



AMP ★ LOCATORS 220221-2 AND -3
FOR AMP HAND CRIMPING TOOL 59980-1

Instruction Sheet
IS 9205
RELEASED 1 · 30 · 86
REDUCED FOR PACKAGING

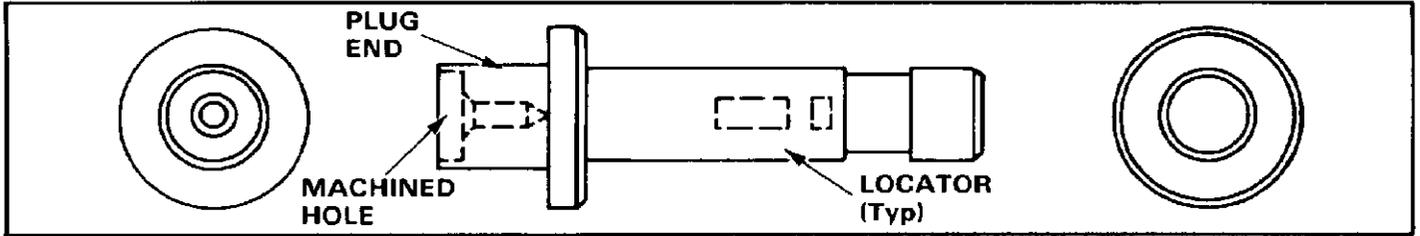


Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Locators 220221-2 and -3 which are designed for use in AMP Hand Tool 59980-1. The locators are *required* for positioning specific SMA, TNC, and N Series RF connectors in the tool for crimping onto the semi-rigid coaxial cables listed in Figure 2. Read these instructions and IS 6788 (which is packaged with the tool and which covers cable preparation and use of the tool) before proceeding.

2. DESCRIPTION (Figures 1 and 2)

Each locator features a plug end with a machined hole which positions the connector/cable assembly for crimping. The SMA Series connectors feature a plug body assembly with a captive center contact which is crimped to RG-402 or RG-405 cable. The TNC and N Series plug and jack connector kits feature an adapter assembly which is crimped to RG-405 cable. For all applications, the semi-rigid cable must be properly stripped and pointed in accordance with dimensions given in IS 6788.

CAUTION Select the correct combination of locator, die set, cable, and connector in accordance with the chart in Figure 2 — or improper terminations will result.

NOTE All dimensions on this sheet are in inches unless otherwise specified.

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HAND TOOL LOCATOR NO.	AMP PRODUCT LINE/ TYPE OF CONNECTOR	CONNECTOR PART NO. (Mil-C 39012 No.)	
		RG-402 (.141) CABLE DIE SET 312253-1	RG-405 (.086) CABLE DIE SET 312253-2
220221-2	SMA SERIES		
	Plug W/Center Contact (Mil B)	227743-1 and -2 (79-3104)	227868-1 and -2 (79-3103)
	Plug W/Center Contact (Mil F)	228634-1 and -2 (79-3308)	228639-1 and -2 (79-3207)
	Wthprf Plug W/Center Contact and W/Safety Holes	221328-1 221328-2	221330-1 221330-2
	Plug W/Center Contact and W/Safety Holes (Mil B)	227743-3 and -4 (79-3004)	227868-3 and -4 (79-3003)
	Plug W/Center Contact and W/Safety Holes (Mil F)	228634-3 and -4 (79-3208)	228639-3 and -4 (79-3207)
	N SERIES		
	Front-Mounted Jack Assembly*	---	228448-2
	Rear-Mounted Jack Assembly*	---	228658-2
	Plug Connector Assembly*	---	228440-1
TNC SERIES			
Plug Connector Assembly*	---	228179-4	
Front-Mounted Jack Assembly*	---	228456-2	
Rear-Mounted Jack Assembly*	---	228507-1	
220221-3	SMA SERIES Plug (Short) W/Center Contact	---	221447-1 through -4 (Optional Die Set 313113-1 Available)

*KIT INCLUDES ADAPTER ASSEMBLY 228446-1.

