

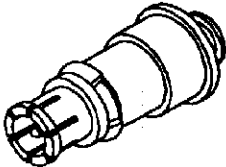
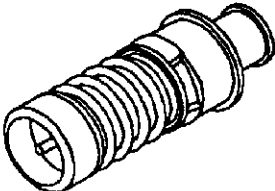
AMPAMP INCORPORATED
HARRISBURG, PA 17105AMP* BLINDMATE 2.8mm CONTACTS
FOR SEMI-RIGID

REDUCED FOR PACKAGING

IS 9585CUSTOMER HOTLINE
1 800 722-1111

.086-IN. COAXIAL CABLE

RELEASED
11-1-90

CONTACT TYPE		TOOLING		
DESCRIPTION	PART NUMBER FOR .086-IN. CABLE	LOCATORS●	CABLE PREP ACCESSORIES†	HAND TOOL††
PLUG 	413242-1	852113-1	312253-2 DIE SET 312317-7 TRIMMER TOOL	59980-1 ↓
JACK 	413249-1	852114-1	311396-1 CABLE DRESSING FIXTURE 311395-1 CABLE CUTOFF FIXTURE	

● MUST BE ORDERED SEPARATELY

† COMPONENTS OF AMP TOOL KIT 59981-1

†† FRAME ONLY-(DOES NOT INCLUDE DIES AND LOCATORS)

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the selection and assembly of AMP blindmate 2.8mm contacts for semi-rigid RG-405 (.086-in.) outer diameter (OD) coaxial cable. See Figure 1. The contacts are crimped to coaxial cable with AMP Hand Tool 59980-1 and are used with AMPLIMITE* Subminiature D Connectors.

For specific product information, refer to AMP Catalogs 79-547 and 80-570, and IS 6788 for cable preparation and crimping procedures. Read this material carefully before assembling any connectors.

NOTE

All dimensions on this instruction sheet are in inches.

2. DESCRIPTION

AMP blindmate 2.8mm contacts are used as coaxial interconnects between plug-in modules and motherboards. Contact configurations include plug and jack assemblies which allow the interconnection of one interface type to another. The contacts are terminated to coaxial cable and then installed into power ports of AMPLIMITE D subminiature connectors.

Hand tool 59980-1 accepts die assembly 312253-2 to crimp .086-in. coaxial cable. Tool locators are also required when crimping blindmate contacts. Locator 852113-1 is used for plug contacts, and 852114-1 is used for jack contacts.

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.

