

CUSTOMER HOTLINE 1 800 722-1111

THREADED-TYPE TWIN COAXICON CONNECTORS								
RECEPTACLE ASSEMBLY			LOCK WASHER		PLUG ASSEMBLY		COLLAR	
FERRULE		JAM NUT		FERRULE				
CABLE (RG/U Coaxial Cable Manufactured in Accordance with MIL-C-17-D)	SILVER-PLATED CONNECTORS			SILVER-PLATED CONNECTOR KITS (Kits Incl Ferrules)		TARNISH-RESISTANT CONNECTOR* KITS (Kits Incl Ferrules)		TOOLING
	CONNECTOR NUMBER & INSULATOR COLOR		FERRULE	Plug	Receptacle	Plug	Receptacle	
	Plug	Receptacle		Plug	Receptacle	Plug	Receptacle	
108U, 108A/U, & Belden 8759	--	--	--	2-329945-1	2-329942-1	225687-2	225689-2	Hand Tool 69311-1 Mod G: Straight Action Double Action Tool Hand Tool 69710: "C" Head
2-3932 MICRODOT 2-3934 MICRODOT	--	--	--	2-329943-1	2-329940-1	--	225689-3	
Belden 8451, 8641 & 8761	--	329941 Natural (White)	329056	2-329944-3	2-329941-3	--	--	Tool Used With Inter- changeable Die Set 69410-1
Belden 8762	--	--	--	2-329945-3	2-329942-3	--	--	
Belden 8737 (Spiral-Wrapped Shield)	--	329941 Natural (White)	329960	2-329944-1	2-329941-1	--	--	Pneumatic Tool 69365-2: Bench-mounted Tool Used With Inter- changeable Die Set 69410-1

\* Same Insulator Color as Silver-Plated Parts

Fig. 1

## 1. INTRODUCTION

This instruction sheet (IS) covers the selection and assembly of AMP Threaded-Type Twin COAXICON Connectors listed in Figure 1. These connectors can be purchased as single items or as kits, and they are terminated to the variety of coaxial cables listed in Figure 1.

**NOTE** All dimensions on this sheet are in inches.

Read these instructions thoroughly before starting assembly or termination.

**NOTE** Current production hand tools are identified by the model letter designations listed in Figure 1. See Instruction Sheet IS 1833-2 for crimping instructions using hand tools, and see Instruction Sheet IS 1833-3 for the use of interchangeable dies.

## 2. CABLE PREPARATION

Before stripping cable, slip ferrule on cable as shown in Figure 2. Then proceed as follows:

1. If plug is being crimped, slide collar — knurled end first — onto cable.
2. Strip outer jacket from cable exposing .500 in. of braid.
3. Strip .219 in. from end of braid; then flair

braided as shown in Figure 2.

4. Strip cable, exposing .250 in. of both conductors as shown in Figure 2.

**NOTE** Be certain that collar has been placed on cable if plug is to be terminated to cable. See Figure 3.

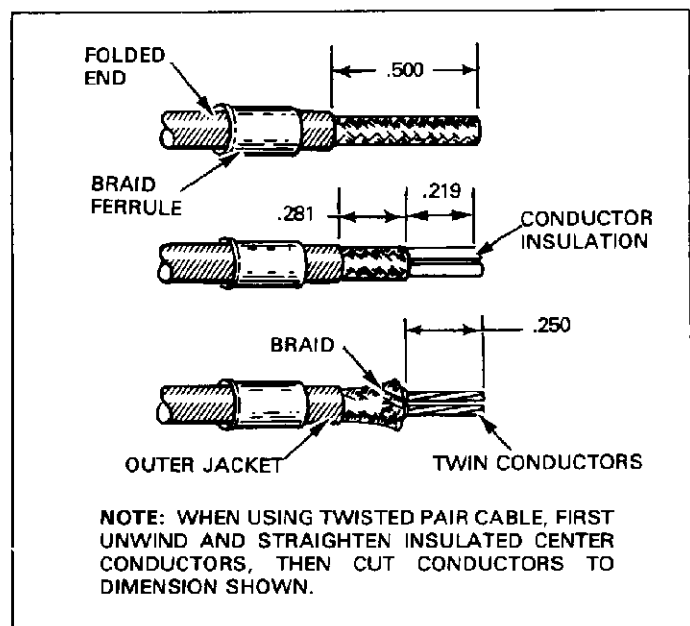


Fig. 2

**3. ASSEMBLY PROCEDURE**

The steps which follow are recommended to assemble the cable for termination. Use the applicable illustration for the connector being terminated. Proceed as follows:

1. Holding the cable, rotate the conductors to flare braid as shown in Figure 3.
2. Insert conductors into connector as far as they will go. The braid passes over and around the support sleeve. The symbols formed on the end of the inner insulator provide polarization for the connectors.
3. Slide braid ferrule forward and over the braid until the ferrule bottoms against the shoulder on the connector. See Figure 3.
4. Crimp the assembled connector using IS 1833-2 for the hand tool and IS 1833-3 for the interchangeable dies.

