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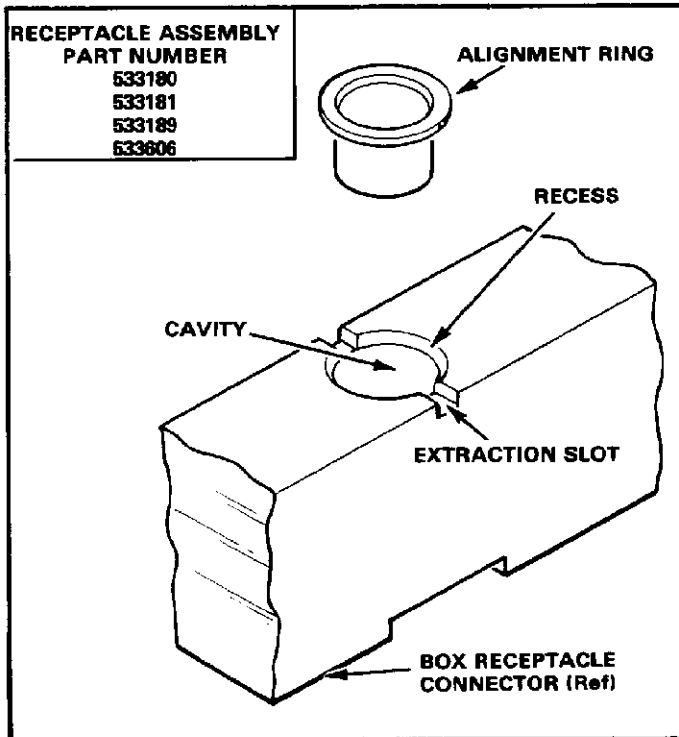


Fig. 1

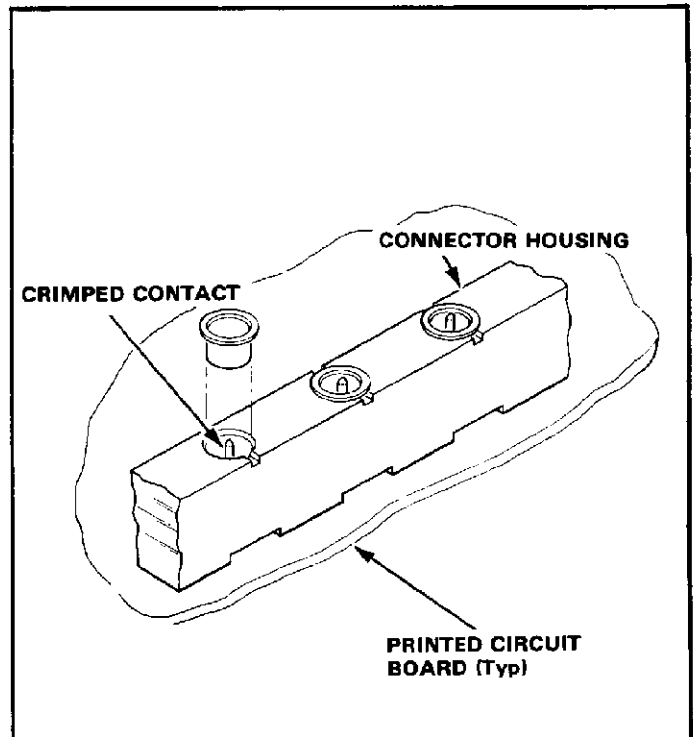


Fig. 2

## 1. INTRODUCTION

This instruction sheet (IS) covers installation of AMP Alignment Ring 222000-1 into microminiature coaxial contact cavities in AMP 750 and 1000 Series Box Receptacle Assemblies. The alignment ring provides proper coaxial contact alignment in the connector cavity. Refer to AMP instruction sheet IS 2923, AMP MULTIPLE COAXICON ★ MICROMINIATURE PIN AND SOCKET CONTACTS, for additional information regarding the crimping of coaxial contacts.

Read these instructions thoroughly before installing alignment rings in the coaxial contact cavities.

## 2. DESCRIPTION (Figure 1)

The box receptacle assemblies listed in Figure 1 are designed for installation of the alignment ring(s) in the coaxial contact cavities. The coaxial contact cavities of the receptacles feature a recess for the flange of the alignment ring and extraction slots for removal of the alignment ring, if necessary. One alignment ring will be provided with each coaxial contact purchased for use in the listed receptacle assemblies.

The outer configuration of the alignment ring and the recess of the coaxial contact cavity in the connector housing are identical. When positioned in the hous-

ing, the alignment ring forms a firm support for the coaxial contact.

## 3. INSTALLATION PROCEDURE (Figure 2)

1. Refer to IS 2923 for contact crimping procedure and install the coaxial contact(s) in the connector housing.
2. Grasp the alignment ring by the flange and position the sleeve between the inner wall of the contact cavity and the outside of the coaxial contact body.
3. Gently push the alignment ring into position by pressing on the flange until it is seated in the cavity. The flange of the alignment ring should be flush with, or slightly below, the mating face of the connector housing.
4. Repeat Steps 2 and 3 for each coaxial contact to be installed in connector housing.