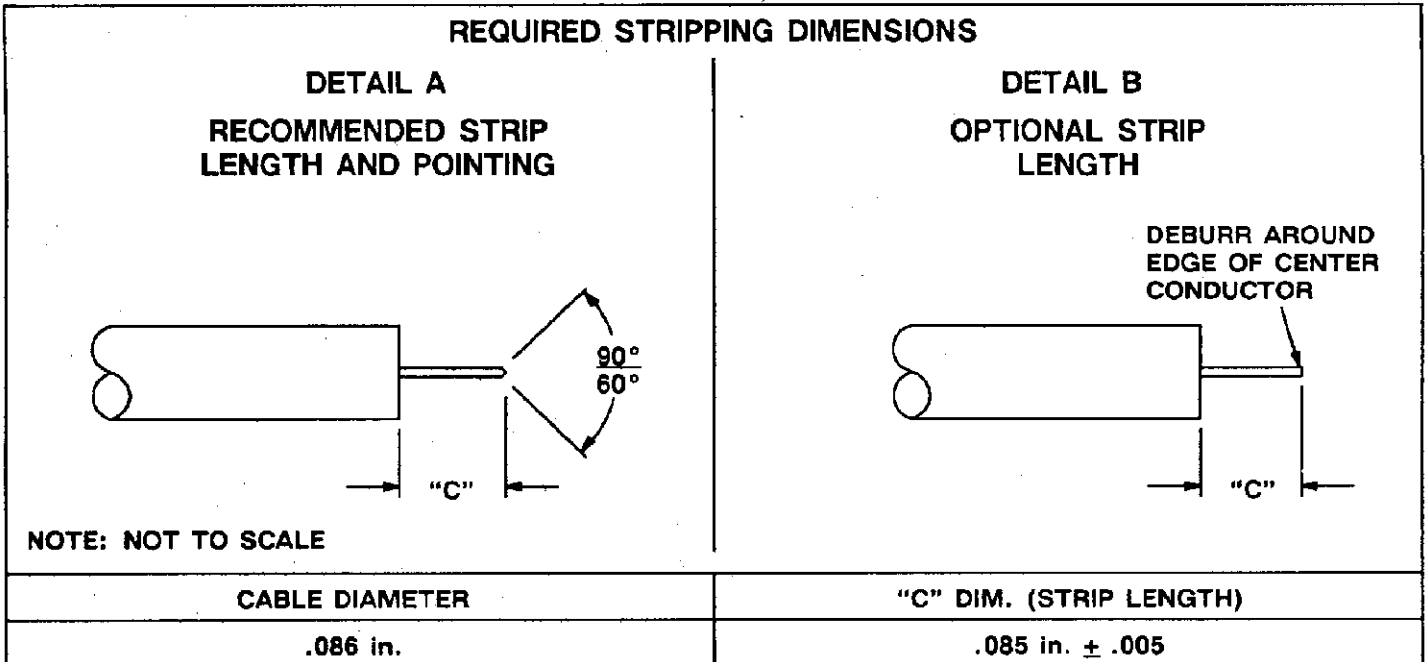


Fig. 2

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

3. ASSEMBLY AND CRIMPING PROCEDURES

It is recommended that the cable preparation accessories (listed in Figure 1) be used to prepare cable for crimping. For detailed information on tool setup procedures, cable preparation, and crimping procedures, refer to IS 6788. Proceed as follows:

- 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 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.

- Select the appropriate contact and locator from the chart in Figure 1. Install the locator in the hand tool according to the tool setup procedures provided in IS 6788.

- Slide contact over cable, grip ring end first. See Figure 3.

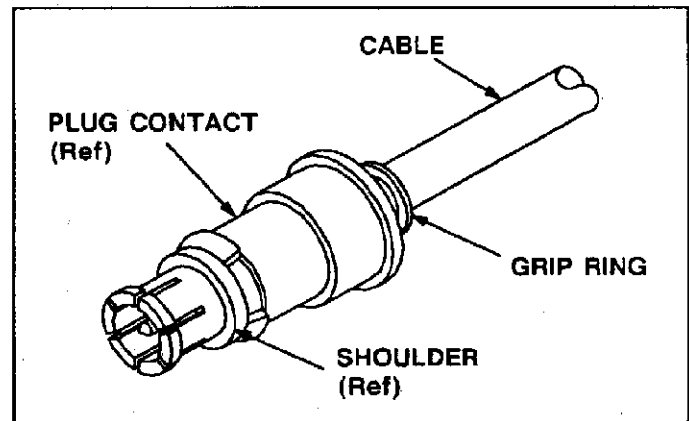


Fig. 3

- Place contact assembly, contact end first, inside locator of tool ensuring that the center conductor or center contact enters the hole of the locator. The contact must be seated squarely on the locator. See Figures 4 and 5.

NOTE When crimping a plug assembly, the plug must go into the locator with the shoulder of the contact resting against the locator. See Figure 5.

