



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

IS 2348-3

RELEASED	1-7-72
REVISED	7-20-76

PIN ASSEMBLY

FERRULE

CENTER
CONTACT

PIN
BODY

SOCKET ASSEMBLY

SOCKET
BODY

CENTER
CONTACT

FERRULE

	CONTACTS		CABLE	STRIP DIMENSIONS	CENTER CONTACT TOOL†		TOOL FOR FERRULE OR BACK SHELL CRIMP	
Size	Desc.	Part No.	RG 58C, 141A	FIG. 1	Tool No.	Positioner No.	Part No.	Crimp Die
9	PIN	225935-1			M22520/2-01 W/SELECTOR AT #5	K345 (AMP EQUIV. 1-601966-6)	220066-1	B
	SOCKET	225936-2						C
9	PIN	225935-4	RG 174, 188	FIG. 2	M22520/2-01 W/SELECTOR AT #4	K345 (AMP EQUIV. 1-601966-6)	220020-4	—
	SOCKET	225936-3						—
9	PIN	225935-3	FILOTEX 27-537 §	FIG. 1	M22520/2-01 W/SELECTOR AT #5	K345 (AMP EQUIV. 1-601966-6)	220020-4	—
	SOCKET	225936-4						—

§ Equivalent to RG 196, Double Braid.

SOCKET ASSEMBLY 225936-1									
CONTACTS			CABLE	STRIP DIMENSIONS ±.015		CENTER CONTACT TOOL		TOOL FOR FERRULE OR BACKSHELL CRIMP	
Size	Desc.	Part No.		A	B	Tool No.*	Positioner No.	Part No.	Crimp Die
9	SOCKET	225936-1	.141 SEMI-RIGID	.062	.125	M22520/2-01 W/SELECTOR AT #5	K345 (AMP EQUIV. 1-601966-6)	220066-1	B

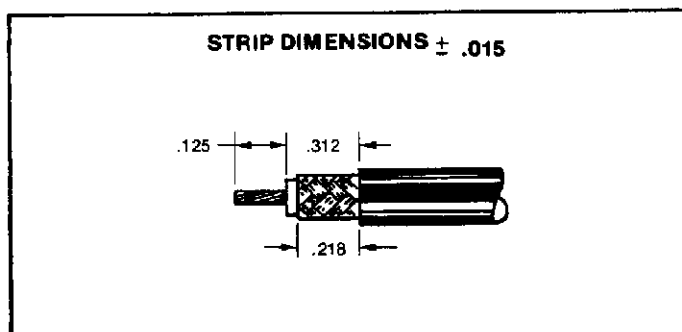


Figure 1

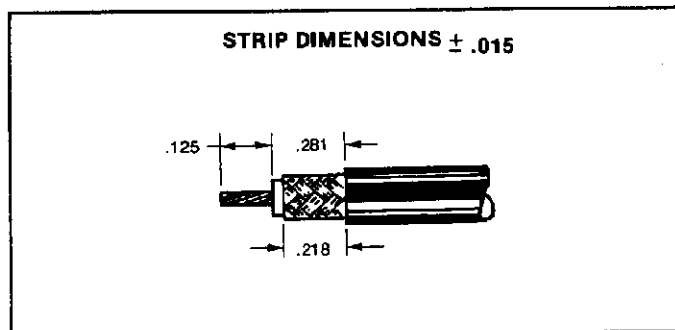
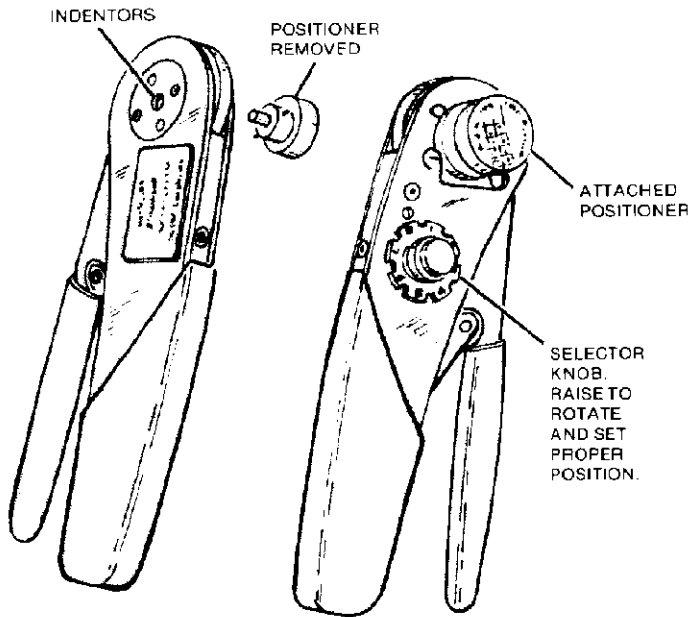


Figure 2

† 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.

