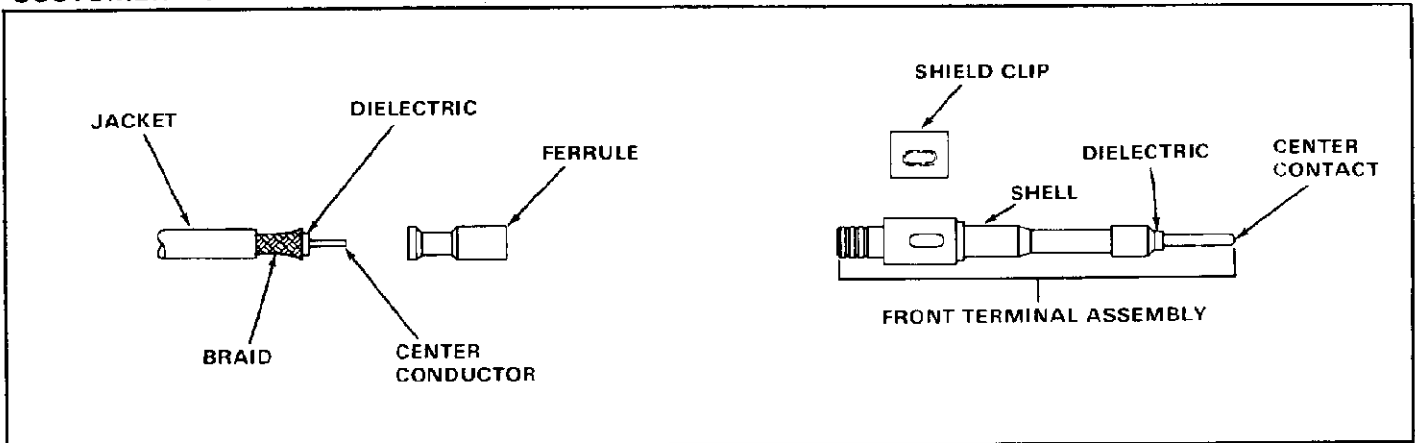


CUSTOMER HOTLINE 1 800 722-1111



CABLE					PATCHTIP				CRIMPING TOOL	
SIZE	JACKET OUTSIDE DIA	DIELECTRIC OUTSIDE DIA (Max)	CENTER CONDUCTOR		KIT*	FRONT TERMINAL ASSY	FERRULE	SHIELD CLIP	HAND TOOL	DIE ASSY
			AWG	DIA (Max)						
RG-174 or 188, 316, No. 26 or 24 Shielded	.085 to .110	.063	26 to 24	.025	424635-1	425442-1	328666	421260-2	402660	402954
No. 22 Shielded	.085 to .110	.063	22	.030	425888-1	425442-4	328666	421260-2	402660	402954
RG-195 180, or 180A	.150 to .165	.135	30 to 26	.024	424635-2	425442-5	328664	421260-2	402661	402955
RG-58	.187 to .199	.119	22 to 20	.0375	424635-3	425442-6	328663	421260-2	402658	402951

* EACH KIT INCLUDES FRONT TERMINAL ASSY, FERRULE, AND SHIELD CLIP.

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) provides assembly instructions for the AMP Patchboard shielded Patchtip Kits listed in Figure 1. These kits are recommended for making semi-permanent, shielded single-lead patchcords for front boards of AMP coaxial patchboard systems. Read this material thoroughly before starting assembly.

NOTE All dimensions on this sheet are in inches.

2. DESCRIPTION (Figure 1)

Each kit includes a front terminal assembly, a ferrule, and a shield clip. The front terminal assembly consists of an outer shell, a dielectric, and a center contact.

3. ASSEMBLY PROCEDURE

Refer to the chart in Figure 1 and select the appropriate patchtip kit according to the specified

dimensions of the cable being used. Proceed as follows:

- Slide ferrule onto cable — folded end first. Strip cable to the dimensions shown in Figure 2.

