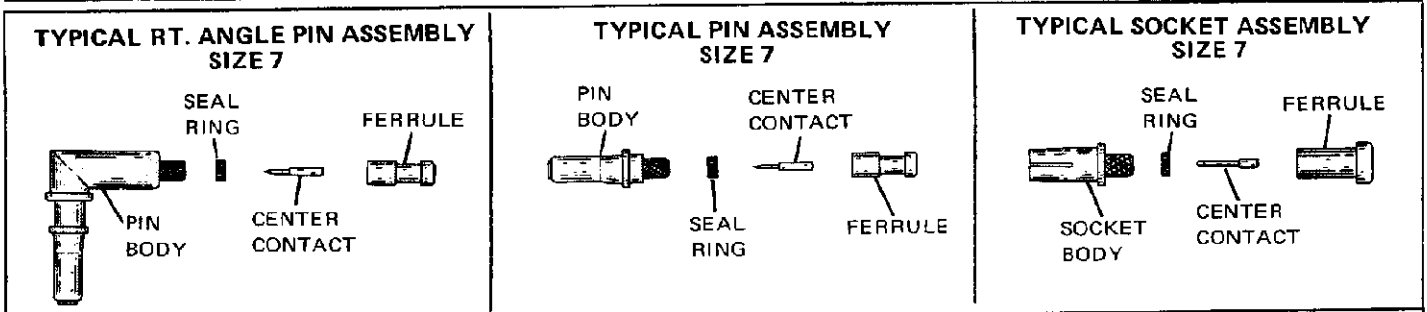




**AMP* COAXICON* CONTACTS
PER MIL-C-23216**
For use in RM (Arinc Spec. 404)
or RME (Mil-C-81659) Connectors

IS 2348-1

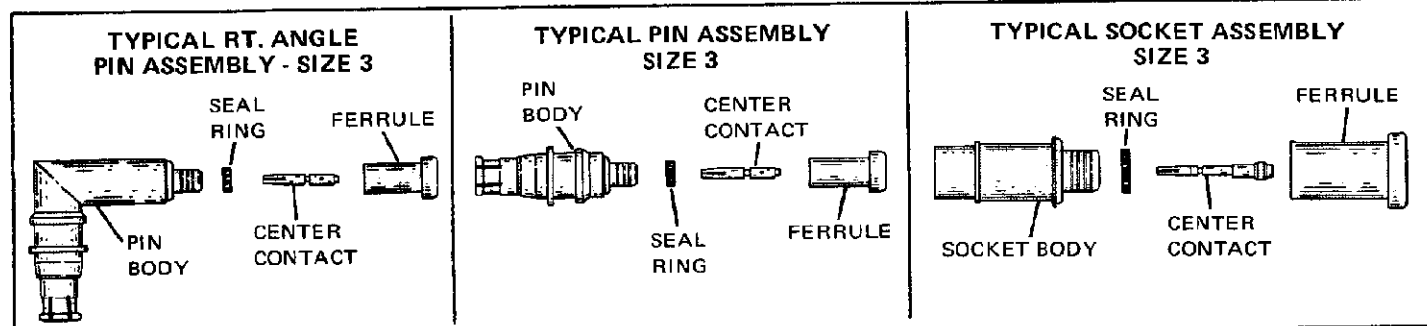
RELEASED	7-1-71
REVISED	11-14-75



CONTACTS			RG CABLE	STRIP DIMENSIONS ±.015			CENTER CONTACT TOOL*		FERRULE TOOL	
Size	Desc.	Part No.		A	B	C	Tool No.	Positioner No.	Part No.	Crimp Die
7	RT. ANGLE PIN	225814-1	188	.375	.218	.125	M22520/2-01 W/SELECTOR AT NO. 4	K397 (AMP EQUIV. 2-601966-6)	220066-1 OR 220009-1†	C
7	SOCKET	225796-1	58C	.281	.218	.125	M22520/2-01 W/SELECTOR AT NO. 5	K344 (AMP EQUIV. 1-601966-7)	220066-1	B
7	PIN	226052-1	188	.312	.218	.125		K345 (AMP EQUIV. 1-601966-6)	220066-1 OR 220009-1†	C
7	SOCKET	225796-3	188	.281	.218	.125		K344 (AMP EQUIV. 1-601966-7)	220066-1 OR 220009-1†	C
7	SOCKET	225796-2	223	.281	.218	.125			220066-1	B

† Tool 220009-1 provides an insulation crimp.