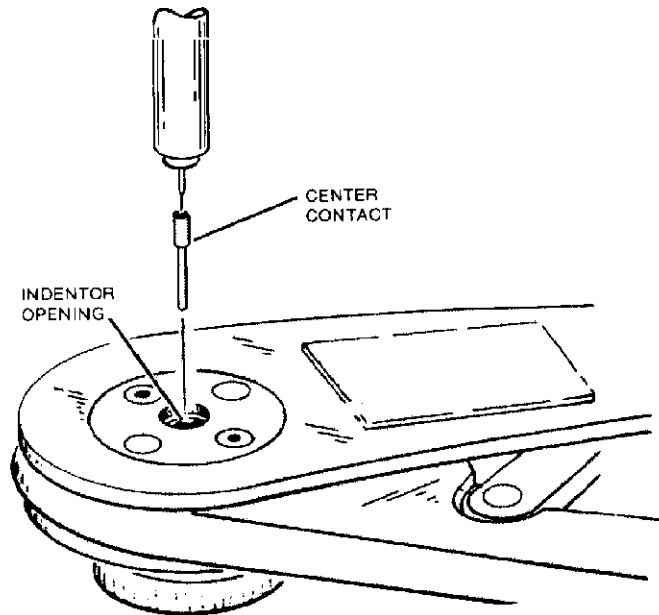
CENTER CONTACT TOOL SET-UP

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.



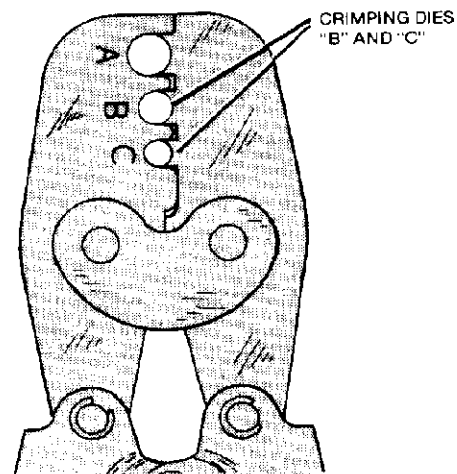
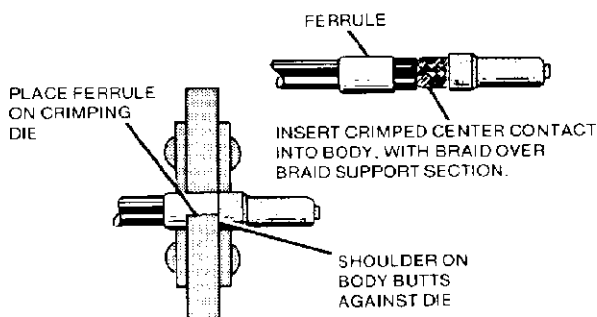
CRIMPING CONTACT

1. Slip ferrule on cable (for braided cable).
2. Strip cable. See table on Page 1 for dimensions.
3. Insert contact into indenter opening. Contact will rest on positioner.
4. 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.

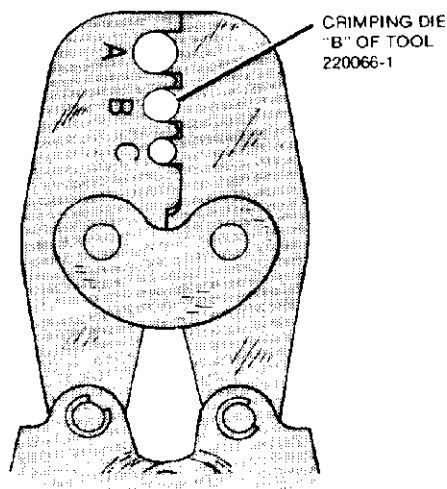


CRIMPING FERRULE WITH TOOL NO. 220066-1

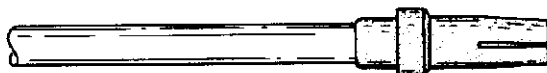
1. Flare braid.
2. Insert crimped center contact into contact body until cable dielectric bottoms against dielectric inside contact body. Braid should fit over braid support section of contact body.
3. Position ferrule over braid and against shoulder on contact body.
4. Place the assembly in the appropriate crimping die of tool jaw, with shoulder of contact body against tool jaw as shown below.
5. Close tool handles until CERTI-CRIMP* ratchet releases to form braid crimp.



