

# AMP\* SERIES UHF PLUGS

IS 2491-1

RELEASED 11-7-91

CUSTOMER HOTLINE 1 800 722-1111

TYPICAL SERIES UHF PLUG ASSEMBLY			STEP-DOWN FERRULE	N
STA	NDARD COLLAR		`	
PLUG	BODY			STRAIGHT
CABLE SIZE	CONNECTOR PART NO.	DIES FOR BENCH MACHINE 220152-1 (CM 2627)	HAND TOOLS•• (IS 2499)	LONG COLLAR
58, 58A,	226208-3 1-226208-3	220157-2		1
58B, 58C	1-226208-9 226279-1• 1-226279-6	(IS 2623-1)	220094-1	
	226279-1•		220094-1	
58B, 58C 59, 59A,	226279-1• 1-226279-6 226208-6 1-226208-6 226279-3•			

# Fig. 1

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#### 1. INTRODUCTION

This Instruction Sheet (IS) covers the selection and assembly of Series UHF Plugs listed in Figure 1. Read these instructions thoroughly before using the connectors.

\*\*Hand tools do not provide insulation grip.

NOTE

Dimensions on this sheet are in millimeters [with inch equivalents in brackets].

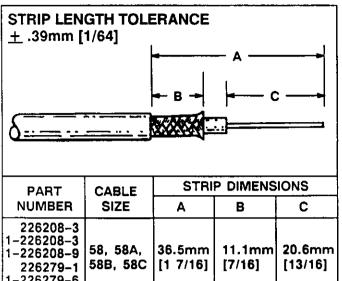
## 2. DESCRIPTION

Figure 1 shows the plug connector assembly which consist of a plug body, a standard or long collar, and a step-down or straight ferrule. Plugs with long collars are crimped in hand tools only.

### 3. ASSEMBLY PROCEDURES

Determine the cable size needed for your application; then refer to the chart in Figure 1 and select the appropriate connector along with the correct tooling.

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1-226279-6 226847-1 226208-6 59. 59A. 36.5mm 11.1mm 20.6mm 1-226208-6 59B [1 7/16] [13/16] [7/16] 226279-3 1-226279-8 8, 8A, 30.9mm 11.9mm 19.0mm 1-226208-1 1-226208-8 | 213 [1 7/32] [15/32] [3/4] 34.9mm 11.9mm 23.0mm 8. 8A. 226279-2 1-226279-7 213 [1 3/8] [15/32] [29/32]

Fig. 2

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NOTE

Crimping procedures are covered in separate publications shipped with the respective tooling.

- 1. Slip the ferrule over the cable, followed by the collar. See Figure 3, Step A.
- 2. Strip the cable to the dimensions shown in Figure 2.
- 3. Flare the braid and insert the stripped cable into the plug body until the cable dielectric butts against the dielectric inside the body. The braid fits over the support sleeve. See Fig. 3, Step B.

NOTE

The end of the center conductor will extend from the end of the contact for inspection purposes on some cable assemblies. After the crimp is finished, the center conductor should be trimmed flush with the end of the contact.

- 4. When using hand tools, the center contact is crimped and the ferrule is assembled over the braid. See Fig. 3, Step C.
- 5. When using the bench machine, assemble the parts as shown in Steps C and D.
- 6. Complete the crimp as required by the tooling Instruction Sheet.

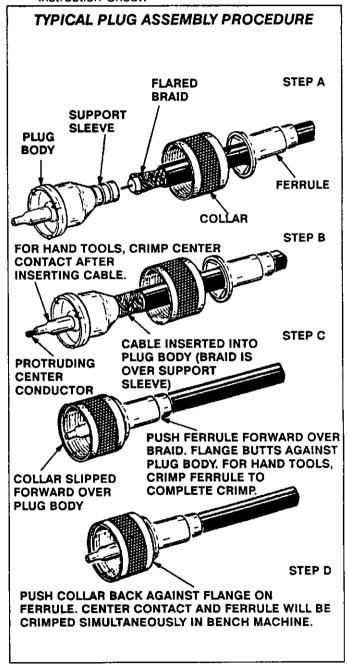


Fig. 3

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