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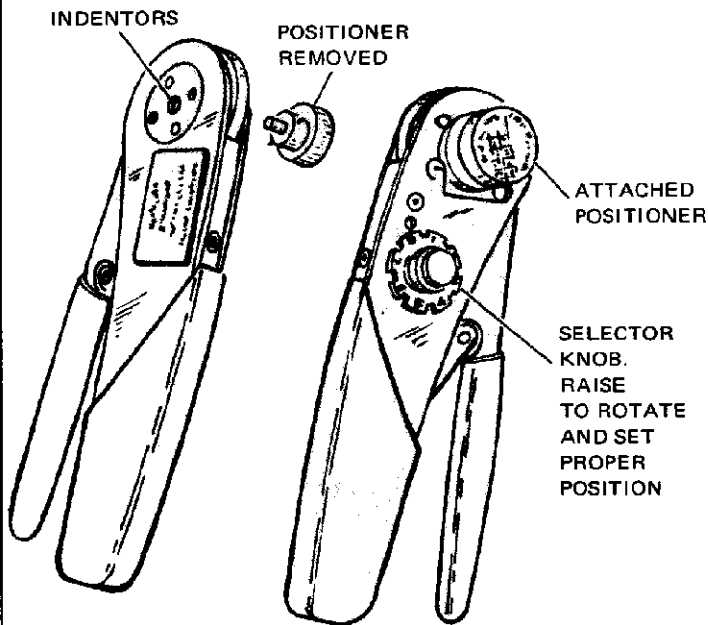
CONTACTS			RG CABLE	STRIP DIMENSIONS ±.015			CENTER CONTACT TOOL*		FERRULE TOOL	
Size	Desc.	Part No.		A	B	C	Tool No.	Positioner No.	Part No.	Crimp Die
3	RT. ANGLE PIN	225803-1	142, 142A, 142B	.281	.218	.125	M22520/2-01 W/SELECTOR AT NO. 8	K346 (AMP EQUIV. 1-601966-8)	220066-1	B
3	SOCKET	225792-1	214	.500	.500	.187	220015-1	—	220015-1	—
3	SOCKET	225792-2	213	.375	.500	.187			220015-1	—
3	PIN	226053-1	58C, 141	.281	.218	.187	M22520/2-01 W/SELECTOR AT NO. 8	K346 (AMP EQUIV. 1-601966-8)	220066-1	B
3	SOCKET	225792-3	58C, 141	.312	.218	.125	M22520/2-01 W/SELECTOR AT NO. 8	K374 (AMP EQUIV. 2-601966-4)	220066-1	B
3	SOCKET	225792-4	165	.500	.500	.187	220015-1	—	220015-1	—

* AMP equivalent 601966-1 for tool M22520/2-01. This tool and positioners supplied by Daniels Mfg. Corp. 2266 Franklin Road, Bloomfield Hills, Michigan 48013.

