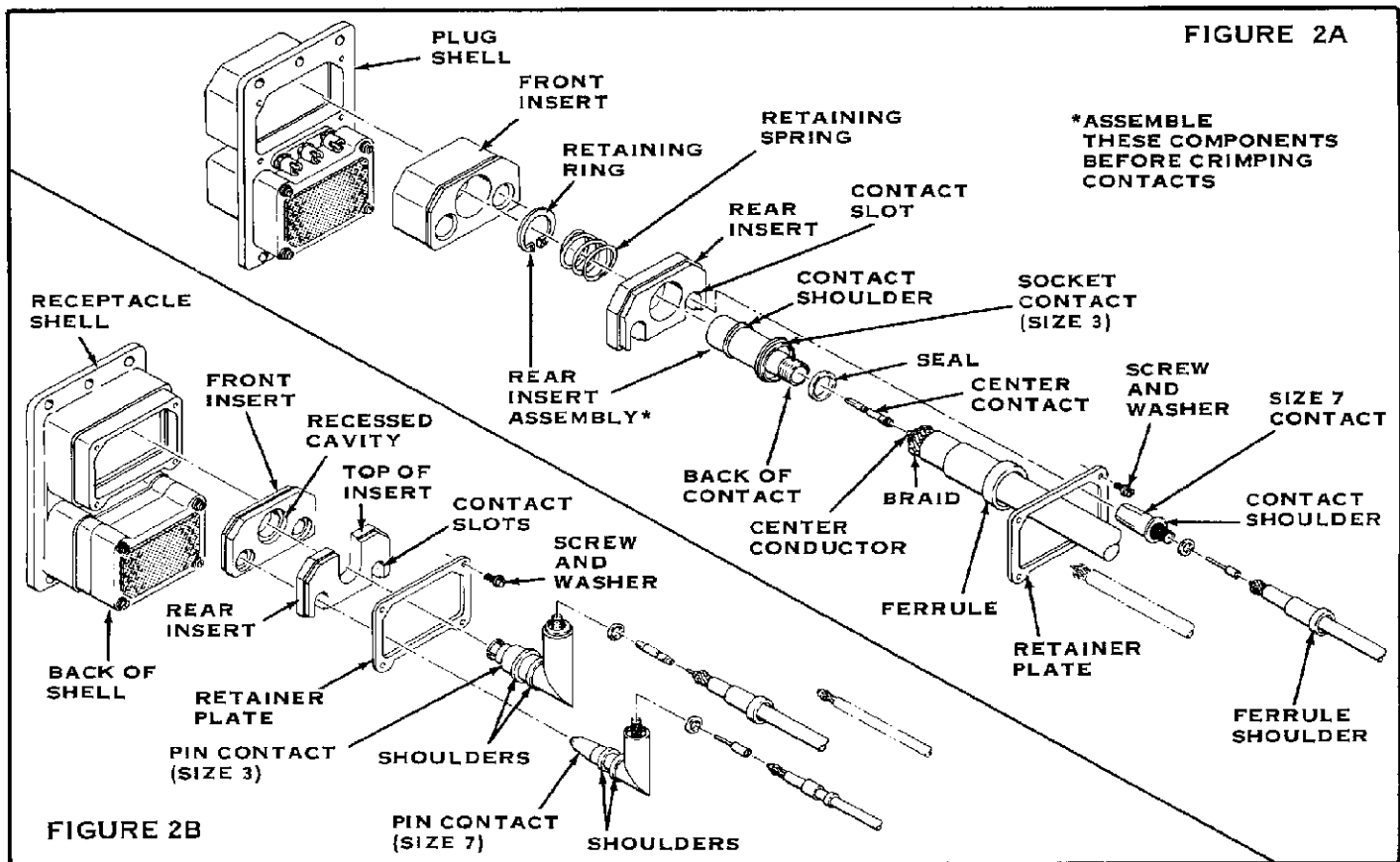


FIGURE 2

4. Strip the cable and crimp the Size 3 Socket Contact according to the procedures described on Instruction Sheet IS 2348-1. *When crimping make certain the Rear Insert is against the tool Side Plate and the cable exits the Cable Side of the tool.*
 5. Now slide the Ferrules for the Size 7 Contacts over the applicable cable. Strip the cable and crimp the contacts according to Instruction Sheet IS 2348-1.
 6. Insert the Size 7 Contacts through the Retainer Plate and position them in the Rear Insert Slots. Make sure the Insert is positioned on the Ferrule between the Contact Shoulder and Ferrule Shoulder as indicated in Figure 2A.
 7. Align the contacts with the holes in the Front Insert. Insert the contacts until the Rear Insert seats on the Front Insert.
 8. Insert this assembly into the back of the Plug Shell until it bottoms. Slide the Retainer Plate over the cables and position it on the Rear Insert. Make sure the Plate is flat against the Shell then secure it with the 4 screws and washers supplied with the connector.
- 4. INSTALLING PIN CONTACTS**
Select the Receptacle Shell specified for your application and proceed as follows:
1. Determine the size of the cable that you are using then refer to the chart in Figure 1 and select the applicable contact.
 2. Slide the Ferrule(s) over the unstripped cable(s). Then strip the cable(s) and crimp the contact(s) according to the procedures described on Instruction Sheet IS 2348-1.
 3. Slide the Retainer Plate over the crimped contacts.
 4. Turn the cables toward the TOP of the Insert. Position the contacts in the Rear Insert Slots. Make sure the Insert is positioned between the Front and Back Shoulders of the contacts.
 5. Align the contacts with the Recessed Cavities in the back of the Front Insert. Insert the contacts until the Rear Insert bottoms on the Front Insert.
 6. Insert this assembly into the Back of the Receptacle Shell until it seats in the Shell.
 7. Slide the Retainer Plate into position and secure it with the 4 screws and washers supplied with the Shell.