

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the installation and use of AMP Locators 312644-1 and 312645-1, shown in Figure 1. These locators are *required* in AMP hand tools and pneumatic tools being used to crimp TNC Series Plug Connector 228179-3 to RG-402 (.141) semi-rigid coaxial cable, shown in Figure 2.

NOTE

The two locators are NOT interchangeable and MUST be used in the appropriate tool. Locator 312644-1 is used with AMP Hand Crimping Tool 59980-1. Locator 312645-1 is used with AMP Pneumatic Tool 59964-1.

Refer to IS 6788 for locator installation and application procedures to be used with AMP Hand Crimping Tool 59980-1. Refer to IS 6744 for locator installation and application procedures to be used with AMP Pneumatic Tool 59964-1. Read these instructions and the other references thoroughly before proceeding.

NOTE

All dimensions on this sheet are in inches.

2. DESCRIPTION (Figure 1)

Each locator features a plug end with a machined hole designed to position the prepared cable/assembly for crimping. The TNC Series connector (228179-3) features a *plug body assembly* with captive center contact and an *adapter assembly* which is crimped to RG-402 semi-rigid cable. After termination, the cable/adapter assembly is threaded into and secured to the plug assembly. Finished plug assemblies mate with TNC Series jack connectors.

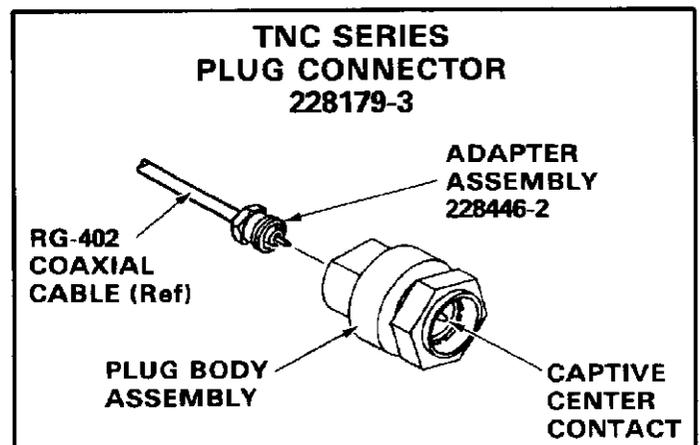


Fig. 2

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3. HAND CRIMPING APPLICATION (With Locator 312644-1)

Prepare the RG-402 cable according to instructions given in IS 6788. To set up AMP Hand Tool 59980-1 with Locator 312644-1 for crimping TNC Plug 228179-3 to the cable, proceed as follows:

1. Loosen locator locking screw and insert locator in cavity of tool head. See Figure 3. After ensuring that locator is bottomed, tighten screw.

CAUTION

Do NOT use locators packaged with the tool to crimp TNC Plug 228179-3, or improper terminations will result.

2. Install die set 312253-1 (for RG-402 cable) in the tool, making sure chamfer on each die is oriented as shown.
3. To prepare connector for crimping, slide adapter assembly onto cable, flange-end first.
4. Place adapter/cable assembly onto locator of tool. Make sure that center conductor is inserted in locator hole, and that connector is seated squarely on locator.
5. Squeeze tool handles to crimp adapter assembly to cable.
6. Thread and secure crimped assembly to plug body assembly.

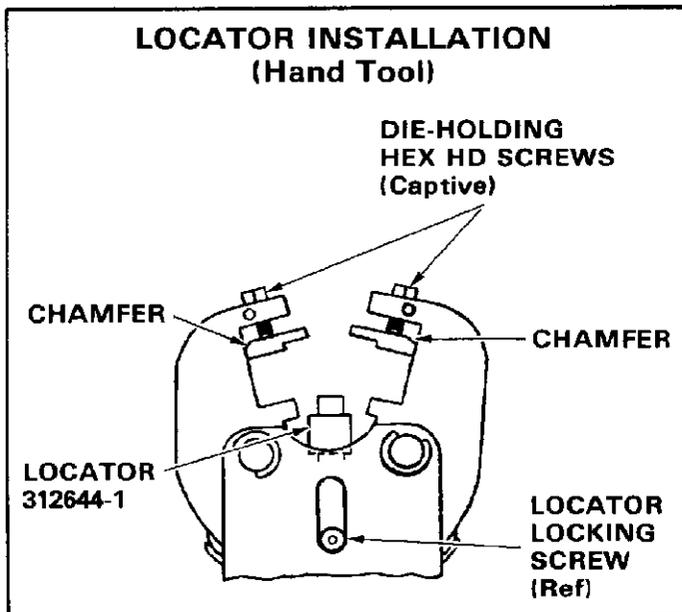


Fig. 3

4. MACHINE CRIMPING APPLICATION (With Locator 312645-1)

Refer to IS 6744 supplied with AMP Pneumatic Tool 59964-1 and follow cable preparation and die installation procedures.

CAUTION

Do NOT use locators packaged with the pneumatic tool to crimp TNC Plug 228179-3, or improper terminations will result.

Insert Locator 312645-1, shown in Figure 1, by carefully following the procedures given in IS 6744. When installing the locator, ensure that:

1. The jack end of the locator is inserted into the tool. (Note that the jack end is the same as the other locators packaged with the tool.)
2. The flat side of the locator faces UP. See Figure 4.
3. The locator is firmly bottomed in the tool before tightening setscrew.

After tool setup, apply TNC Plug 228179-3 to RG-402 semi-rigid cable, as follows:

1. Slide adapter assembly onto cable, flange-end first.
2. Follow application and crimping procedures provided in IS 6744. Ensure that center conductor is inserted in hole of locator, and that cable is bottomed.
3. After crimping, thread and secure terminated assembly to plug body assembly.

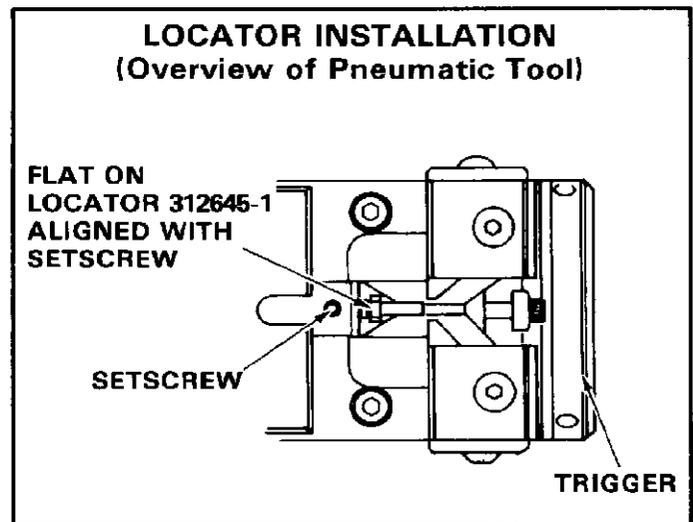


Fig. 4