

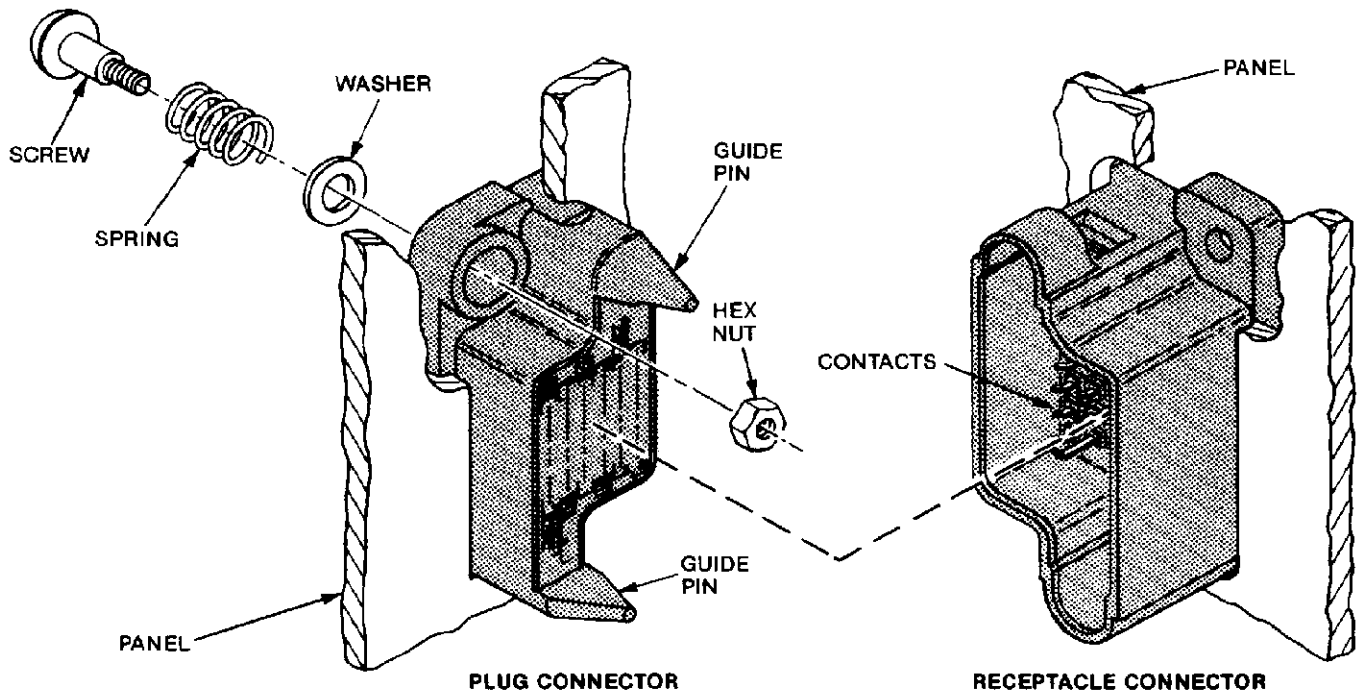
AMPAMP INCORPORATED
Harrisburg, Pa. 17105**AMP* HIGH-DURABILITY
DRAWER CONNECTORS (HDDC)**

Instruction Sheet

IS 9163

RELEASED

11-19-86



TYPE OF CONNECTOR	HOUSING	CONTACTS	HARDWARE KIT	TOOLING		
				HAND	MACHINE*	APPLICATOR
25-Position	213271 (Plug) 213272 (Rcpt)	66806 66807 66808	213283-2	90423-1	565435-4	567237-2
50-Position	213277 (Plug) 213278 (Rcpt)	66806 66807 66808	213283-1			

* AMP-O-LECTRIC* MODEL "K" MACHINE.

Fig. 1**1. INTRODUCTION**

This instruction sheet (IS) covers selection and assembly of the AMP High-Durability Drawer Connectors (25 and 50 positions) listed in Figure 1. Read these instructions thoroughly before assembling the connectors.

