

Figure 1

## 1. INTRODUCTION

AMP MCX Right-Angle Cable Plug (Crimp Attachment) 1362991-1 is designed to be crimped onto coaxial cable sizes 179, or 187, using the following tools:

| TYCO ELECTRONICS PART NUMBER | DESCRIPTION              |
|------------------------------|--------------------------|
| 58425-2 or 1583696-1         | Crimp Die                |
| 354940-1                     | PRO-CRIMPER II Hand Tool |

**NOTE**



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

## 2. DESCRIPTION

The plug consists of a housing, cap, and ferrule. Refer to Figure 1.

## 3. ASSEMBLY PROCEDURE

**DANGER**

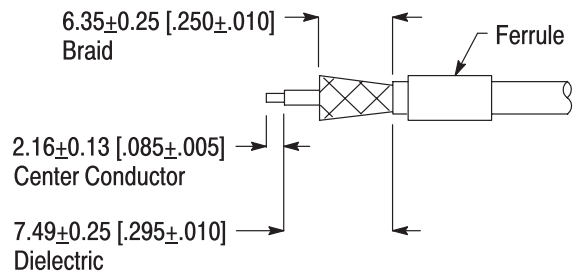


Follow safety precautions included with the tools used for assembly.

- Slide the ferrule onto the cable. Strip the cable to the dimensions shown in Figure 2. Take care not to nick the center conductor. Flare the cable braid.
- Secure the housing in a small bench vise.
- Tin the center conductor.
- Insert the center conductor into the housing. See Figure 3, Detail A. Make sure that the center conductor is positioned in the slot of the contact inside the housing. Slide the center conductor

against the housing dielectric. Do not allow braid to enter the housing. See Figure 3, Detail B.

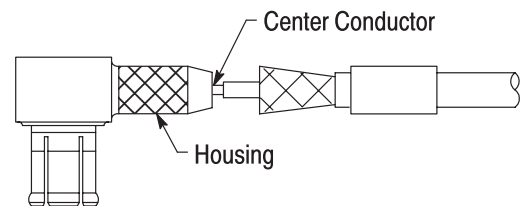
- Place soldering iron on tip of center contact, and solder.



**Note:** Not to Scale

Figure 2

**Detail A**



**Detail B**

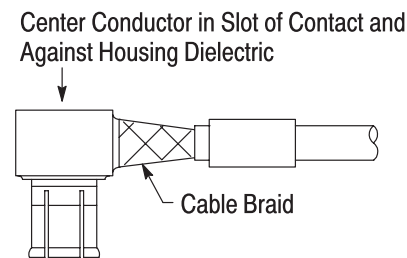


Figure 3

- Slide ferrule over cable braid and against housing. Then crimp the ferrule in place using the .128 inch hex crimping chamber. Refer to Figure 4, Detail A. Trim excess braid strands.

- Place cap into opening in housing, and either press, or solder or epoxy into place. Refer to Figure 4, Detail B.

**NOTE**



The cap can also be installed using the installation tool.

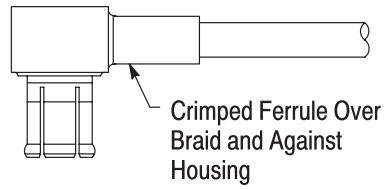
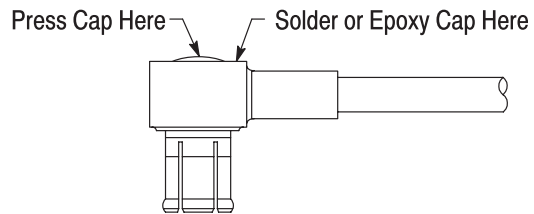
**Detail A****Detail B**

Figure 4

**4. REVISION SUMMARY**

Since the previous release of this document:

- Tyco Electronics' hand tool and crimp die replaced the M/A-COM versions
- Format was updated to current corporate requirements