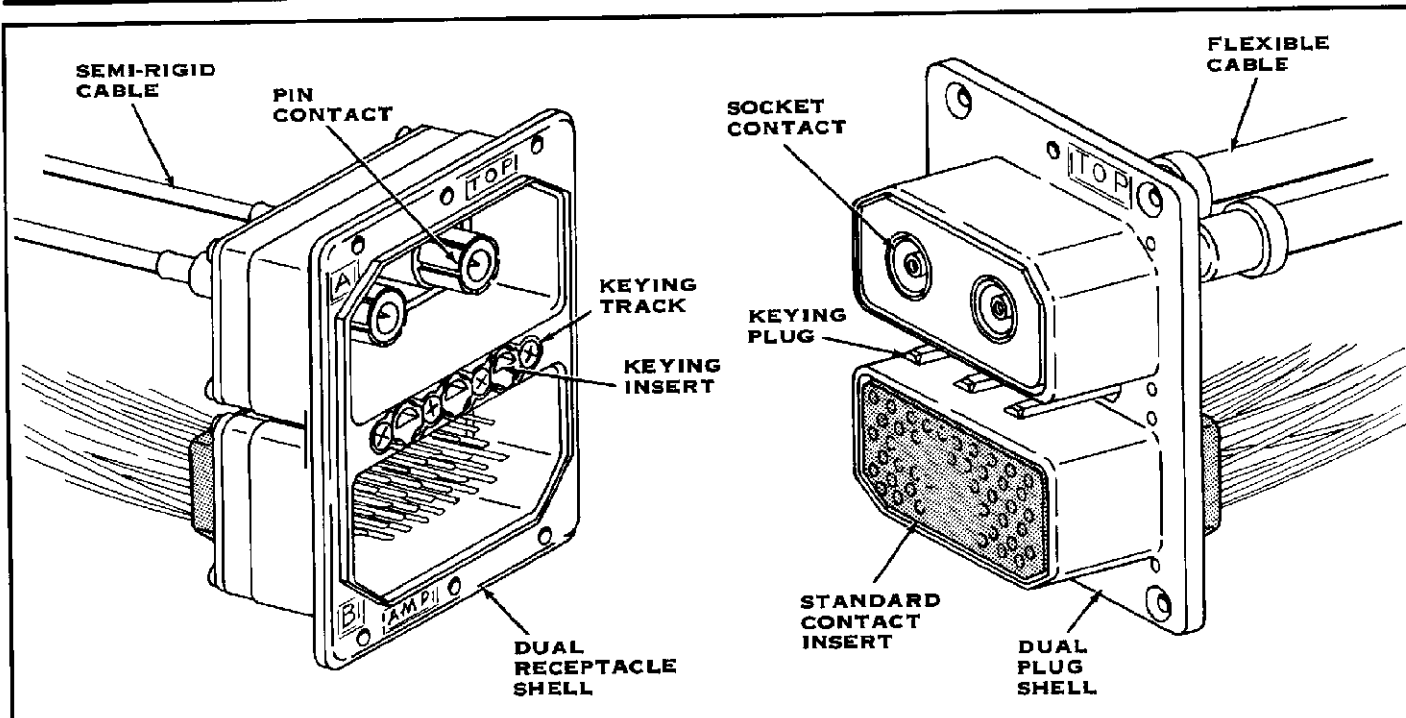




CONNECTOR SERIES	INSERT TYPE	CONTACT		CABLE	CENTER CONTACT CRIMPING TOOL		FERRULE/BACKSHELL CRIMPING TOOL	
		TYPE	NUMBER		TOOL	POS.	FERRULE	BACKSHELL
RM AND RME	CAPTIVE	PIN	225837-1	SEMI-RIGID 141	601966-1* M22520/2-01	1-601966-9* K 350	220066-1	
		SOCKET	225831-1	RG 214	220015-1			220015-1

*A-MP NUMBER - THE NUMBER LISTED DIRECTLY BELOW IS THE MIL-SPEC NUMBER

FIGURE 1

1. INTRODUCTION

These instructions cover the recommended procedures for installing A-MP size 1 Coaxial Contacts in the A-MP RM and RME Series, ARINC Type, Rack and Panel Connectors. Read this material thoroughly before starting.

2. DESCRIPTION

The C2 Captive Inserts prevent stresses, caused by the large cables, from inadvertently releasing the contacts. The Pin Contacts and the applicable Inserts must be installed in the Receptacle Shell. The Socket Contacts and the applicable Inserts must be installed in the Plug Shell. See Figure 1.

Refer to the A-MP Instruction Sheet, IS 7482, for the Panel Cutout Dimensions, Keying Plug Arrangements and various other RM and RME Series Contact Inserts that are available.

3. CONTACT CRIMPING

The contacts are designed to be crimped with A-MP Hand Crimping Tools listed in Figure 1. Read the instructions (IS 2348-2) for the cable strip length and the contact crimping procedure.

4. INSTALLING SOCKET CONTACTS (Figure 2A)

Select the Plug Shell specified for your application. We have shown a double shell to illustrate the possible combination of the C2 and Standard contact inserts.

To ease assembly, we recommend that you assemble the Rear Insert Assembly before crimping the contacts.

1. Insert 2 Socket Contacts into the Rear Insert. Position this assembly on a horizontal support with the back of the contacts resting on the support.

