

Fig. 1

**1. INTRODUCTION**

This instruction sheet covers the AMPMODU Locking Clip contacts and connectors which are designed to be installed on .031 by .062-in. posts. The contacts can be installed directly onto posts, or they can be inserted into AMPMODU Locking Clip housings and then installed onto posts. Read this material, and all referenced material, before installing any contacts.

**2. DESCRIPTION**

The contacts feature a locking lance and a contact spring. The locking lance retains the contact in the housing. The contact spring provides high contact-to-post retention and, as a result, fastening devices are NOT needed to hold the contact and/or housing on the post(s).

Housings are available in various sizes (number of contact positions) with single row contact cavities on .156-in. centers. Keyed housings are available to provide polarization by not allowing post to enter contact cavity that has been blocked off.

**3. CRIMPING CONTACTS**

The contacts are designed to accept a wire range of 22 to 18 AWG and an insulation range of .050 to .100 in. See chart portion of Figure 1.

Strip form contacts are designed to be crimped with an AMP\* semi-automatic or automatic machine. Consult your local AMP representative for assistance in selecting the machine that will best suit your needs.

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Loose piece contacts are designed to be crimped with AMP Hand Crimping Tool 90308-1. Read AMP Instruction Sheet IS 7671, packaged with the tool, for the proper crimping procedure.

#### 4. INSTALLING CONTACTS

An insertion tool is NOT needed for installing contacts onto posts or inserting contacts into housings.

##### A. Installing Contacts onto Posts

The posts must have a functional length of between .281 and .344 in. The centerline spacing between adjacent posts must be no less than .156 in. See Figure 1.

Refer to Figure 2 and proceed as follows:

1. Align center of contact spring with post. Make sure widest portion of contact spring opening is oriented with wide portion of post.
2. Slide contact over post until it bottoms.
3. Pull back lightly on wire to be sure contact spring retains contact on post.

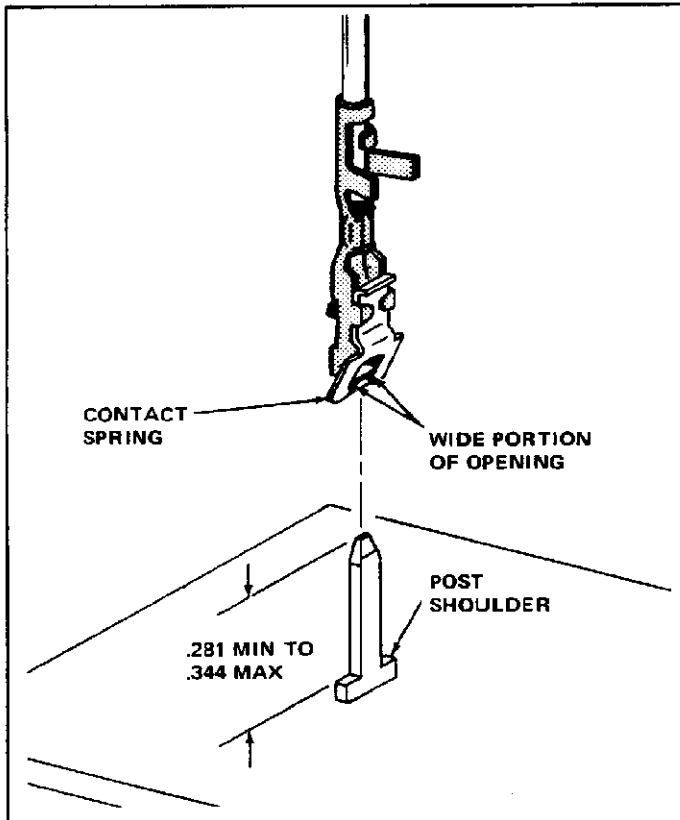


Fig. 2

##### B. Inserting Contacts into Housings

Select appropriate housing according to application requirements (number of contact positions and keyed cavities).

