



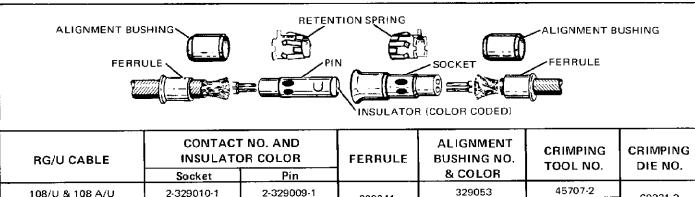
# AMP\* TWIN STANDARD COAXICON\* CONTACTS

IS 1772

RELEASED 1-11-61

REVISED 1-18-74

NOTE: Current production hand tools are identified by the model letter designations shown in Figure 1. See instruction sheet IS 1772-2 for crimping instructions, maintenance and inspection procedures for those tools. See instruction sheet IS 1772-3 for crimping procedure for the interchangeable dies listed.



RG/U CABLE	CONTACT NO. AND INSULATOR COLOR		FERRULE	ALIGNMENT BUSHING NO.	CRIMPING TOOL NO.	CRIMPING DIE NO.
	Socket	Pin Pin		& COLOR		
108/U & 108 A/U	2-329010-1	2-329009-1	329041	329053	45707-2	69231-2
(Ctr. Cond. 7/0126	Yellow	Yellow		Natural (White)	45707-2 MOD. H	
2-3932 Microdot	329055	329054	329056	330576	45707-2	69231-2
2-3934 Microdot	Red	Red		Yellow	45707-2 MOD. H	
Belden 8451, 8641	den 8451, 8641 329010 329009 and 8761 Natural (White) Natural (White) 329056	330576 Yellow	45707-4	69494-1		
and 8761			45707-4 MOD. D			
Belden 8761	2-329010-1	2-329009-1	329041	329053 Natural (White)	45707-2	69231-2
(Alternate to Above)	Yellow	Yellow			45707-2 MOD. H	
Belden 8762	2-329010-1	2-329009-1	2-329009-1	329053	45707-2	60221.2
	Yellow	Yellow 329041	Natural (White)	45707-2 MOD. H	69231-2	
Belden 8737	329010	329009	329041	329053	69731.2	20004.0
(Spiral Wrapped Shld)	Nat⊔ral (White)	Natural (White)		Natural (White)		69231-2
Belden 8737	2-329010-1	2-329009-1	329041	329053	45707-2	69231-2
(Alternate to Above)	Yellow	Yellow		Natural (White)	45707-2 MOD. H	
Belden 8759	2-329010-1	2-329009-1	329041	329053	45707-2	69231-2
	Yellow	Yellow		Natural (White)	45707-2 MOD, H	
Raychem	2-329055-2	2-329054-2	329056	330576	45707-4	69494-1
44/7065-20-9/0-9	Blue	Blue		Yellow	45707-4 MOD. D	

Figure 1

# 1. PREPARATION & ASSEMBLY (Braided Shielded Cable)

### 1.1 CABLE PREPARATION

- (a) Slide braid ferrule, "folded" end first, over cable as shown in Figure 2.
- (b) Strip cable to dimensions specified in Figure 2.

### 1.2 ASSEMBLY PROCEDURE

- (a) Hold cable and rotate conductors to flare braid as shown in Figure 3.
- (b) Insert conductors into contact wire barrel as far as they will go. Braid passes over and around support sleeve on contact. See Figure 3.
  - NOTE: Contacts have numbers 1 and 2 formed on ends of inner insulator. This feature permits polarization of conductors. Wire barrel crimping ports of corresponding size can also be used for this purpose. See Figure 3.
- (c) Slide braid ferrule forward and over braid until ferrule is even with shoulder on contact. See Figure 3. DO NOT PUSH END OF FERRULE PAST THE SHOUL-DER OF CONTACT.
- (d) Assembly is ready to be crimped.

# "FOLDED" END OF BRAID FERRULE 1/4" CONDUCTOR INSULATION OUTER JACKET BRAID 1/4" TWIN CONDUCTORS

- 1. SLIDE FERRULE, FOLDED END FIRST, ON CABLE.
- STRIP OUTER JACKET FROM CABLE EXPOSING 7/16" OF BRAID.
- TRIM 3/16" FROM END OF BRAID, THEN FLARE BRAID.
- 4. STRIP CABLE, EXPOSING 1/4" OF BOTH CONDUCTORS.

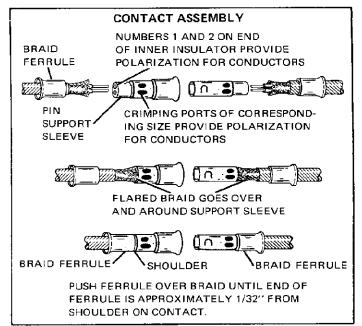


Figure 3

# 2. PREPARATION & ASSEMBLY (Non-braided Shielded Cable)

### 2.1 CABLE PREPARATION

- (a) Slide ferrule on cable, small end first.
- (b) Strip cable to dimensions specified in Figure 4.
- (c) Trim off foil shielding back against outer jacket.

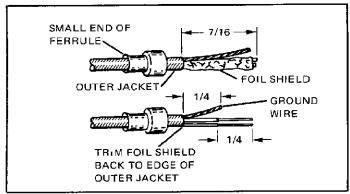


Figure 4

### 2.2 ASSEMBLY PROCEDURE

- (a) Insert conductors into contact wire barrels as far as they will go. (Contacts have numbers 1 and 2 formed on ends of inner insulator. This feature permits polarization of conductors. Wire barrel crimping ports of corresponding size can also be used for this purpose. See Figure 5.)
- (b) Fan ground wire around support sleeve on contact. NOTE: Ground wire should always be located in line with crimping ports.
- (c) Slide ferrule forward over ground wire and contact support sleeve until ferrule is even with shoulder on contact. See Figure 5.
- (d) Assembly is ready to be crimped.

