

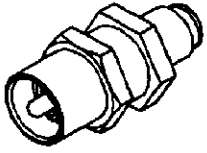
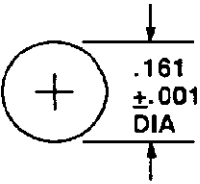
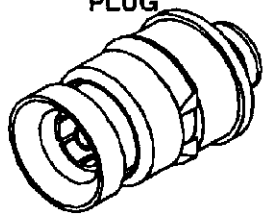
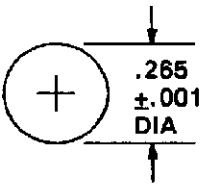
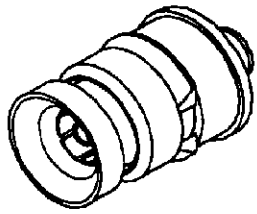
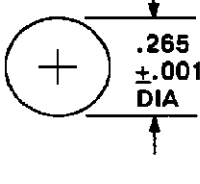
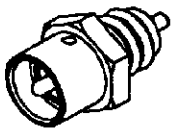
AMP

REDUCED FOR PACKAGING

AMP INCORPORATED
HARRISBURG, PA 17105AMP* BLIND MATE 2.8mm CONNECTORS
FOR SEMI-RIGID**IS 9473**CUSTOMER HOTLINE
1 800 722-1111

.086-IN. AND .047-IN. COAXIAL CABLE

RELEASED
1-4-91

CONNECTOR TYPE		PANEL MOUNT SPECIFICATIONS		TOOLING			
DESCRIPTION	PART NUMBER		RECMD PANEL THKNS	RECOMMENDED MOUNTING HOLE	LOCATORS*	CABLE PREP ACCES	HAND TOOL
	FOR .086-IN. CABLE	FOR .047-IN. CABLE					
 BULKHEAD JACK	---	413024-1	.078 ±.002		314238-1	314250-1† 312253-2◆ DIE SET	59980-1 ↓
 FLOATING SNAP-IN PLUG	413012-1	---	.093 ±.002		314237-1	314240-1† 312317-1◆ TRIMMER TOOL	
 FLOATING SNAP-IN PLUG	---	413025-1	.093 ±.002		↓	314239-1† 311396-1◆ CABLE DRESSING FIXTURE	
 SCREW-IN JACK LAUNCHER 413020-1	---	---	.085 ±.002	Tapped Hole 6-40 UNF-2B	---	314243-1† 311395-1◆ CABLE CUTOFF FIXTURE	

† USED WITH .047-IN. CABLE — MUST BE ORDERED SEPARATELY

◆ USED WITH .086-IN. CABLE — COMPONENT OF AMP TOOL KIT 59981-1

● MUST BE ORDERED SEPARATELY

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the selection and assembly of AMP Blind Mate 2.8mm connectors for semi-rigid .086-in. outer diameter (OD) and .047-in. OD coaxial cable. The connectors are terminated to coaxial cable by AMP Hand Crimping Tool 59980-1.

For specific information concerning tool setup procedures, cable preparation, and crimping procedures, refer to IS 6788 packaged with the hand tool. Read these instructions thoroughly before proceeding.

NOTE

All dimensions on this instruction sheet are in inches.

