



AMP ★ COAXICON ★ SERIES SMC
DUAL CRIMP PLUGS

IS 2224-1	
RELEASED	6-26-81
REVISED	

RG/U CABLE	PLUG P/N		HAND TOOL P/N (Instr. Sheet 2224)	DIE SET FOR TOOL P/N 69365 (Instr. Sheet 2983)
	GOLD	TARN. RES.		
174,188	51749-1	228026-1	220020-1	220018-1
178,196	51749-2	228026-2	220020-1	220018-1
179	51749-5	228026-3	220020-1	220018-1
196 DBL. BRD.	51749-3	228026-4	220020-1	220018-1
RD-316, 188 DBL. BRD.	51749-6	228026-5	220020-2	

Figure 1

1. INTRODUCTION

See Figure 1 for plug part numbers along with tools and dies used to terminate the cables listed.

Figure 2 shows a typical COAXICON series SMC plug assembly. Detailed crimping instructions are packaged with the crimping tools and dies. Refer to Figure 3 and steps below for assembly procedure.

Refer to Section 3 for use of center contact locating gage when assembling SMC plugs on RG 178 and 196 cables.

2. PLUG ASSEMBLY (Figure 3)

- (a) Slide ferrule onto cable and strip cable to dimensions shown. (Note orientation of stepped ferrule in figures 2 and 4.) Flare braid.
- (b) Slide center contact onto center conductor of cable until bottoming is felt. Crimp center contact; then remove tape. (See instructions packaged with tool.)
- (c) Insert contact into plug with braid over support sleeve. Ensure cable dielectric bottoms inside connector.
- (d) Slide ferrule forward over braid and support sleeve.
- (e) Crimp ferrule (see tool instructions).

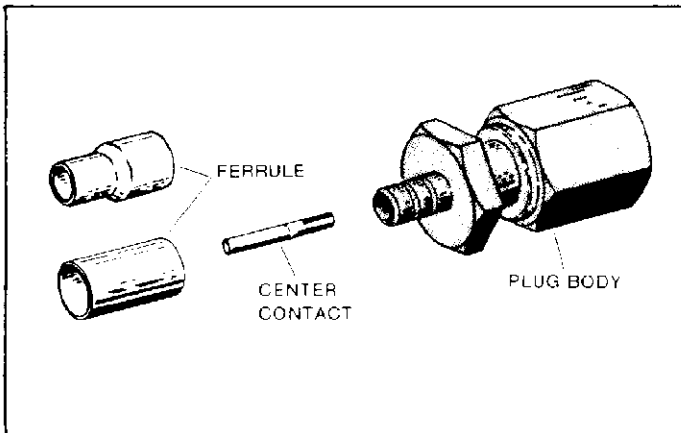


Figure 2

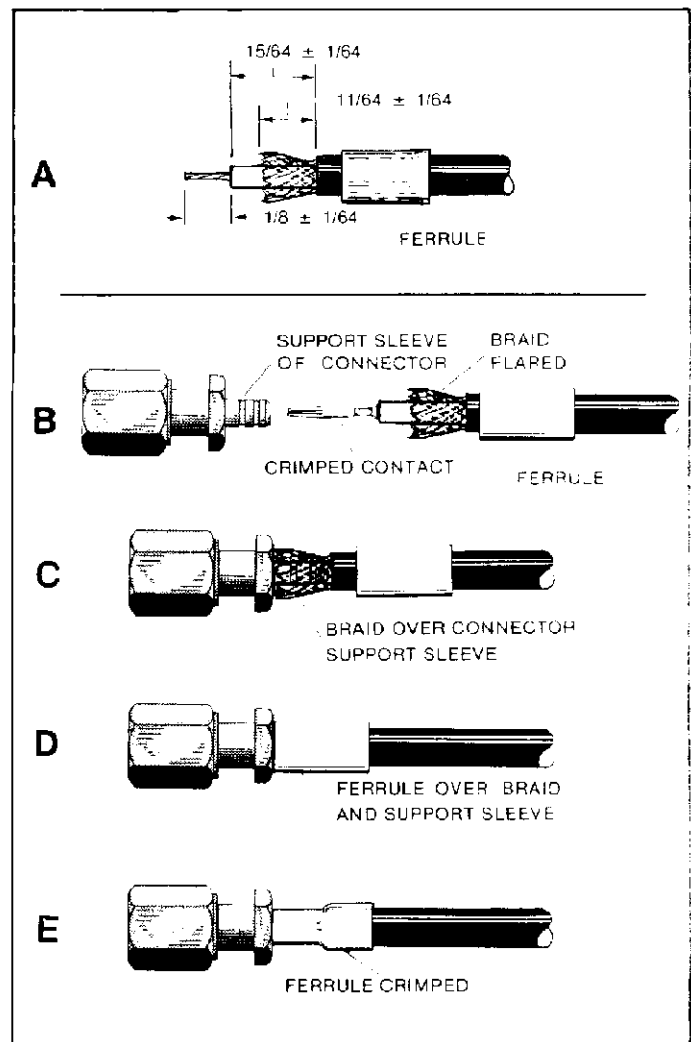


Figure 3

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3. CENTER CONTACT LOCATING GAGE FOR USE WITH RG 178, 196 CABLES (Figure 4)

Center contact locating gage P/N 225162-1 is used as follows when assembling SMC plugs on RG 178 and 196 cable.