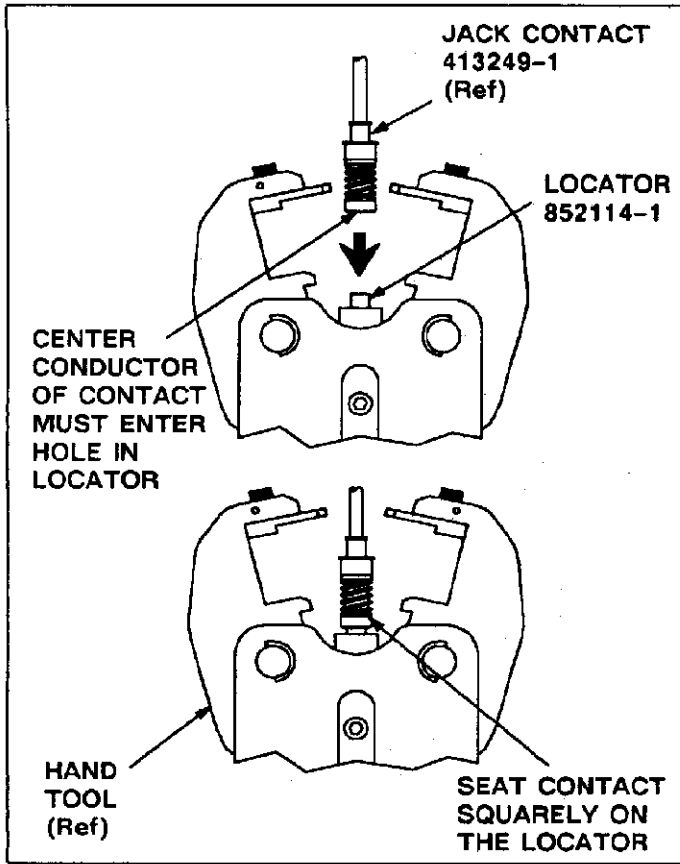


Fig. 4

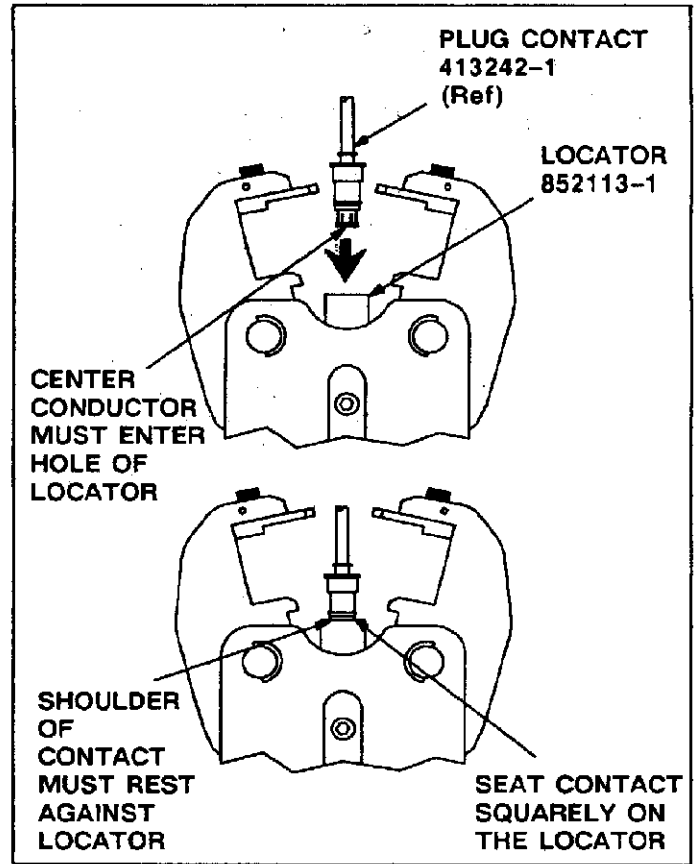


Fig. 5

5. Support contact assembly and squeeze tool handles together to complete the crimp. See Figure 6.

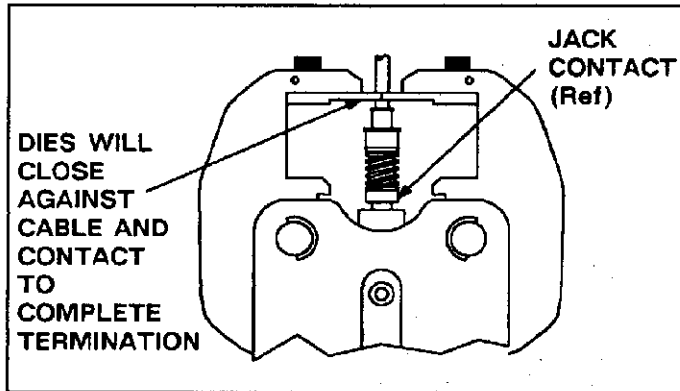


Fig. 6

NOTE CERTI-CRIMP[®] ratchet of tool will NOT release until tool jaws have bottomed.

