

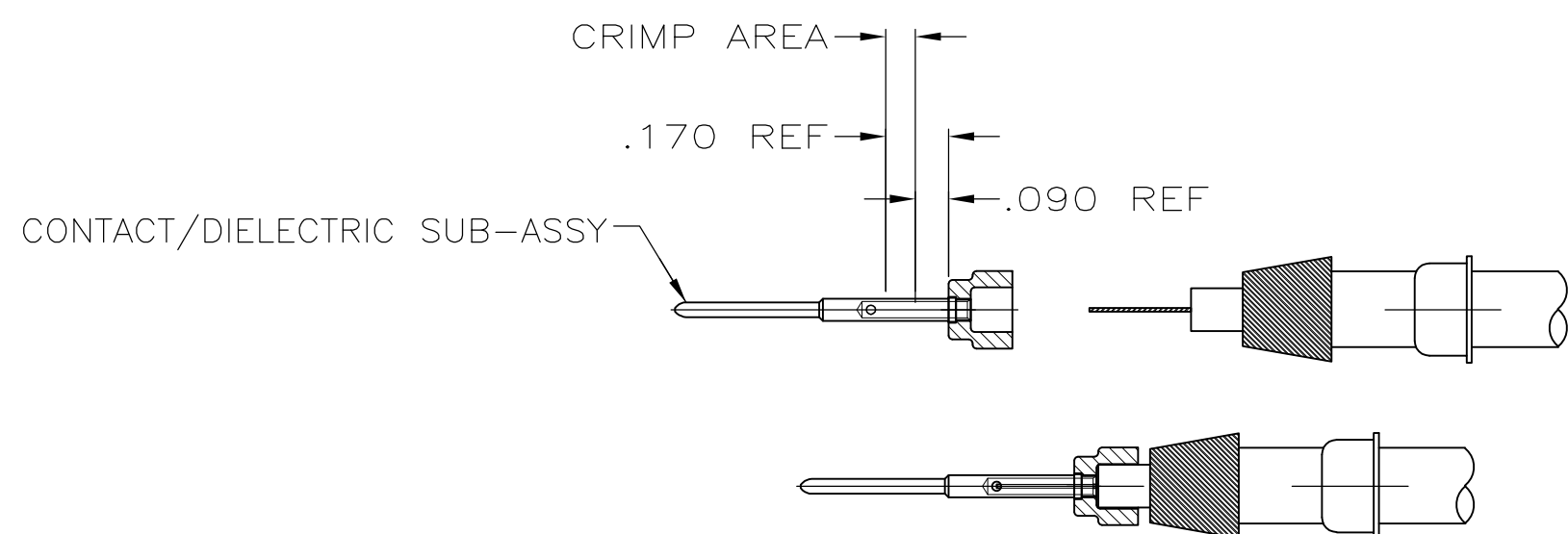


FIGURE #1

2. CRIMPING:
- CENTER CONDUCTOR-- CRIMP CENTER CONDUCTOR USING DANIELS MFG CORP 4-8 INDENT HANDTOOL M22520/2-01. THE HANDTOOL CRIMP SELECTOR SHOULD BE SET TO #5. NO LOCATOR IS NECESSARY. INSERT THE CONTACT/DIELECTRIC SUB-ASSEMBLY INTO HANDTOOL. THE DIELECTRIC WILL POSITION THE CENTER CONTACT. INSERT THE CENTER CONDUCTOR INTO CONTACT WIRE BARREL. THE TIP OF THE STRIPPED WIRE SHOULD BE VISIBLE IN THE WIRE BARREL SIGHT HOLE. CRIMP AND REMOVE CENTER CONTACT. SEE FIGURE #3.
 - INSERT THE CRIMPED CENTER CONTACT AND CABLE INTO OUTER CONTACT BODY. SLIDE FERRULE INTO OUTER CONTACT BODY CAPTURING TRIMMED BRAID BETWEEN FERRULE AND SHELL BODY.
 - FERRULE CRIMP-- PLACE CONTACT ASSEMBLY INTO AMP HAND CRIMPING TOOL 354940-1 & DIE SET 91907-1 AND BOTTOM FRONT END OF CRIMP END FERRULE ON THE CRIMPER. COMPLETE CRIMPING AND RELEASE CONTACT. SEE FIGURE #4.
 - AFTER CRIMPING, THE DIAMETER ACROSS THE ϕ .200 DIMENSION, SHOWN IN FIGURE #4 SHOULD BE .273--.276.

