

RG/U CABLE		CONTACT ASSY			CENTER CONTACT TOOL			FERRULE TOOL		
TYPE	STRIP DIM.	SIZE	TYPE	PART NO.	TOOL NO.	POSITIONER NO.†	SELECTOR/LOCATOR SETTING	TOOL NO.	CRIMP SECT	FERRULE NO.
58C	Fig. 2-A	5	Pin	225790-1	M22520/2-01*	K345	5	220066-1	B	50427-4
58C			Skt	225791-1	M22520/2-01*	K345	5	(IS 2347) or		
141A			Pin	225790-1	220066-2	--	2	220066-2		
141A			Skt	225791-1	220066-2	--	1	(IS 6692)		
223			Pin	225790-2	M22520/2-01*	K345	5			1-329099-1
223			Skt	225791-2	M22520/2-01*	K345	5			
142A, 142B			Pin	225790-2	220066-2	--	2			
142A, 142B			Skt	225791-2		--	1			
.141 Dia Semi-Rigid	Fig. 2-B		Pin	225790-3		--	2			--
.141 Dia Semi-Rigid	Fig. 2-B		Skt	225791-6		--	1			--
180A, 180B, 195A	Fig. 2-A		Pin	225790-4	M22520/2-01*	K345	5			225344-3
180A, 180B, 195A			Skt	225791-8						225344-3
188A, 316			Pin	225790-5				220066-1,	C	2-328666-5
188A, 316			Skt	225791-3				220066-2,		
179, 187A			Pin	225790-6				220009-1‡		
179, 187A			Skt	225791-4						
178A, 178B, 196A	Fig. 2-C		Pin	225790-7				220020-1	--	51744-2
178A, 178B, 196A	Fig. 2-C		Skt	225791-5				(IS 2224)	--	51744-2

\* AMP TOOL 601966-1 IS EQUIVALENT FOR TOOL M22520/2-01 AND POSITIONERS SUPPLIED BY DANIELS MFG. CORP., 2266 FRANKLIN ROAD, BLOOMFIELD HILLS, MICHIGAN 48013. SEE AMP INSTRUCTION SHEET IS 7516.  
† AMP POSITIONER 1-601966-6 IS EQUIVALENT FOR POSITIONER K345.  
‡ AMP HAND CRIMPING TOOL 220009-1 HAS ONE FERRULE CRIMPING SECTION — SEE IS 2329.

**Fig. 1**

**1. INTRODUCTION**

This instruction sheet (IS) covers the use of AMP COAXICON Contacts, Size 5, for ARINC RM and RME Connectors. Read these instructions thoroughly to make certain the selected contacts are compatible with the cable and with the center contact and ferrule tooling.

**NOTE**

All dimensions shown in this instruction sheet are in inches.

**2. DESCRIPTION (Figure 1)**

The pin and socket connector assemblies shown in Figure 1 consist of a center contact and a pin or socket body. Tubing for the cable dielectric and a

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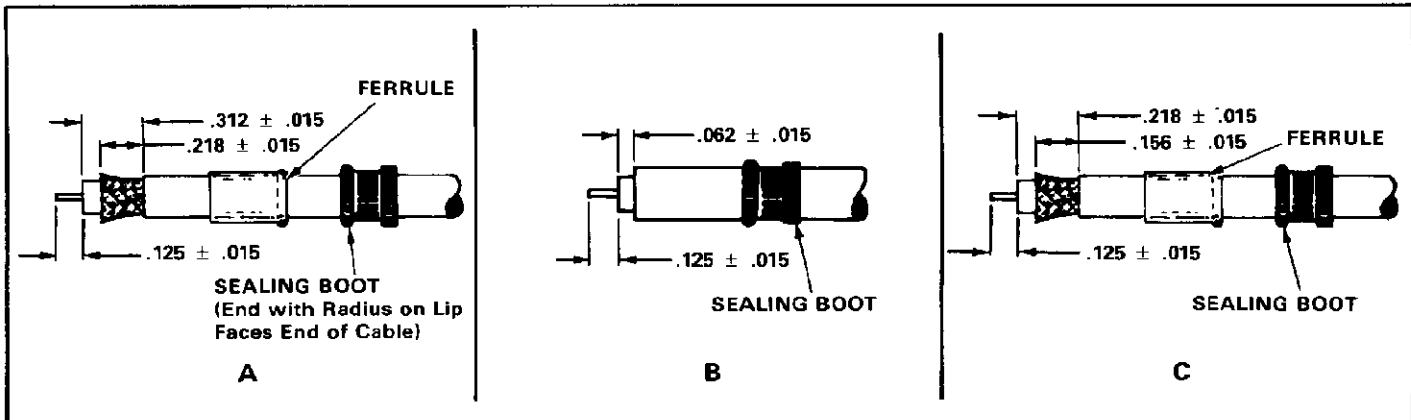