NOTE If production practice dictates, the ferrule may be installed after the stripping procedure.

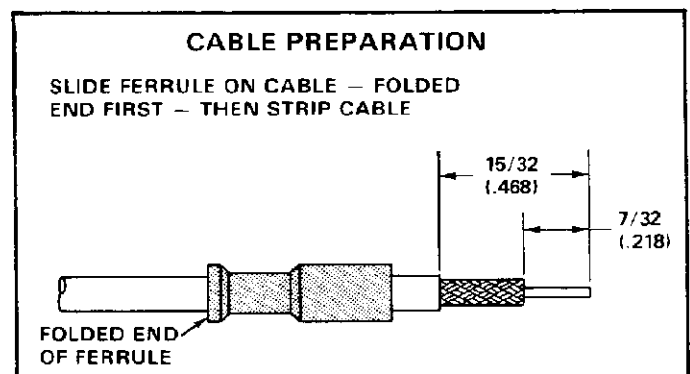


Fig. 2

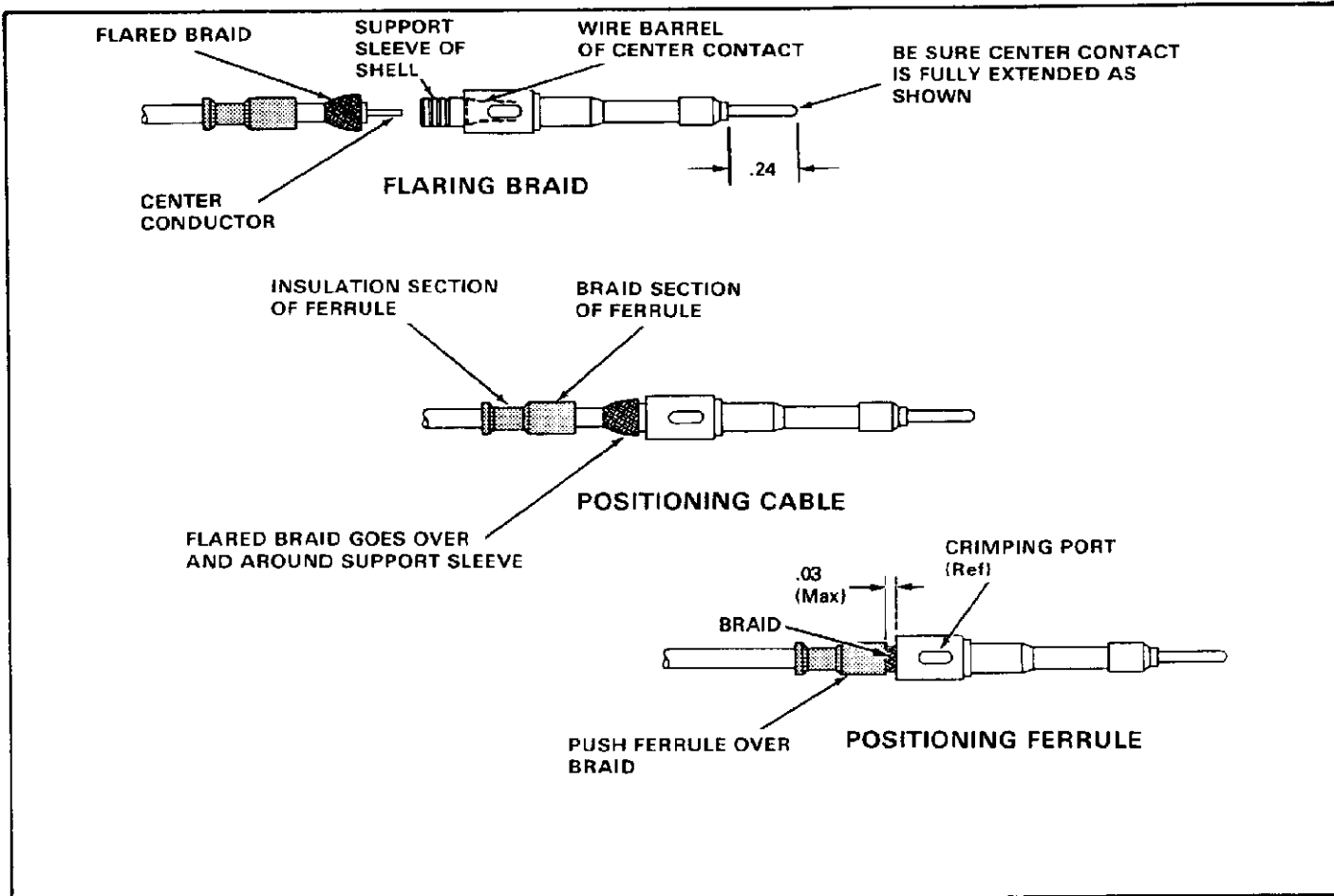


Fig. 3

2. Flare braid as shown in Figure 3. Insert center conductor into wire barrel portion of center contact as far as it will go. Make certain braid passes over and around support sleeve portion of shell.

CAUTION Be sure center contact is fully extended (see Figure 3).

3. Slide ferrule forward and over braid until it butts against shell, or until it bottoms on braid.
4. The assembly is now ready to be crimped.

4. CRIMPING PROCEDURES

Refer to the chart in Figure 1, and determine the appropriate hand tool or die assembly to be used.