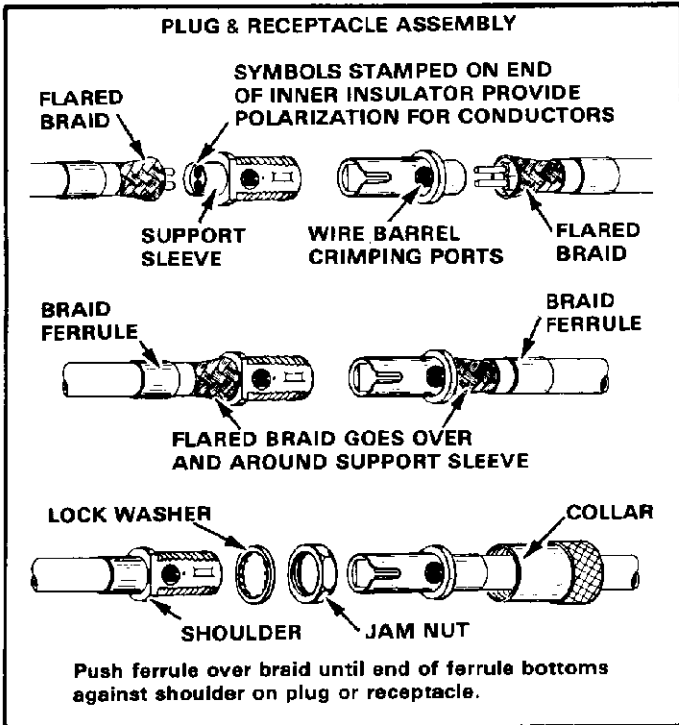


Fig. 3

**4. PANEL MOUNTING**

The dimensions to cut the panel for Threaded-Type Twin COAXICON receptacles are shown in Figure 4. Refer to Figure 5 for panel insulating bushings used for receptacles.

**5. PRINTED CIRCUIT (PC) BOARD ADAPTER**

PC board adapters are available for use with plugs listed in Figure 1. Refer to Figure 6 for adapter mounting dimensions.

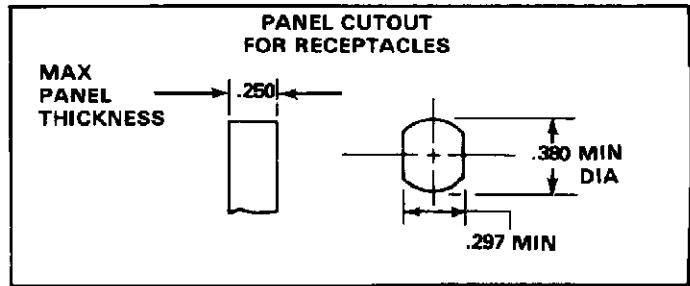


Fig. 4

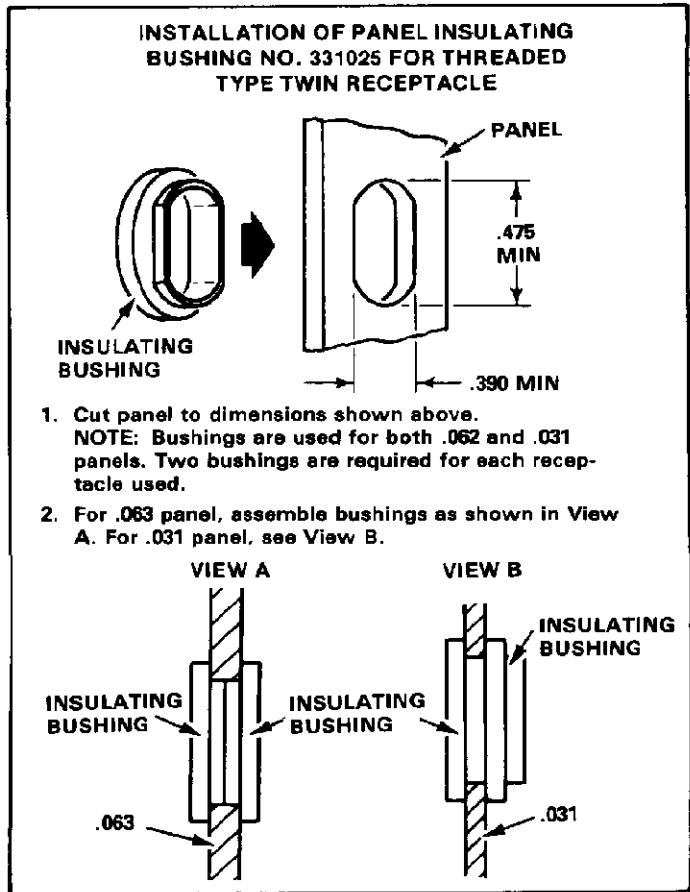


Fig. 5

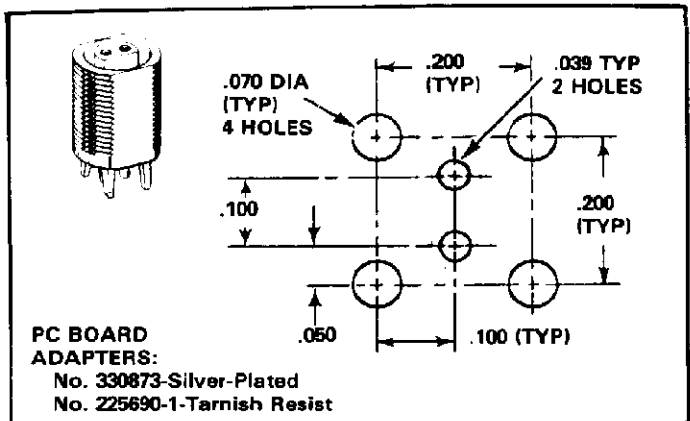


Fig. 6