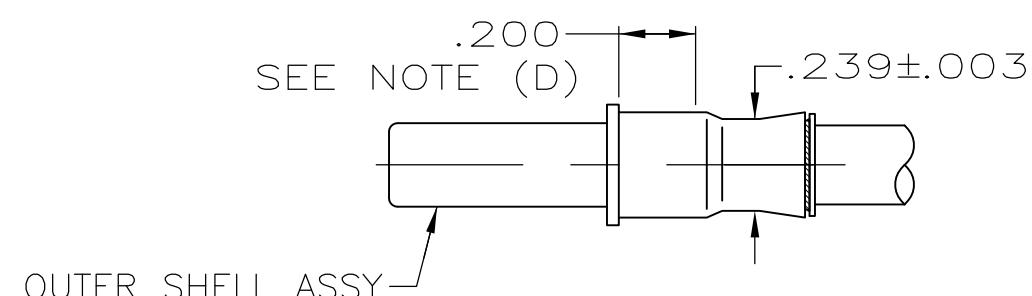
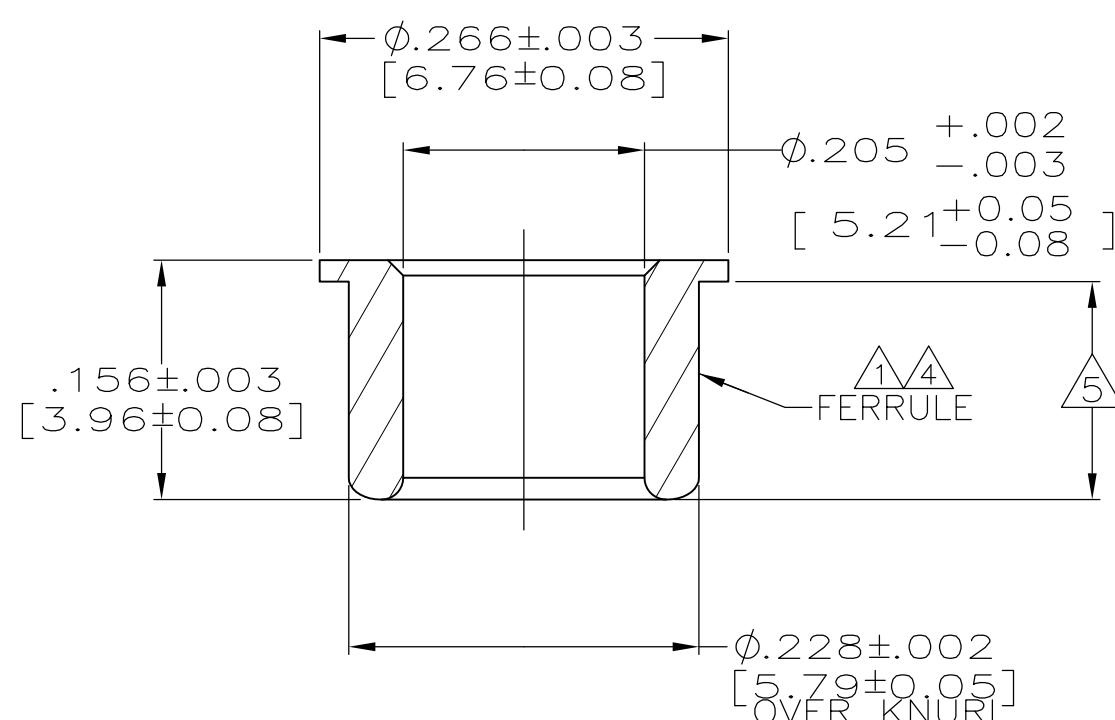
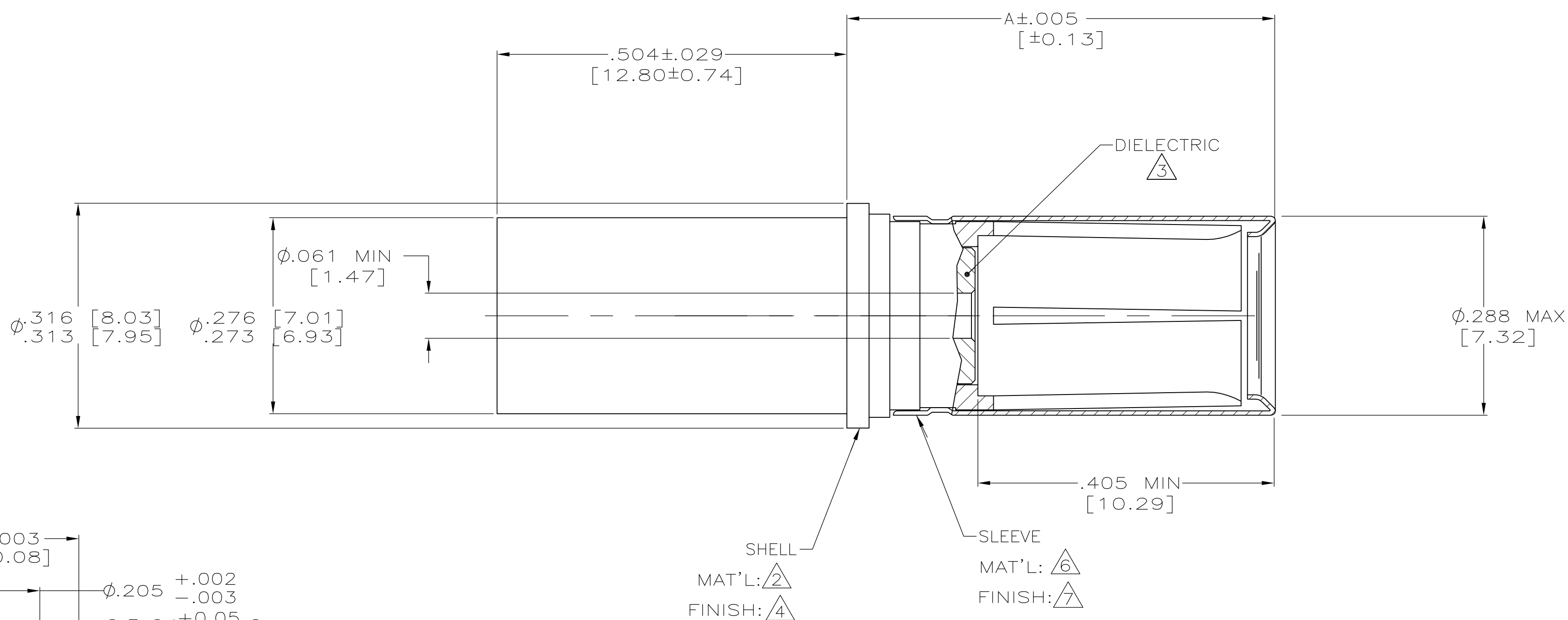
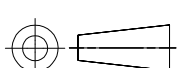