The crimping section of the hand tool (or die assembly) features three crimping die sets (an upper and lower die per set). One die set crimps the wire barrel portion of the center contact, one set crimps the braid section of the ferrule, and one set crimps the insulation section of the ferrule. All three crimps are made at the same time. See Figure 4.

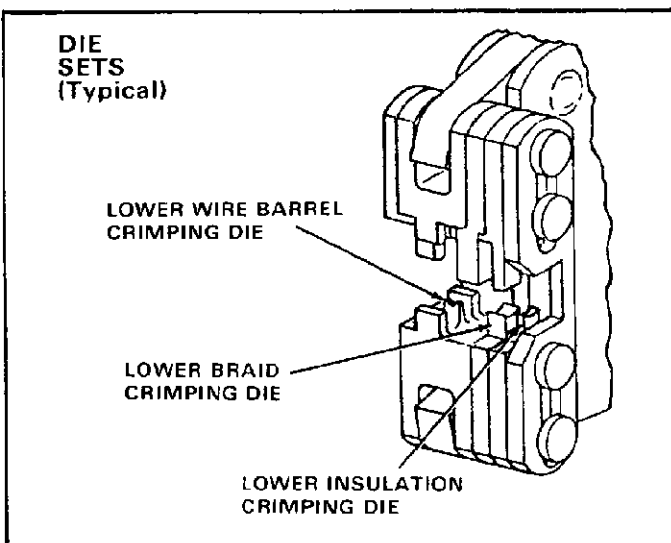


Fig. 4

A. Hand Tool Application (Figure 5)

The hand tools feature a CERTI-CRIMP★ ratchet which assures full crimping of the assembly. Once engaged, the ratchet will not release until the tool handles have been FULLY closed. Proceed as follows:

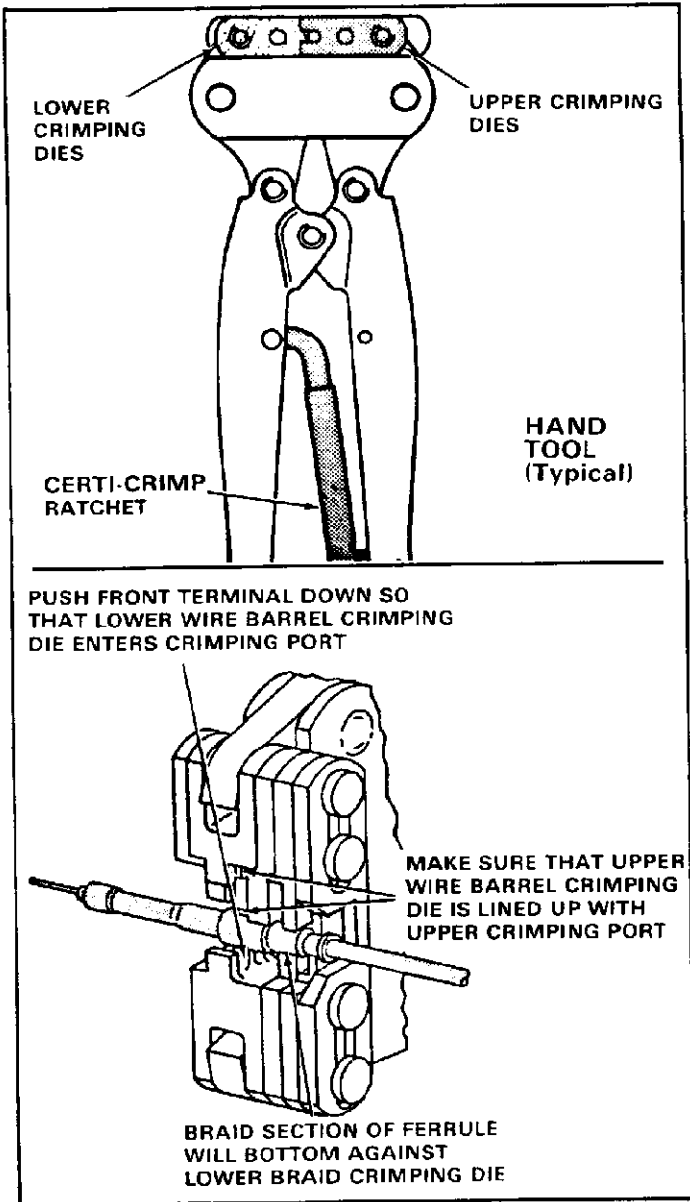


Fig. 5

1. Make sure ratchet is released — squeeze tool handles together and allow them to open FULLY. Position assembly in crimping section, making sure wire barrel crimping die set is aligned with front terminal crimping ports.
2. Push front terminal DOWN so that lower wire barrel crimping die enters lower crimping port, and braid section of ferrule is bottomed on lower braid crimping die.
3. Hold assembly in this position and squeeze tool handles together just enough so die sets hold assembly in place. Make certain upper wire barrel crimping die is aligned with upper crimping port.

4. Squeeze tool handles together until ratchet releases. Allow tool handles to open FULLY and remove crimped assembly from tool.
5. Check assembly to be sure it is properly crimped. Make certain wire barrel has been crimped without damaging crimping ports. Be sure cable and/or ferrule have not moved during crimping procedure. Test shield and center contact for conductivity.