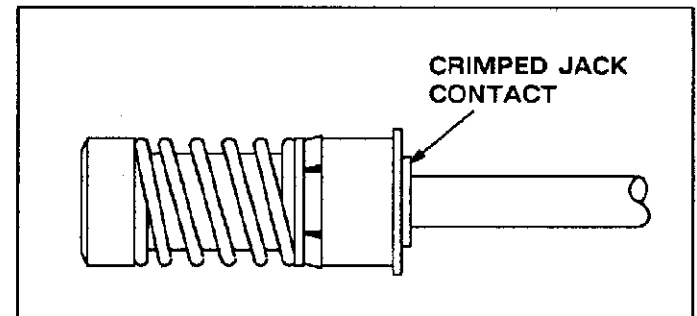


Fig. 7

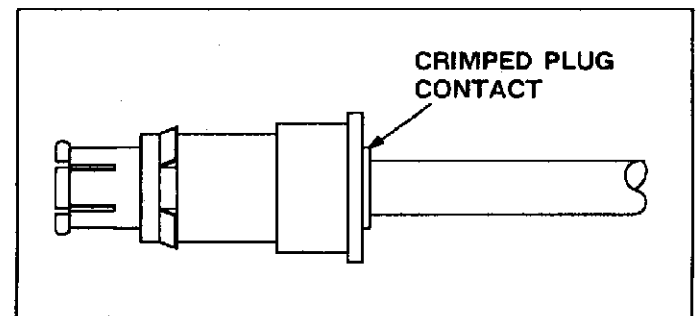


Fig. 8

6. Remove crimped assembly from the hand tool. Properly crimped plug and jack contacts are shown in Figures 7 and 8.

7. Insert the plug or jack contact into the power port cavity from the **back side** of the connector housing. See Figure 9.

NOTE

The plug contact is supplied with a shroud which is used to retain the contact within the connector cavity. The shroud is snapped onto the contact with AMP Insertion Tool 852115-1 after the contact is properly positioned inside the connector cavity. For proper instructions concerning the use of the tool, refer to IS 9582.

AMP Extraction Tool 2-305183-0 is used to remove a plug contact from the connector housing. For information concerning the use of this tool, refer to IS 9581.

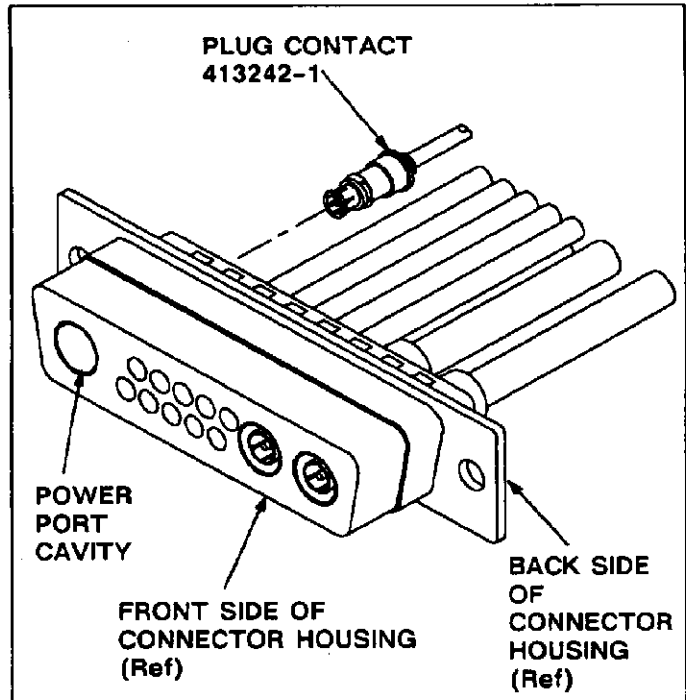


Fig. 9