# 3. CRIMPING PROCEDURE

After contacts have been assembled on wire, they can be crimped by hand tools or interchangeable dies in the appropriate tool. As noted on page 1, refer to IS 1772-2 for instructions on the use of current production hand tools. See IS 1772-3 for procedure to use interchangeable dies.

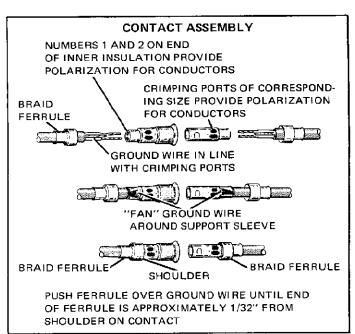


Figure 5

# 4. ATTACHING RETENTION SPRING

(a) Retention springs are attached to contacts after contacts are crimped, but before they are inserted into connector housing. These parts not only retain contacts in connector cavities but hold them in correct alignment.
 Although retention springs can be used on any twin COAXICON contact, specific use will depend upon con-

### 4.1 SPRINGS NO. 51413-1 & 51413-3

(a) Begin assembly by spreading front corners of spring over contact into the two LARGE crimping ports. See Figure 7.

nector housing. Refer to Figure 6 for selection of springs.

(b) Snap spring downward over contact. Holding lugs (indents) on retention spring must fit into LARGE crimping ports.

RETENTION SPRING NUMBER	WHERE USED	CONTACT EXTRACTION TOOL NO.	
329042	12 POS. CONNECTOR	305141-2	
	10 POS. CONNECTOR	_	
51413-3	8 POS. SERIES "W" CONNECTOR	305141-4	
51413-1	10 POS. "T" CONN.		

Figure 6

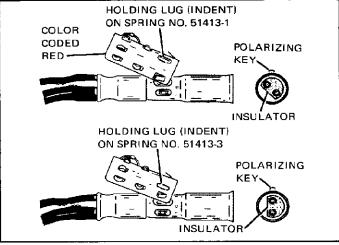


Figura 7

- (c) Insulators will appear at an angle when spring No. 51413-1 is properly assembled (for use in 10 position "T" connector). See Figure 7.
- (d) Insulators will be in alignment with key when spring No. 51413-3 is properly assembled (for use in 10 position connector and 8 position series "W" connectors),

# 4.2 SPRING NO. 329042

- (a) Place open side of spring against section containing large crimping ports. See Figure 8.
- (b) Push spring down so that it spreads slightly and snaps over contact, then rotate it until indents fit into large crimping ports on contact.
- (c) Spring should fit firmly against contact.

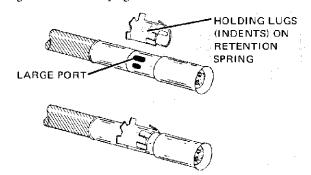
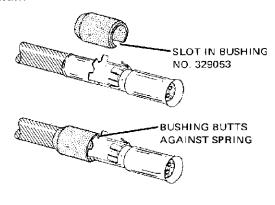


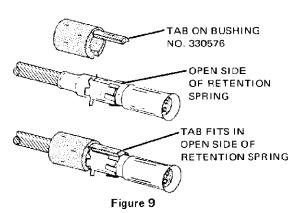
Figure 8

### 4.2.1 Attaching Alignment Bushing

NOTE: Alignment bushings are used only on contacts with retention spring No. 329042.

- (a) Alignment bushing should be positioned as shown in Figure 9 before attaching it to contact.
- (b) Place section of bushing containing slot against crimped
- (c) Push bushing down until it spreads open and slides over ferrule.





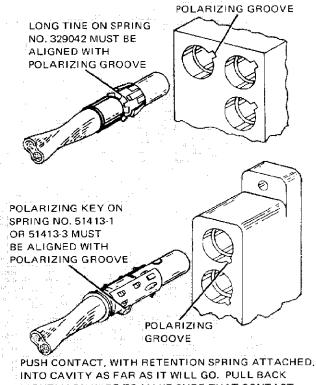
- (d) Bushing must butt against retention spring. See Figure 9.
- (e) Bushing No. 330576 (yellow) has tab protruding from end. Tab fits into open side of retention spring. See Figure 9.

# 5. INSERTION & EXTRACTION INSTRUCTIONS

Insert contacts into cavity in housing as shown in Figure 10. To extract contacts from housing, use tool as shown in Figure 11. Extraction tool part numbers are listed in Figure 6.

Extract contacts in the following manner:

- (a) Place end of tool over end of contact. See Figure 11.
- (b) Push sleeve into cavity as far as it will go. Note that push rod button will "back out" of handle when tip of contact is engaged.
- (c) Rotate handle several times.
- (d) Hold handle down firmly with thumb and forefinger and push button with palm of hand.
- (e) As button is pressed down, contact will be ejected.



LIGHTLY ON WIRE TO MAKE SURE THAT CONTACT IS SECURED IN CAVITY.

Figure 10

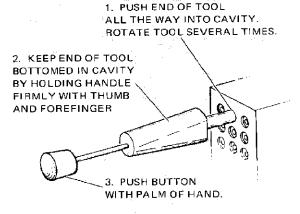


Figure 11