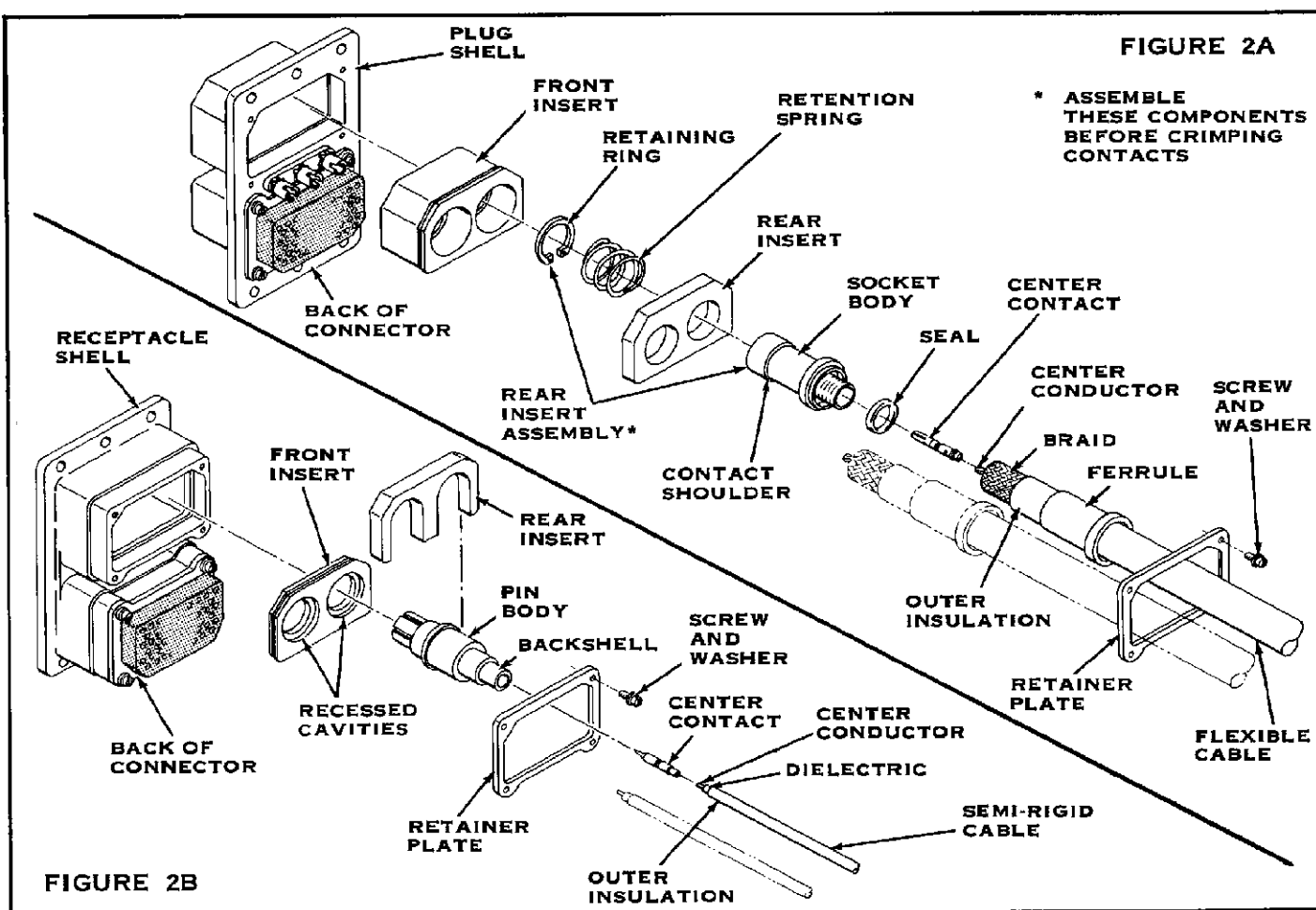


FIGURE 2

2. Slide the Retention Springs over the Front of the contacts.
3. Now install the Retaining Rings. Using a suitable tool, spread each Ring and slide it over the Front of the contact. Push the Ring down until it locks behind the Shoulder of the contact. Check to be sure the Ring is properly seated.
4. Slide the Retaining Plate over the cables. Then slide the Contact Ferrules over the unstripped cables.
5. Strip the cables and crimp the contacts according to the procedures described on IS 2348-2. *Caution must be used when crimping the Ferrules. Make certain the Rear Insert is against the tool Side Plate and the cable exits the Cable Side of the tool.*
6. Insert the Front Insert into the back of the Connector as indicated in Figure 2A.
7. Insert the contacts into the Front Insert until the Back Insert is flush with the back of the Plug Shell.
8. Slide the Retainer Plate over the cables and position it on the back of the Shell. Secure

the Plate with the 4 screws and washers supplied with the connector.

5. INSTALLING PIN CONTACTS (Figure 2B)

Select the Receptacle Shell that mates with the Plug Shell and proceed as follows:

1. Using Semi-Rigid 141 cable, strip and crimp it to the contact according to the procedures described on IS 2348-2.
2. Insert the Front Insert into the Back of the Receptacle Shell as indicated in Figure 2B. Make certain the Recessed Cavities are facing the back of the shell.
3. Slide the Retainer Plate over the crimped contacts and cable.
4. Insert the contacts into the Front Insert. Make sure they seat in the Recessed Cavities.
5. Slide the Rear Insert over the rear portion of the contact. Push the Insert in until it is flush with the back of the shell.
6. Slide the Retainer Plate over the cables and position it on the back of the shell. Secure the Plate with the 4 screws and washers supplied with the connector.