NOTE

All dimensions on this instruction sheet are in inches.

2. DESCRIPTION (Figure 1)

The plug and receptacle connectors consist of a housing plus the contacts and wires. The connectors are used for panel-mounted applications. Every connector component listed above must be ordered separately.

Each plug housing features two guide pins which are molded into the plug housing and assist when

mounting the connectors into "blind" applications. Also featured are mounting holes which are used for the attaching hardware.

The hardware kits listed in Figure 1 feature a flat washer, a spring, and a shoulder screw. The kit can be attached to the plug connector by using a screwdriver and hex wrench. Hex nuts for the plug connector are sold separately.

Receptacle hardware items are determined by the customer and can usually be assembled with a screwdriver and hex wrench.

There are three types of contacts used in the housings. The contacts are crimped to wires with a range of 22 AWG to 18 AWG. Refer to the appropriate instruction sheet or customer manual for information on crimping the contacts.

NOTE

The maximum insulation diameter of the wire should NOT be greater than .014 in.

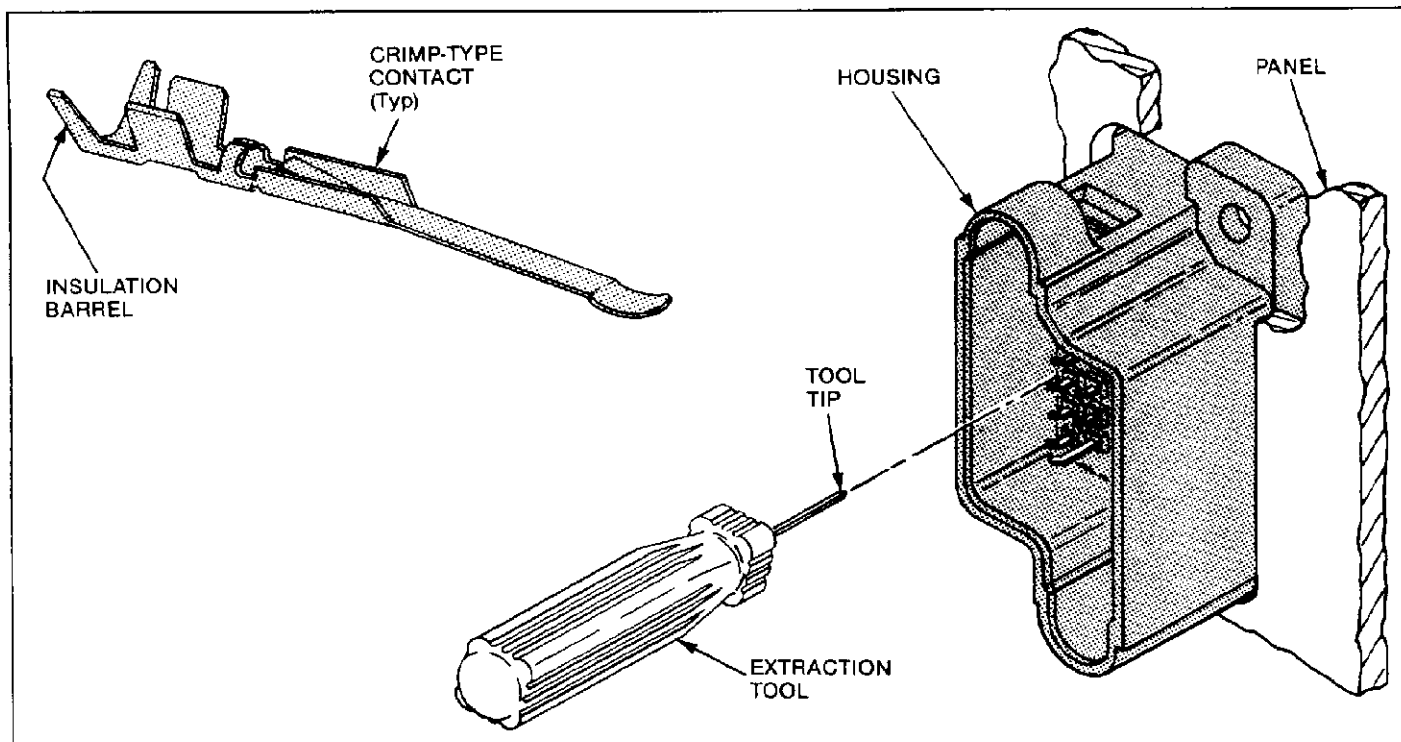


Fig. 2

3. CONTACT INSERTION AND EXTRACTION

A. Insertion (Figure 2)

Normally, an insertion tool is NOT needed to insert these contacts. When inserting the contacts, grip the wire directly behind the contact and push the contact straight into the back of the connector until the contact bottoms. Pull back lightly on the wire to make sure the contact is locked in position.