**NOTE**

*For solder-type coaxial contacts, place the alignment ring in the contact cavity prior to hand or wave soldering.*

## 4. REMOVAL PROCEDURE

Removal of alignment ring(s) is required only when repair

or replacement of a coaxial contact becomes necessary. Obtain AMP Extraction Tool 58327-1 and, referring to Figure 3, proceed as follows:

1. Gently insert the extraction tool tips into the slots on the edges of the connector housing and elevate the flange of the alignment ring until it is above the mating face of the connector.

2. Grasp the flange of the alignment ring and lift it out of the coaxial contact cavity.

After repairing the contact, replace the alignment ring according to the procedure described in Paragraph 3. If replacing a damaged contact, you may elect to discard the used alignment ring and replace it with the new one which is packaged with the replacement contact.

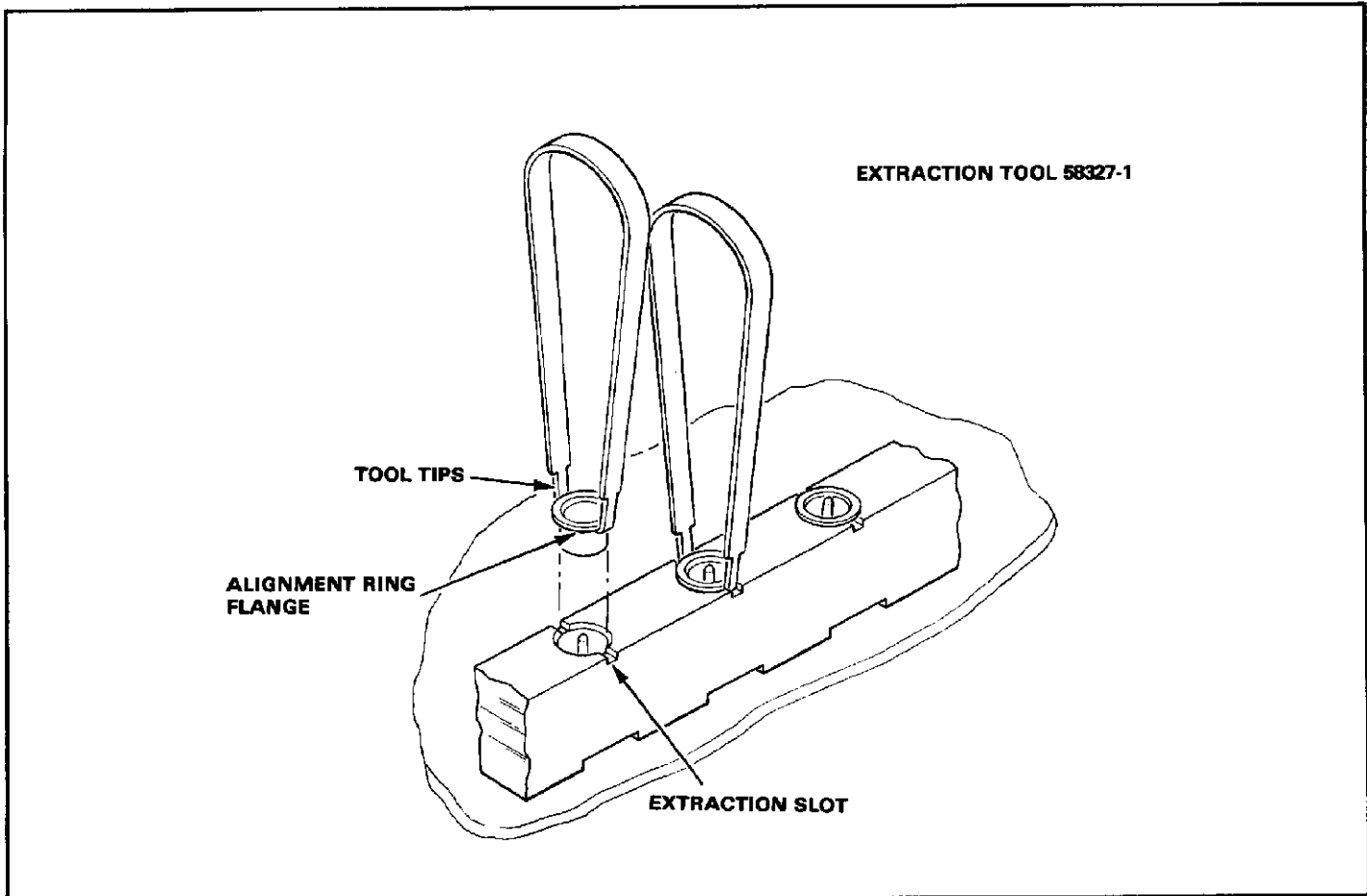


Fig. 3

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