Fig. 2

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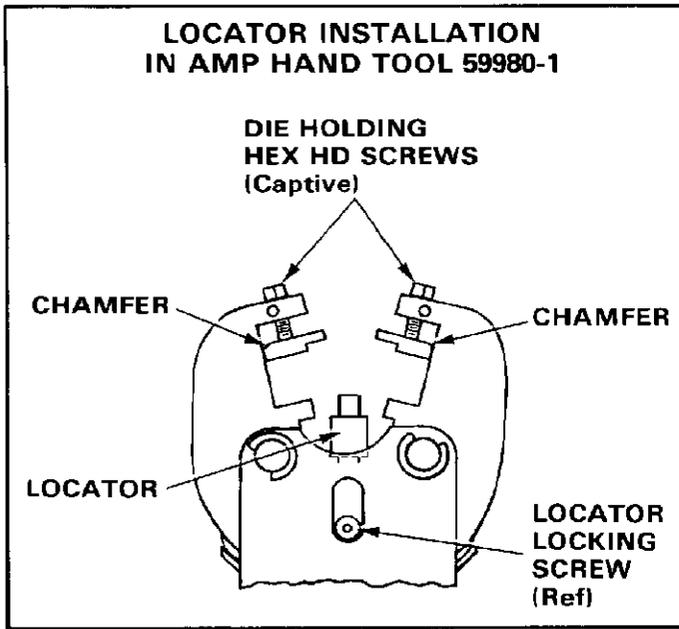
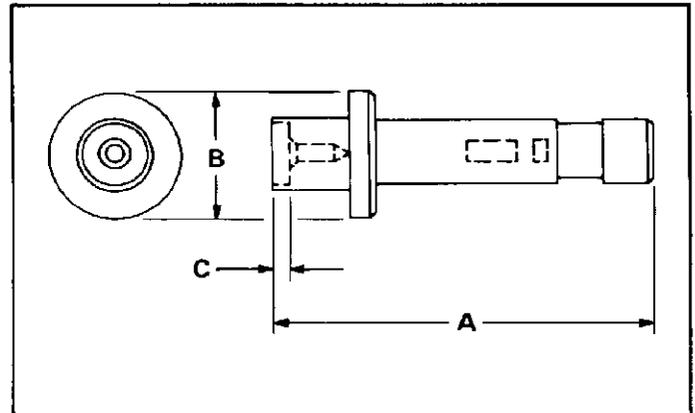


Fig. 3

3. LOCATOR INSTALLATION

To install AMP Locator 220221-2 or -3 in Hand Tool 59980-1, refer to IS 6788 and Figure 3 and proceed as follows:

1. Loosen locator locking screw and insert locator into cavity of tool head. Make sure that the machined hole in the locator faces UP, as shown in Figure 3.
2. After ensuring that locator is bottomed in tool cavity, re-tighten screw.
3. Refer to IS 6788 for die setup and application procedures. For SMA plug 221447 applications using optional die set 313113-1, refer to IS 9210 packaged with the die set.



LOCATOR NUMBER	DIMENSION			WEIGHT
	A	B (Dia)	C	
220221-2	.991	.360	.045	.5 oz.
220221-3	1.093	.360	.045	.5 oz.
ENGINEER			DATE	
Lloyd Osman			1 - 30 - 86	

Fig. 4

4. TOOLING CERTIFICATION

The locators listed in this instruction sheet should be certified with the information provided in Figure 4. AMP recommends that the locator be inspected immediately upon its arrival at your location, and at regularly scheduled intervals, to ensure that the locator has not become worn or damaged.

Locators may be purchased by ordering by part number from:

AMP Incorporated
 Customer Repair
 1523 North 4th Street
 Harrisburg, PA 17102-1604

or a wholly-owned subsidiary of AMP Incorporated.