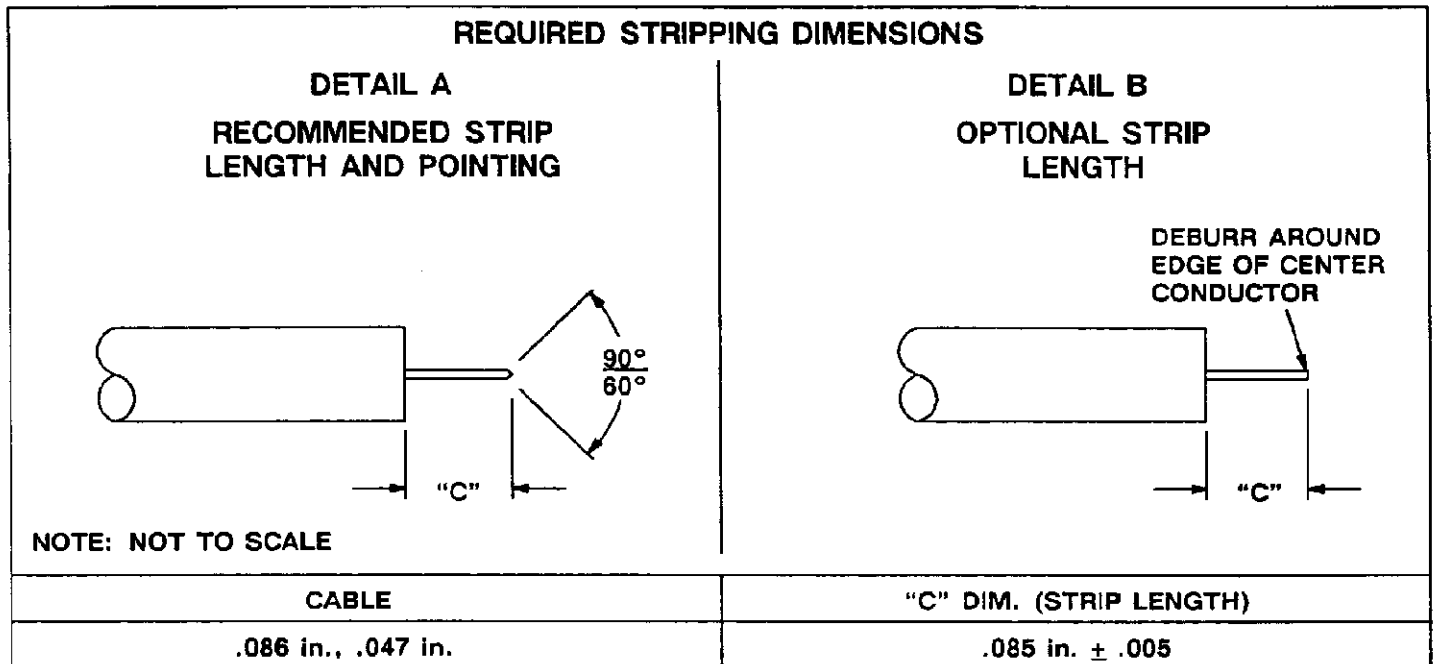


Fig. 2

2. DESCRIPTION

AMP Blind Mate 2.8mm Connectors are high-performance coaxial connectors that provide module pluggability. Connector configurations include bulkhead jacks, snap-in plugs, and jack launchers.

Hand tool 59980-1 accepts AMP interchangeable die assemblies 312253-2 and 314250-1. Die assembly 312253-2 is used to crimp .086-in. cable and die assembly 314250-1 is used to crimp .047-in. cable. Tool locators are also required when crimping Blind Mate connectors. Locator 314238-1 is used for bulkhead jack connectors, and 314237-1 is used for plug connectors.

Cable preparation tools (listed in Figure 1) are used to ensure proper strip-length dimensions and pointing. The tools are marked to distinguish the area designed for .086-in. cable or .047-in. cable.

For the selection of appropriate tooling accessories, refer to Figure 1.

NOTE *Tooling accessories used to crimp .047-in. cable assemblies must be ordered separately, along with the locators.*

3. ASSEMBLY AND CRIMPING PROCEDURES (Figures 3 and 4)

AMP recommends that the cable preparation accessories (listed in Figure 1) be used to prepare cable for crimping. For detailed information on tool

set-up procedures, cable preparation, and crimping procedures, refer to IS 6788.

1. Strip cable according to the dimension shown in Figure 2, Detail A. To ensure a sound connection, cable should be pointed.

NOTE *Correct use of cable preparation tools (cutoff fixtures, dressing fixtures, and trimming tools) will ensure proper strip-length dimensions and pointing.*

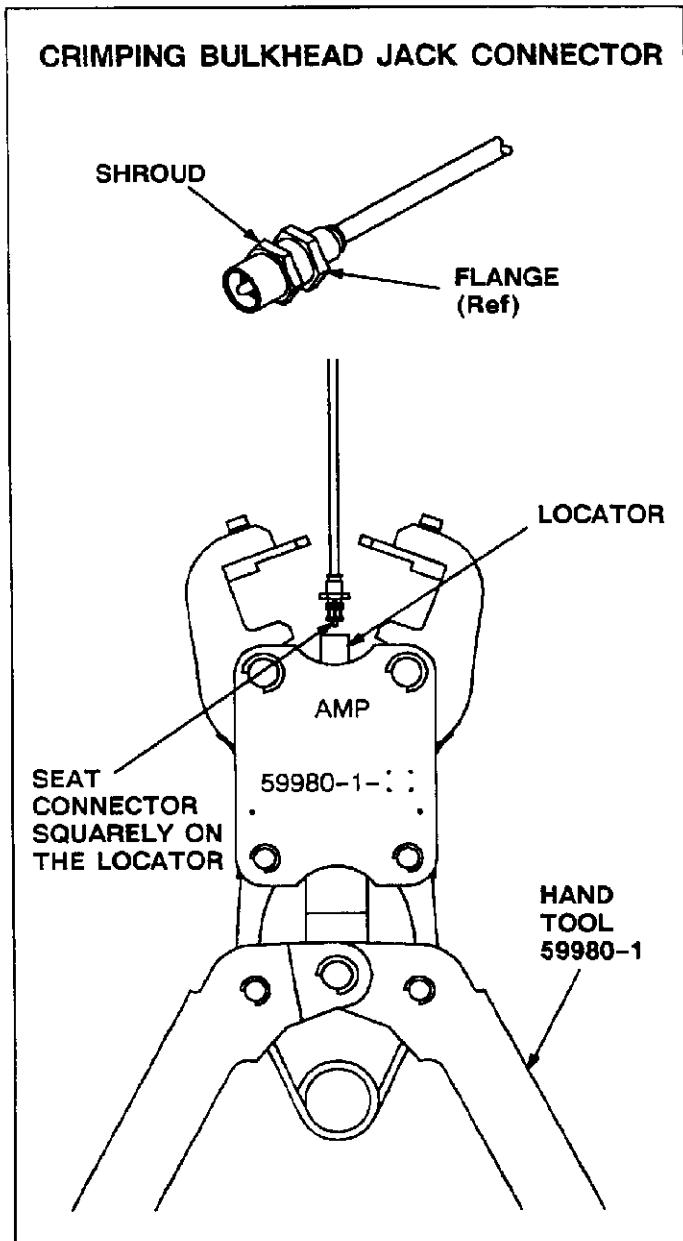
NOTE *If tooling accessories are not used to prepare cable, use optional strip-length dimension provided in Figure 2, Detail B. Deburr around the edge of the center conductor.*