Fig. 2

ferrule for shield braid is also included in some types of connector assemblies.

### 3. CONTACT SETUP PROCEDURE

Determine the cable size to be terminated and refer to the chart in Figure 1 to select the pin and socket connector assembly, center contact crimping tool, ferrule crimping tool, and stripping dimensions of the cable (see Figure 2).

#### NOTE

The 8-indent (M22520/2-01) crimping tool is manufactured by Daniels Manufacturing Corp. Tools and components for AMP products are also stocked by AMP Special Industries (ASI), Berwyn, PA. See chart in Figure 1 for the Daniels and AMP part numbers.

1. Slide components of the connector assembly onto the cable BEFORE stripping the cable.
  - a. When using the RME connector, first slide rubber sealing boot and then slide metal ferrule onto the cable.
  - b. When using the RM connector, slide the metal ferrule onto the cable; the rubber sealing boot is not used.

#### NOTE

When installing the sealing boot over the cable, make sure the end with radius on lip faces the end of cable. See Figure 2.

2. Strip the cable to dimensions referenced in Figure 1 and shown in Figure 2.

#### NOTE

If using braided cable, flare the braid so it will slide easily onto the back of the pin or socket body. Semi-rigid cable does not contain braid and does not require a ferrule.

3. Slip tubing on cable dielectric where applicable. This completes the center-contact setup procedure.

### 4. CRIMPING PROCEDURE

Using either AMP Hand Crimping Tool 601966-1 (IS 7516) or AMP Hand Crimping Tool 220066-2 (IS 6692), proceed as follows:

#### A. Center Contact (Figure 3)

1. Set positioner (or locator) on tool to proper setting (Figure 1). Note that pin contacts and socket contacts require different locator settings on tool 220066-2.
2. Insert center contact into opening of hand crimping tool. Contact will rest on positioner (or locator).
3. Insert stripped conductor into center contact until dielectric butts against center contact.