B. Extraction (Figure 2)

AMP Extraction Tool 91111-1 is designed to release contacts through the front of the connector, and extract them from the back of the connector. Refer to AMP Instruction Sheet IS 7679, which is packaged with the tool, for specific extraction instructions.

4. ASSEMBLY PROCEDURE (Figure 1)

A. Plug Hardware Kit

1. Assemble spring and washer to screw as shown in Figure 1, and assemble these items into the mounting hole on the housing flange.
2. Slide screw assembly into panel mounting hole.
3. Secure entire assembly with a hex nut into a tapped hole in panel.

4. Torque the assembly until shoulder on screw bottoms on cabinet panel.

B. Receptacle Assembly

Torque the hardware (screw and hex nut) used with the receptacle connector until the appropriate tightness is reached to prevent movement of the drawer panel. (The hardware kit is not used with the receptacle connector.)

5. PANEL CUTOUT (Figure 3)

The connector can be installed or removed from either the FRONT or BACK of the panel. The plug connector is usually mounted into the cabinet panel while the receptacle connector is usually mounted into the drawer panel.

Refer to the dimensions in Figure 3 and make the appropriate panel cutouts according to the particular connector being used.

6. TYING CABLE

After assembling the connector, secure the wire bundles with tie wrap according to the dimensions shown in Figure 4.

NOTE

Do NOT bend the cable between the first cable tie and the connector or damage to the contacts could result. Bend the cable AFTER the first tie wrap.