CRIMPING CENTER CONTACTS - TOOL M22520/2-01

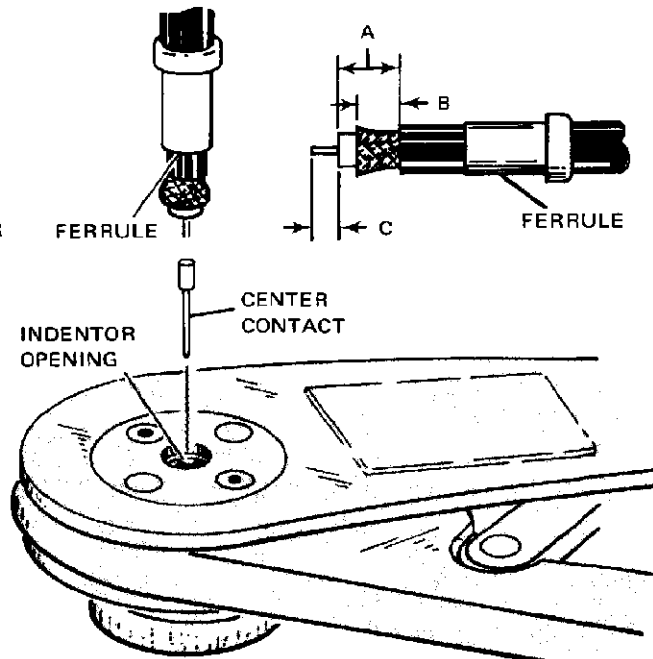
CENTER CONTACT TOOL SET-UP

1. To set up tool, open tool handles.
2. Install positioner by inserting it into tool retainer ring and turning 90 degrees until bayonet pin locks.
3. Install safety clip into retainer ring.
4. Raise selector knob and rotate it until appropriate number is opposite index mark.



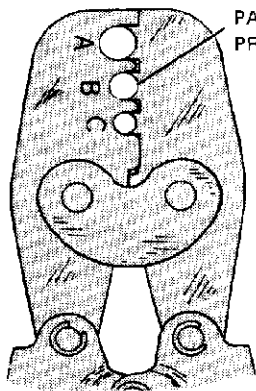
CRIMPING CONTACT

1. Slip ferrule on cable, then strip cable and flare braid. See table on page 1 for dimensions.
2. Insert contact into indenter opening. Contact will rest on positioner.
3. Insert stripped conductor into center contact until dielectric butts against contact, then close handles until ratchet releases. Handles will return to open position, allowing crimped contact to be removed.

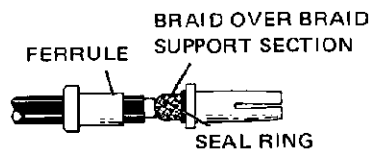


CRIMPING FERRULES - TOOL 220066-1 OR 220009-1

SEE CHART ON
PAGE 1 FOR
PROPER DIE



TOOL NO. 220066-1

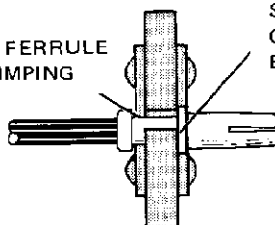


CRIMPING FERRULE

1. Slip seal ring over braid support of contact body, then insert crimped center contact into appropriate contact body until cable dielectric bottoms against dielectric inside contact body. Braid should fit over braid support section of contact.
 2. Position ferrule over braid and against shoulder on contact body.
 3. Place the assembly in appropriate crimping die of tool jaw, with shoulder of contact body against tool jaw.
- NOTE: Tool No. 220009-1, shown below, can be used where insulation crimp is desired.
4. Close tool handles until CERTI-CRIMP* ratchet releases to form braid crimp.