- (a) Strip cable and crimp center contact as previously described.
- (b) Screw gage onto connector body.

- (c) Insert crimped contact into connector body until end of contact butts against stop inside gage.
- (d) Slide ferrule over braid and support sleeve until it butts against connector.
- (e) Remove gage from connector and complete ferrule crimp.

NOTE: Gage must be removed if assembly is crimped in hand tool P/N 220020-1, but can be left on connectors while crimping in tool P/N 69365.

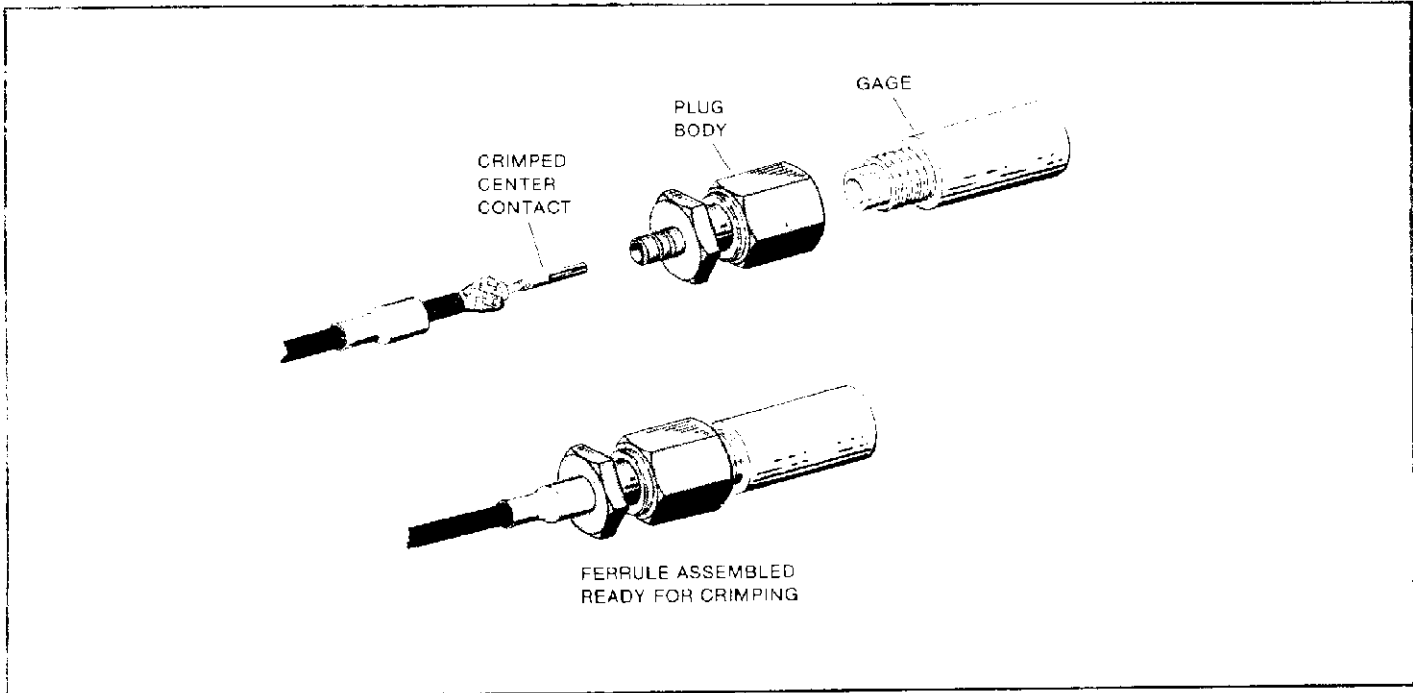


Figure 4

The following publications contain information on additional series SMC connectors.

- JACKS—IS 2224-2
- BULKHEAD JACKS—IS 2224-3
- PANEL JACKS— IS 2224-4
- RIGHT ANGLE PLUGS—IS 2224-5
- RIGHT ANGLE BULKHEAD JACKS—IS 2224-6