PANEL CUTOUTS

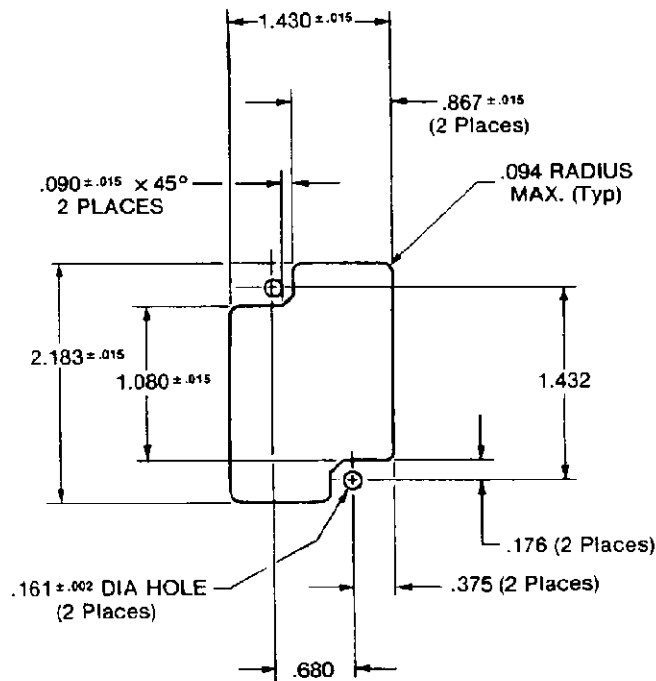
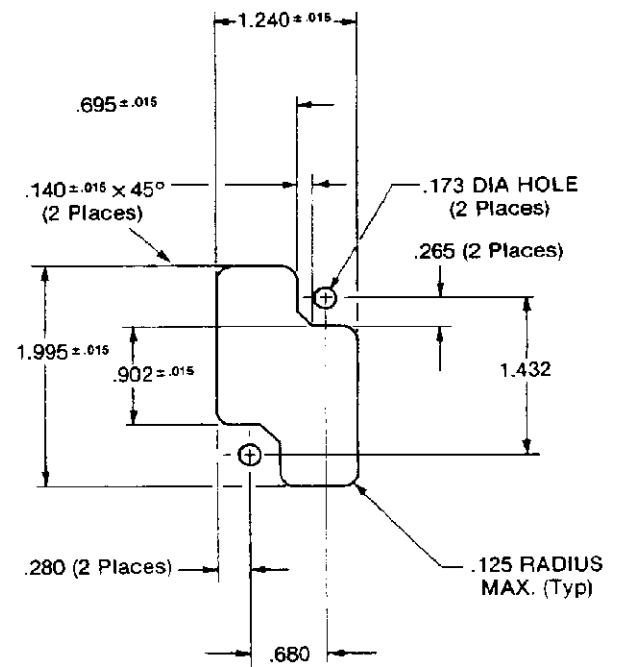
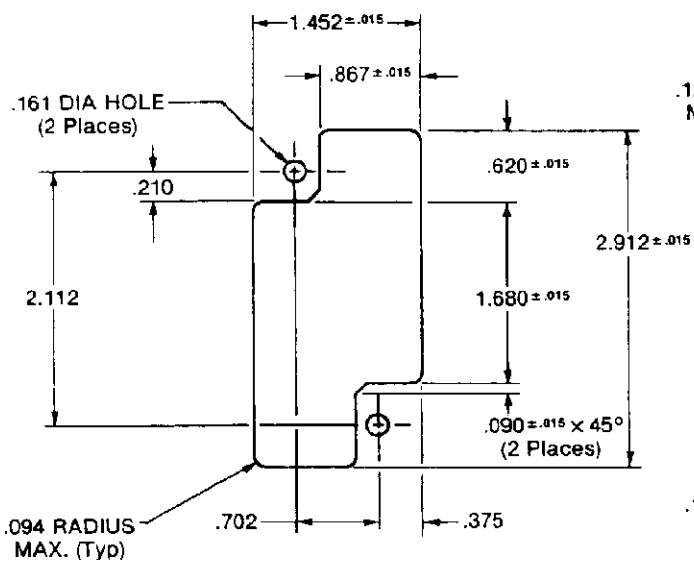
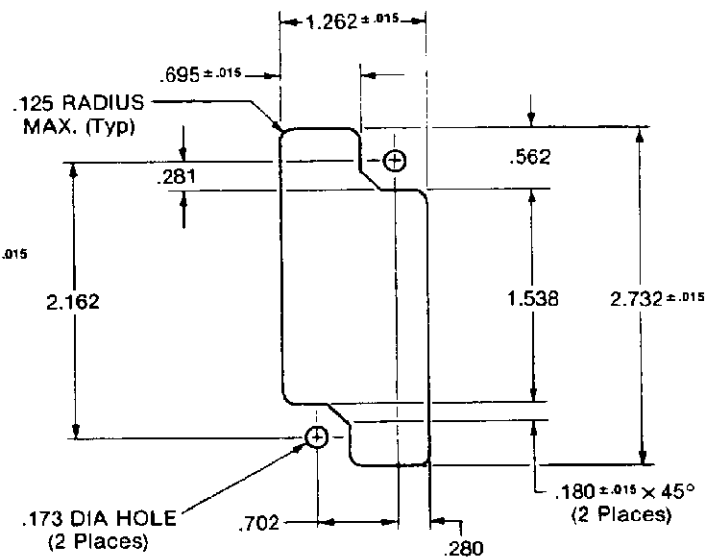
25-POSITION
PLUG HOUSING25-POSITION
RECEPTACLE HOUSING50-POSITION
PLUG HOUSING50-POSITION
RECEPTACLE HOUSING