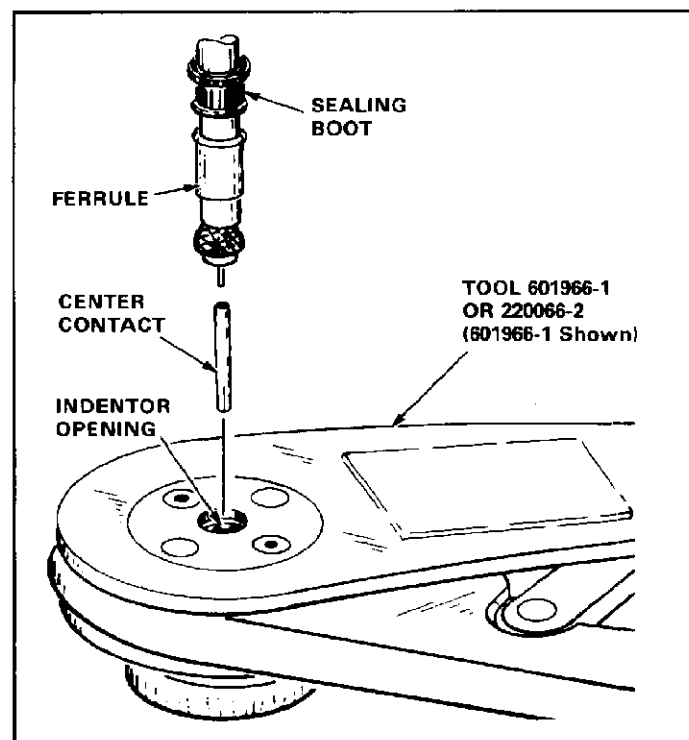


Fig. 3

4. Close handles on crimping tool until ratchet releases allowing handles to open.
5. Remove crimped contact.

### B. Ferrule (Figure 4)

Refer to the chart in Figure 1 and select the appropriate hand crimping tool for crimping the ferrule. The instruction sheet numbers are listed with the tools.

1. Insert the crimped center contact and cable into the appropriate pin or socket body.

**NOTE**

*The cable dielectric should bottom against contact body dielectric, and braid on cable should fit over braid support section of contact body.*

2. Position ferrule over braid and against shoulder on contact body.
3. Place the cable assembly into the crimp section indicated on the chart. Shoulder of contact body should be against tool jaw.

**NOTE**

*Contact assembly for semi-rigid cable should be crimped over rear of contact body.*

4. Crimp the ferrule until the ratchet releases, allowing handles to open.

**NOTE**

*When using RG-223/U cable, relocate uncrimped section of ferrule into appropriate crimp section and crimp the ferrule again over the insulation of cable and end of ferrule.*

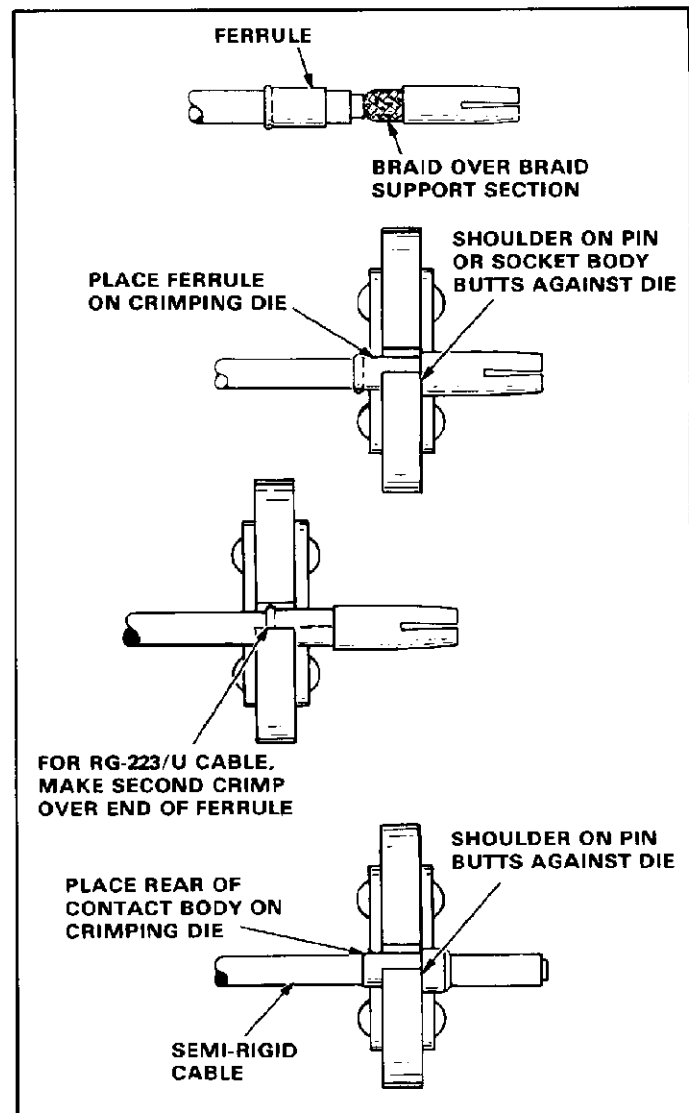


Fig. 4