

NOTE: Some connectors are supplied with a step-down ferrule. When assembling the step-down ferrule over the cable braid, make sure the large diameter end faces the plug body.

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of AMP* SHV COAXICON Plug (Dual Crimp Type) Connectors 51426-[] designed to provide shielded disconnects for high-voltage applications. The plug connectors accept a wide range of coaxial cables and can be crimped using AMP Double Action Hand Tool 220022-1 (408-6872), PRO-CRIMPER* II Hand Tool Frame 354940-1 (408-9930) fitted with appropriate die assembly, Hand Crimping Tool 69710-1 (408-2095), or 626 Pneumatic Tooling Assemblies 189721-[] or 189722-[] fitted with appropriate tool holder or adapter, crimping head, an die set (409-5862).

For a cross-reference of connector-to-cable and applicable tools and die assemblies, refer to AMP Catalog 82074. For detailed information on the tooling, refer to the applicable instructions (408- or 409-series).

NOTE Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue are provided in Section 4, REVISION SUMMARY.

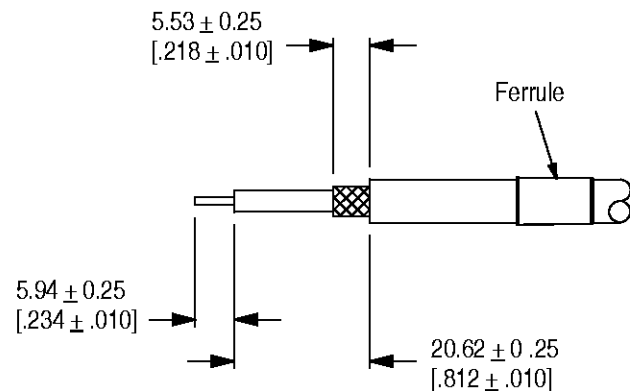
2. DESCRIPTION (Figure 1)

The plug connectors consist of a plug body with a bayonet locking coupling, a center contact, and a ferrule. Some connectors are supplied with a step-down ferrule and a tubing. The tubing is slipped over the cable dielectric before the center contact is crimped. In this use, the tubing compensates for small diameter cable dielectrics.

3. ASSEMBLY PROCEDURE

NOTE If using a step-down ferrule, slide it onto the cable with the small opening first.

- Slide ferrule onto unstripped cable; then strip cable using the recommended strip-length dimension in Figure 2. DO NOT nick or cut cable braid. Center conductor must be straight and free of burrs.



NOTE: Not to Scale

Figure 2

NOTE For connectors supplied with tubing, slip tubing over the cable dielectric before applying center contact.

- Insert center conductor into contact until the shoulder of the contact is against the inner dielectric of the cable. Refer to Figure 3.
- Crimp center contact using the recommended crimping tool. Refer to the instruction sheet packaged with the tool for detailed crimping instructions. See Figure 3.
- Flare cable braid so that it fits over and around the support sleeve of the plug assembly.

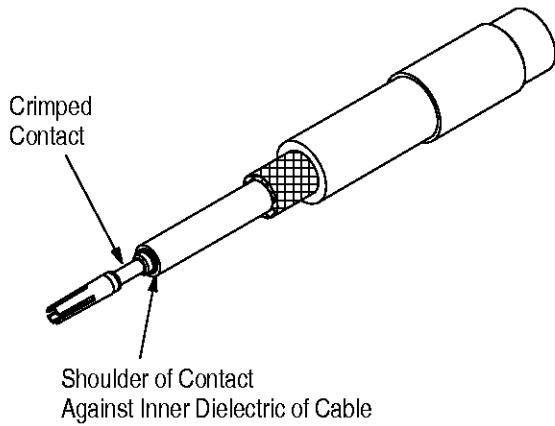


Figure 3

5. Insert crimped contact into plug body until it snaps into place. Make sure that the cable braid is positioned over the connector support sleeve. Pull back gently on the cable to ensure that the contact is held in place by the internal locking feature. See Figure 4.

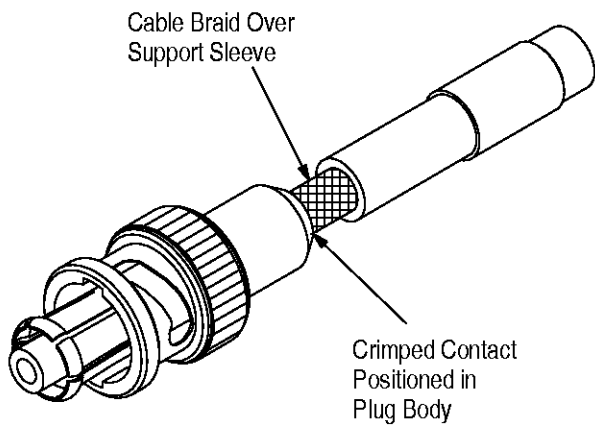


Figure 4

6. Slide ferrule forward over cable braid until it is positioned against the shoulder of the plug body. Crimp the ferrule using recommended crimping tool. Refer to the instruction sheet packaged with the tool for specific crimping instructions. See Figure 5.

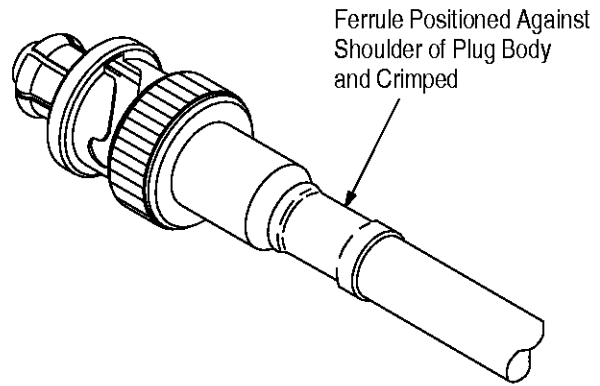


Figure 5

4. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made:

Per EC 0990-1112-98

- Added tubing and step-down ferrule in Figure 1
- Added notes regarding tubing and step-down ferrule to Sections 2 and 3
- Updated crimping tools in Section 1