2. Slide appropriate connector onto cable, as shown in Figures 3 and 4. For bulkhead connectors, slide the connector onto the cable with flange-end first. See Figure 3.

NOTE *Before crimping bulkhead jack assemblies, remove the shroud. See Figure 3.*

3. Place connector assembly onto locator of tool, making sure that the locator enters the front of the connector. The connector must be seated squarely on the locator. See Figures 3 and 4.

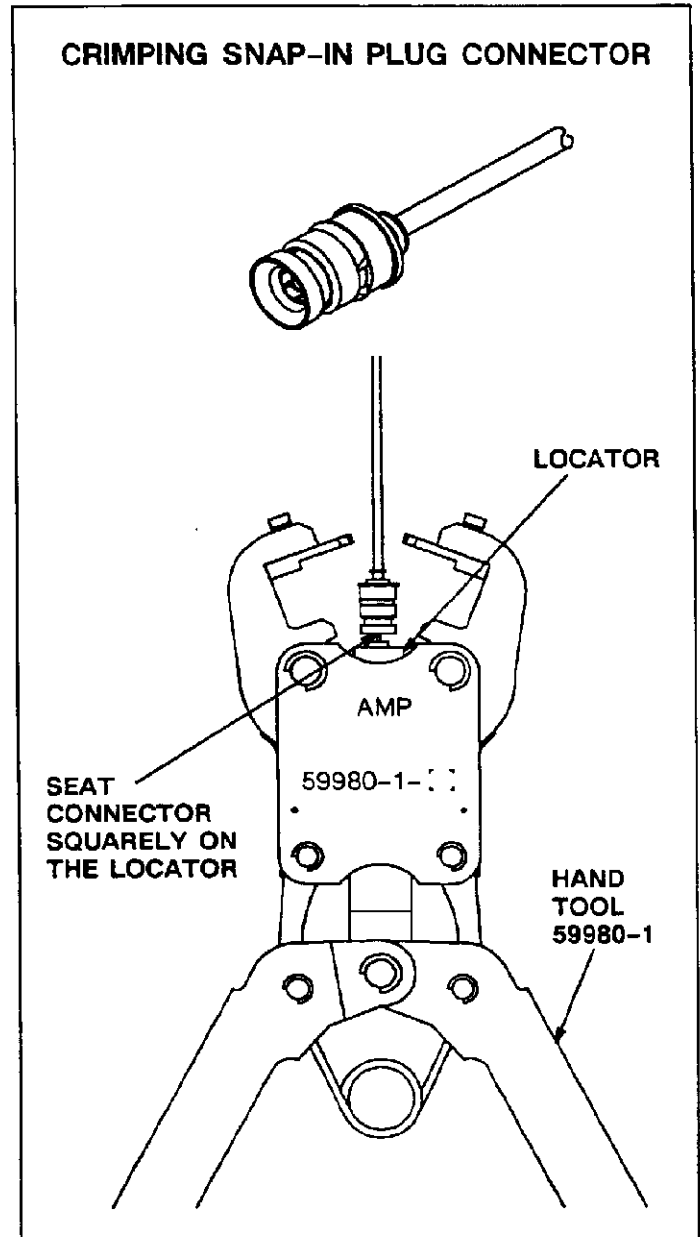
4. To complete the crimp, support connector assembly and squeeze the tool handles together



until the CERTI-CRIMP* ratchet releases. Remove the crimped assembly from the hand tool.

5. Using the recommended mounting hole dimensions provided in Figure 1, make the required panel cutout.

6. Insert the connector assembly through the panel cutout. Snap-in plug connectors are held in place by an integral retention clip. To secure



bulkhead jack connectors to the panel, thread the shroud onto the front of the jack. Recommended tightening torque for bulkhead jack connectors and screw-in jack launchers is 25 to 30 in.-oz.

NOTE

To remove a plug connector from the panel, use AMP Extraction Tool 1-305183-9. Refer to IS 9511.