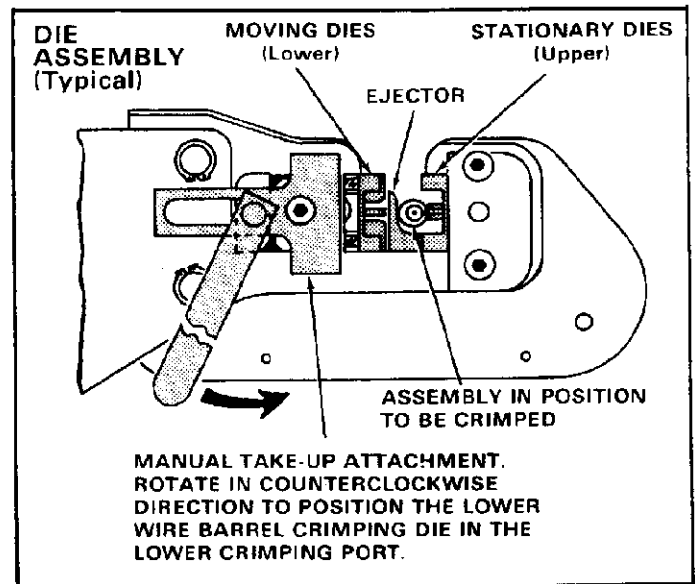


Fig. 6

B. Die Assembly Application (Figure 6)

The die assemblies feature an ejector to facilitate removal of the crimped assembly. The die assemblies are designed for use in AMP Hand Crimping Tool 69710, or AMPORTAPOWERS[®] Pneumatic Tool 69365-2. Install appropriate die assembly according to instructions packaged with tool — AMP Instruction Sheet IS 2095 packaged with hand tool 69710, or AMP Customer Manual CM 1983 packaged with pneumatic tool 69365-2. Proceed as follows:

1. Open die assembly FULLY. Position assembly (to be crimped) between ejector and stationary (upper) crimping dies, making sure wire barrel crimping die set is aligned with front terminal crimping ports.
2. Push terminal UP so that upper wire barrel crimping die enters upper crimping port, and braid section of ferrule is against upper braid crimping die.

NOTE

If using hand tool 69710, crimp the assembly according to Paragraph A (Hand Tool Application), Steps 3 through 5.

If using pneumatic tool 69365-2, continue with the following Steps 3 through 5.

3. Hold assembly in this position and rotate manual take-up lever **COUNTERCLOCKWISE** until moving (lower) wire barrel crimping die enters lower crimping port.

4. Depress pneumatic tool crimping button to crimp assembly. Release crimping button and remove crimped assembly from tool.

5. Check assembly to be sure it is properly crimped. Make certain wire barrel has been crimped without damaging crimping ports. Be sure cable or ferrule have not moved during crimping procedure. Test shield and center contact for conductivity.

5. ATTACHING SHIELD CLIP (Figure 7)

1. Place open side of shield clip against section of shell containing crimping port.
2. Push clip **DOWN** until it spreads open slightly and snaps over shell.
3. Rotate clip until it seats in crimping ports. The assembly is now ready for use.

AMP SHIELDED PATCHTIP KITS

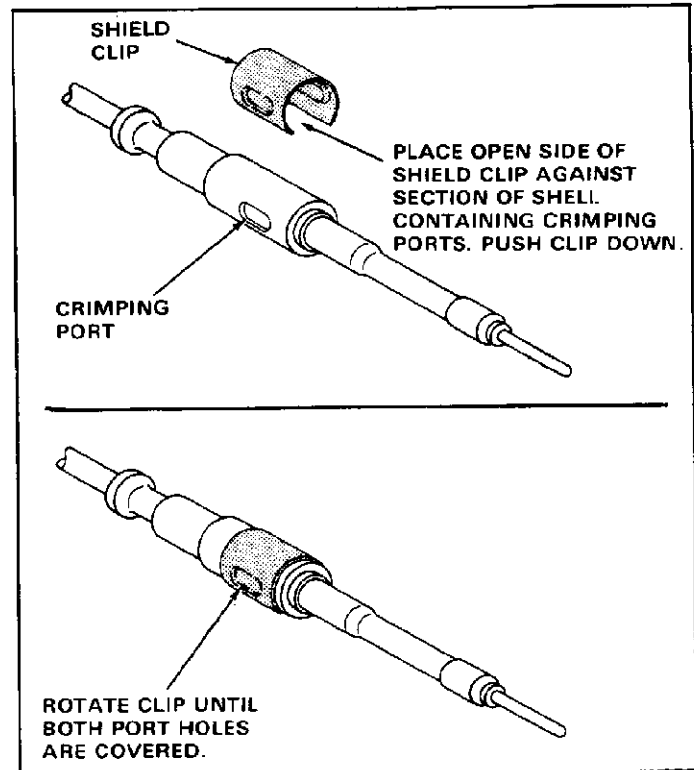


Fig. 7