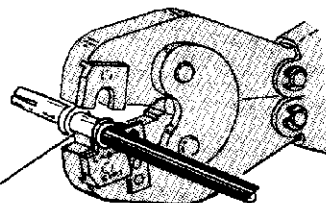
TOOL NO. 220009-1

PLACE FERRULE
ON CRIMPING
DIE



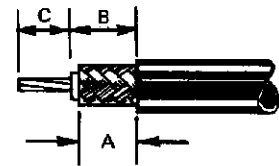
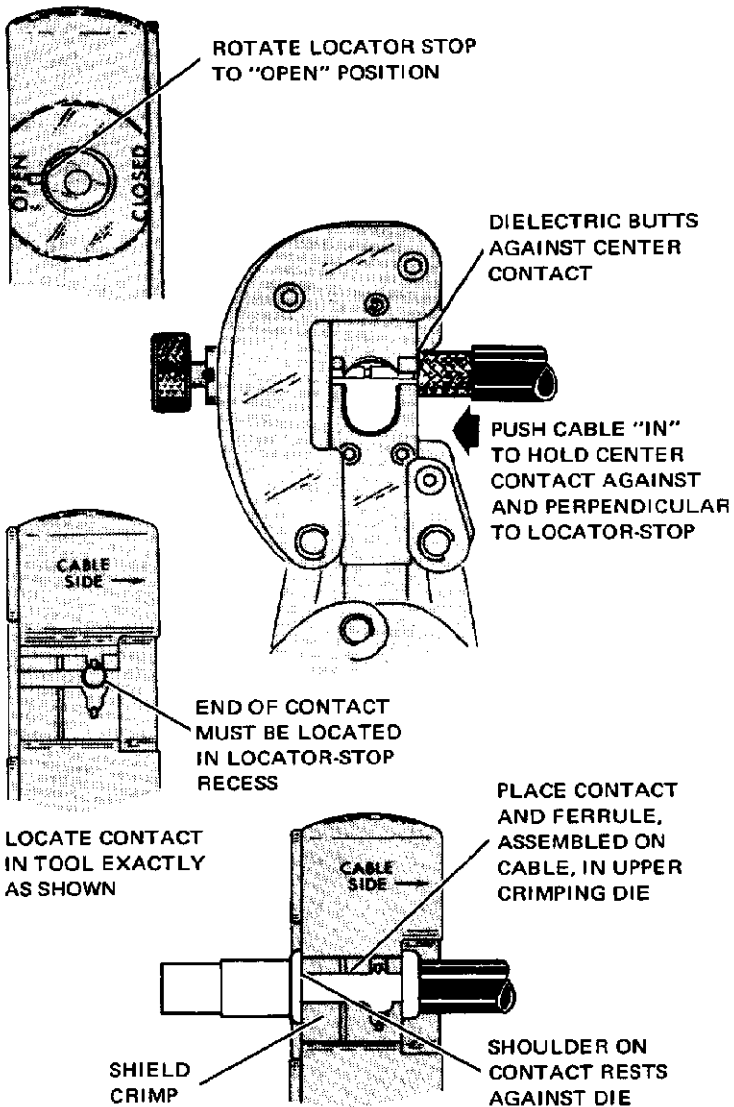
SHOULDER ON PIN
OR SOCKET BODY
BUTTS AGAINST DIE.

PLACE FERRULE ON
CRIMPING DIE.
SHOULDER ON CONNECTOR
BODY BUTTS AGAINST DIE.



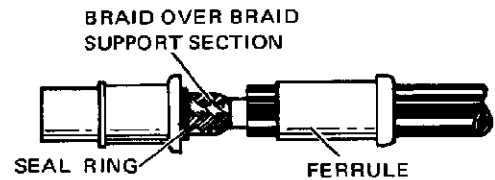
CABLE MUST EXTEND FROM SIDE
OF TOOL CONTAINING INSULATION
CRIMPING DIE.

CRIMPING CENTER CONTACTS AND FERRULES - TOOL 220015-1



CRIMPING CENTER CONTACT

1. Slip Ferrule on Cable, then strip cable. See table on page 1 for dimensions.
2. Rotate contact locator-stop to "open" position on back of tool head.
3. Insert Conductor into contact Wire Barrel until Contact butts against cable Dielectric, then place Contact in Tool Head as shown. (Crimping Dies on Tool are opened by closing Handles until CERTI-CRIMP Ratchet releases. Once Ratchet is engaged, Handles cannot be opened until fully closed.)
4. Close handles until Ratchet releases to complete crimp.



CRIMPING FERRULE

1. Slip seal ring over braid support of contact body, then insert crimped center contact into contact body until cable dielectric bottoms against dielectric inside contact body. Braid should fit over braid support section of contact body.
2. Position ferrule over braid and against shoulder on contact body.
3. Place the assembly in crimping die of tool, with shoulder of contact body against die.
4. Close tool handles until CERTI-CRIMP ratchet releases to form braid crimp.