

PIN ASSEMBLY							SOCKET ASSEMBLY			
CONTACTS			STRIP DIM. ±.015			RG/U CABLE	CENTER CONTACT TOOL †		FERRULE TOOL †	
Size	Pin	Socket	A	B	C		Tool No.	Positioner No.	Tool No.	Positioner No.
15	226782-1	226781-1	.281	.218	.125	316, 188	M22520/2-01 (AMP EQUIV. 601966-1) W/SELECTOR AT NO. 2	K370 (AMP EQUIV. 2-601966-8)	M22520/4-01 (AMP EQUIV. 601963-1)	GP 475 (AMP EQUIV. 601963-2)
15	226782-2	226781-2	.281	.218	.125	179				
15	226782-3‡	226781-3‡	.218	.156	.125	178, 196				
15	226782-4	226781-4	SEE BELOW			50 OHM RIBBON COAX				

‡ These assemblies include a short section of plastic tubing to be used with RG 196 cable.

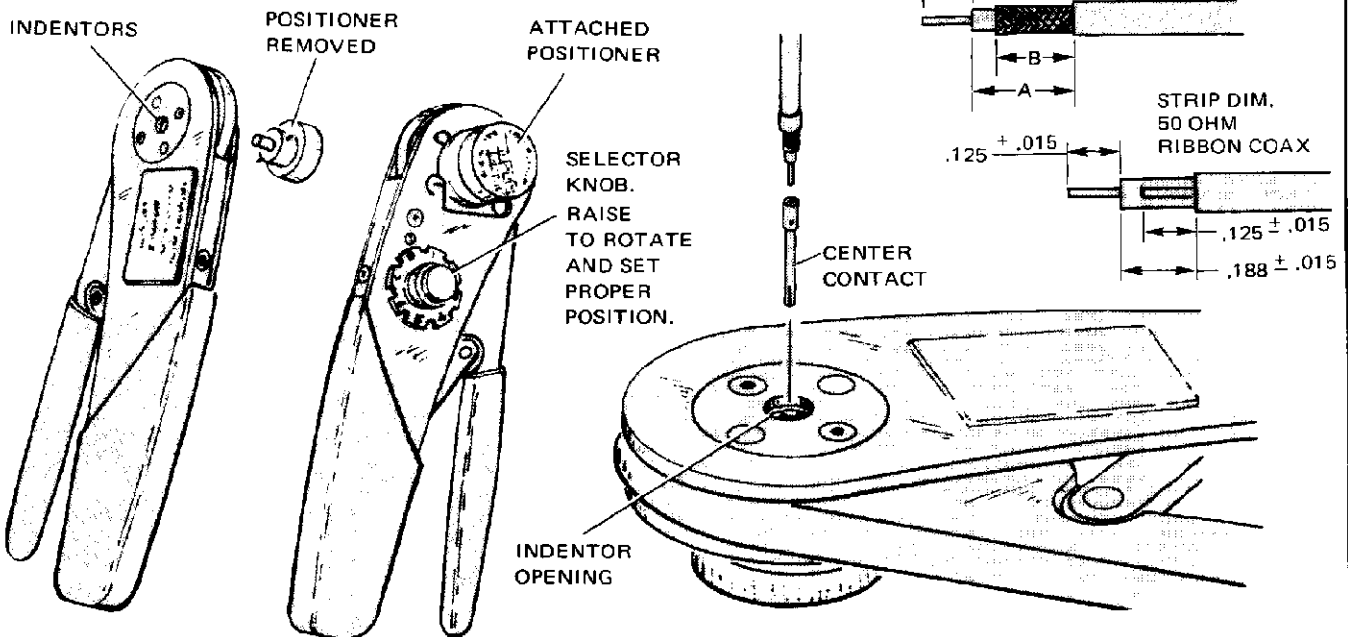
CRIMPING CENTER CONTACT (TOOL M22520/2-01)

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. Strip cable. See below for dimensions.
2. Insert contact into indenter opening. Contact will rest on positioner.
3. Insert center 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.



† These tools and positioners supplied by Daniels Mfg. Corp.,
2266 Franklin Road, Bloomfield Hills, Michigan 48013.

CRIMPING FERRULE (TOOL M22520/4-01)

1. Slip ferrule over contact and braid, or cable jacket where applicable, then flare end of braid.
2. Slip plastic tubing over crimped section of center contact onto dielectric (for assemblies that include tubing for use with RG 196 cable).
3. 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.

4. Position ferrule over braid and against shoulder on contact body.
5. Place the assembly in crimping tool. End of contact will rest against positioner.
6. Close tool handles until ratchet releases to form braid crimp.

NOTE: Part Nos. 226781-4 and 226782-4 require an additional step after the initial ferrule crimp. A second crimp must be made over the ferrule after rotating the ferrule 1/8 turn. This second crimp eliminates the small bulges on ferrule to allow insertion into connector.