FIGURE #4

SCALE 2:1



- ① MAT'L: BRASS PER ASTM-B-16
- ② MAT'L: BERYLLIUM COPPER PER ASTM-B-196.
- ③ MAT'L: PTFE PER ASTM-D-1710.
- ④ FINISH: GOLD PLATE PER MIL-G-45204, TYPE 1, GRADE C,
CLASS 1 OVER NICKEL .000050 [0.0013] THK PER QQ-N-290, CLASS 2.
- ⑤ 160 DP. FULL DIAMOND KNURL OVER THIS LENGTH.
- ⑥ MAT'L: STAINLESS STEEL PER QQ-S-766.
- ⑦ FINISH: PASSIVATE PER QQ-P-35.

USED IN HIRF 120T2 INSERT		RG-142		.669 [16.99]		1218821-2	
—		RG-142		.595 [15.11]		1218821-1	
REMARKS		CABLE		DIM A		PART NUMBER	
THIS DRAWING IS A CONTROLLED DOCUMENT.		DIM 8-30-00 C.C.THOMAS CHK R.GROSS 8-30-00 APVD R.GROSS 8-30-00 PRODUCT SPEC APPLICATION SPEC		 TE Connectivity			
DIMENSIONS: INCHES 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± — 1 PLC ± — 2 PLC ± — 3 PLC ± .005 [0.13] 4 PLC ± — ANGLES ± —		NAME COAX SOCKET CONTACT ASSY REAR RELEASE, SIZE 8			
MATERIAL SEE CALLOUTS		FINISH SEE CALLOUTS		WEIGHT — SIZE A1 CAGE CODE 00779 DRAWING NO. C-1218821		RESTRICTED TO — SCALE 8:1 SHEET 1 of 1 REV F	
CUSTOMER DRAWING							

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[1218821-1](#)