Fig. 3

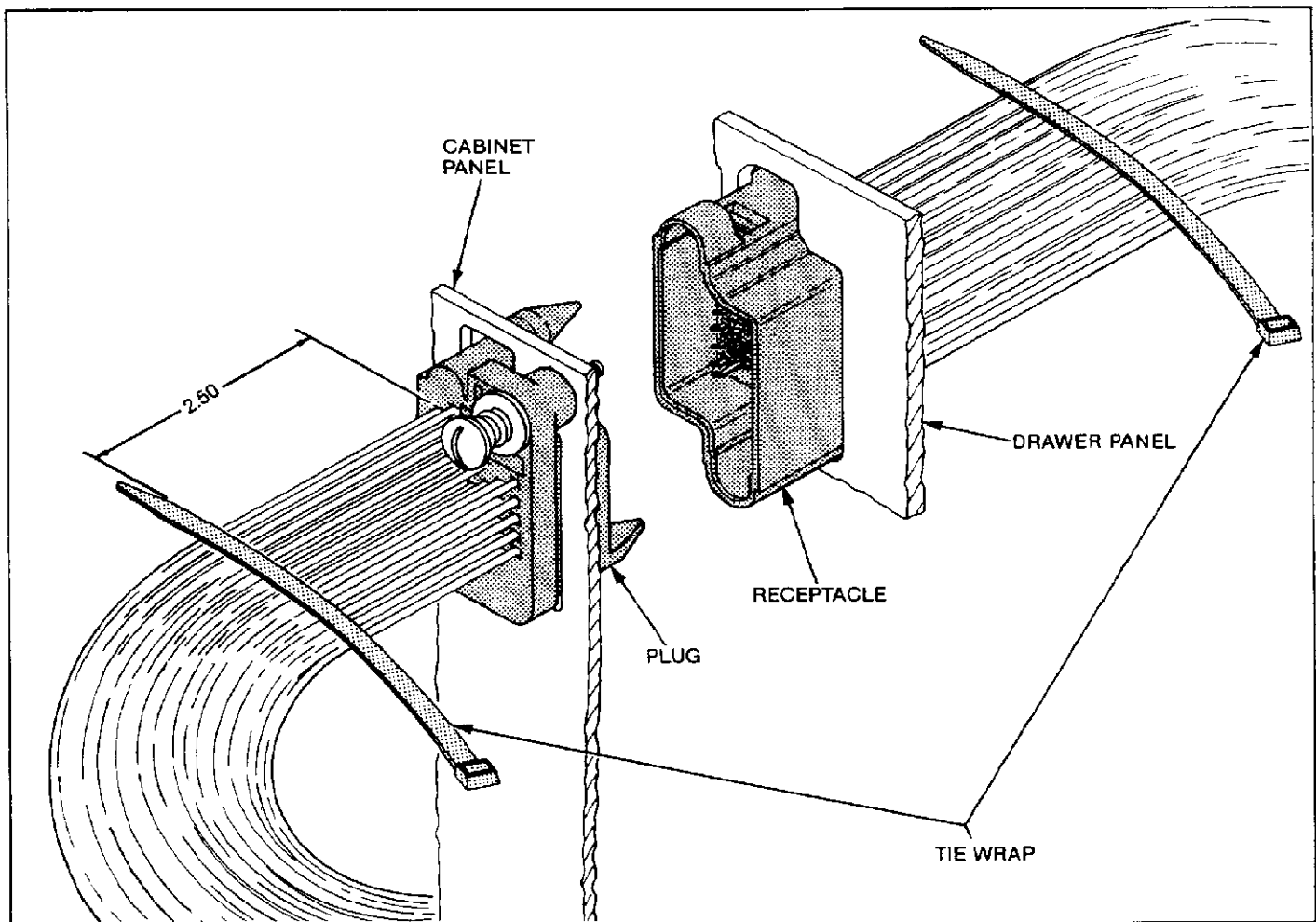


Fig. 4