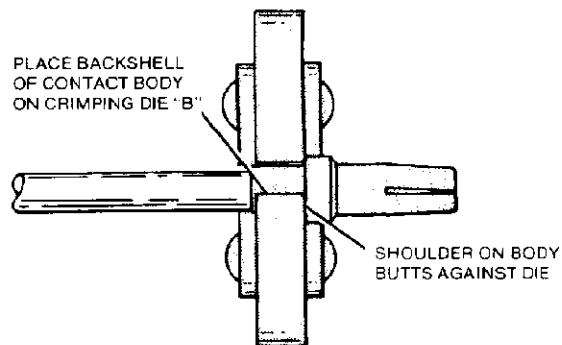
**CRIMPING BACKSHELL OF P/N 225936-1
WITH TOOL NO. 220066-1**



1. Insert crimped center contact into contact body until cable dielectric bottoms against dielectric inside body.
2. Place the assembly in crimping die "B" of tool jaw, with shoulder of contact body against tool jaw.
3. Close tool handles until CERTI-CRIMP ratchet releases to form shield crimp.



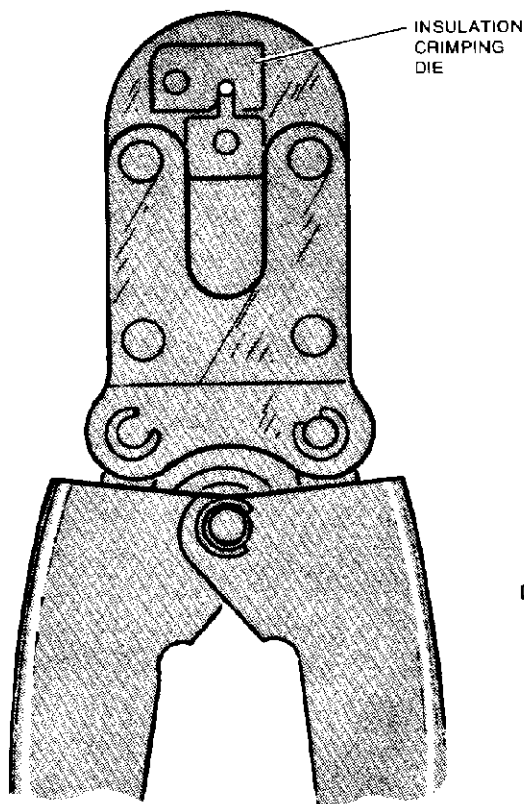
INSERT CRIMPED CENTER
CONTACT INTO BODY.



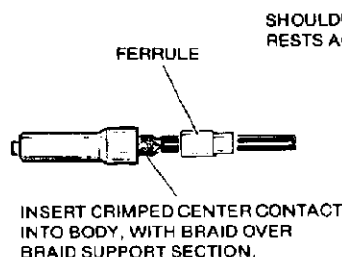
PLACE BACKSHELL
OF CONTACT BODY
ON CRIMPING DIE "B"

SHOULDER ON BODY
BUTTS AGAINST DIE

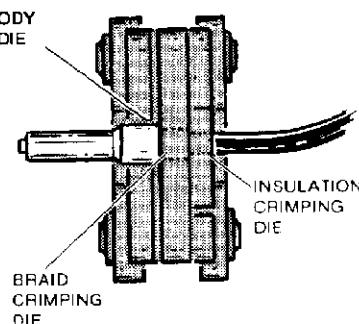
CRIMPING FERRULE WITH TOOL NO. 220020-4



1. Flare braid.
2. 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.
3. Position ferrule over braid and against shoulder on contact body.
4. Place assembly in crimping die of tool with shoulder of contact body against crimping die as shown.
5. Be sure cable extends from insulation crimping side of tool.
6. Close tool handles until CERTI-CRIMP releases to crimp ferrule.



INSERT CRIMPED CENTER CONTACT
INTO BODY, WITH BRAID OVER
BRAID SUPPORT SECTION.



BRAID
CRIMPING
DIE