Refer to Figure 3 and proceed as follows:

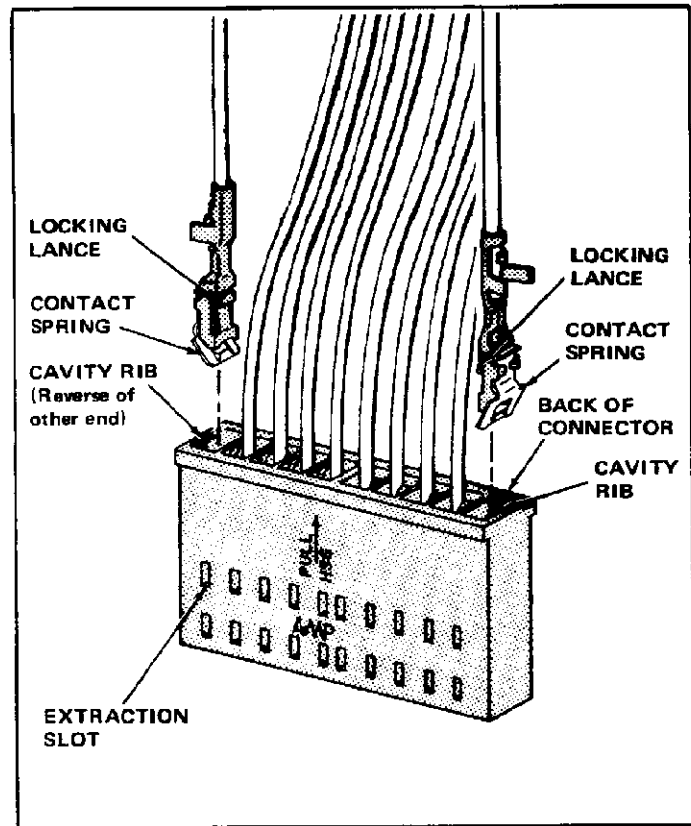


Fig. 3

1. Locate desired contact cavity on BACK of housing. Align contact spring with cavity rib in housing.

**CAUTION**

*All cavity ribs do NOT face the same direction. In some housings, half of the cavity ribs face one direction, and the other half face the opposite direction. Make sure each contact is properly aligned with each cavity rib.*

2. Insert contact straight into cavity until it bottoms.
3. Pull back lightly on wire to be sure contact locking lance retains contact in housing.

#### 5. INSTALLING CONNECTOR ONTO POSTS

The posts must have a functional length of between .370 and .433 in. The centerline spacing between adjacent posts must be .156 in.

Refer to Figure 1 and proceed as follows:

1. Start connector onto posts. Make sure all posts enter evenly into contact cavities.

**CAUTION**

*If installing keyed connector, make sure connector is properly oriented.*

2. Slide connector over posts until it bottoms.
3. Pull back lightly on wires to be sure contact springs retain connector on posts.

**6. SECURING WIRE BUNDLE**

If required, the wires can be bundled together with bundle ties and secured to a panel with fixed clamps. Note, however, the wires **MUST NOT** be confined in any way that would restrict floating action of the contact in the housing.

The minimum distance for the bundle tie is measured from the back of the connector to the first bundle tie. The minimum distance for the fixed clamp is measured from the top of the post to the first fixed clamp. Note that there must be slack in perpendicular wire bundles when the connector is fully installed. See Figure 4.

**7. REMOVING CONNECTOR FROM POSTS**

The connector is removed by gripping the connector sides and by pulling it straight away from the posts. The contact springs deflect within the housing and release locking tension on the posts. Do **NOT** confine or pull the wires during removal, otherwise, damage to the wires and/or contacts could result.

**8. EXTRACTING CONTACTS**

AMP Extraction Tool 91104-1 is designed for removing individual contacts from posts and for extracting contacts from housings. Read AMP Instruction Sheet IS 7678, packaged with the tool, for specific extraction procedures.

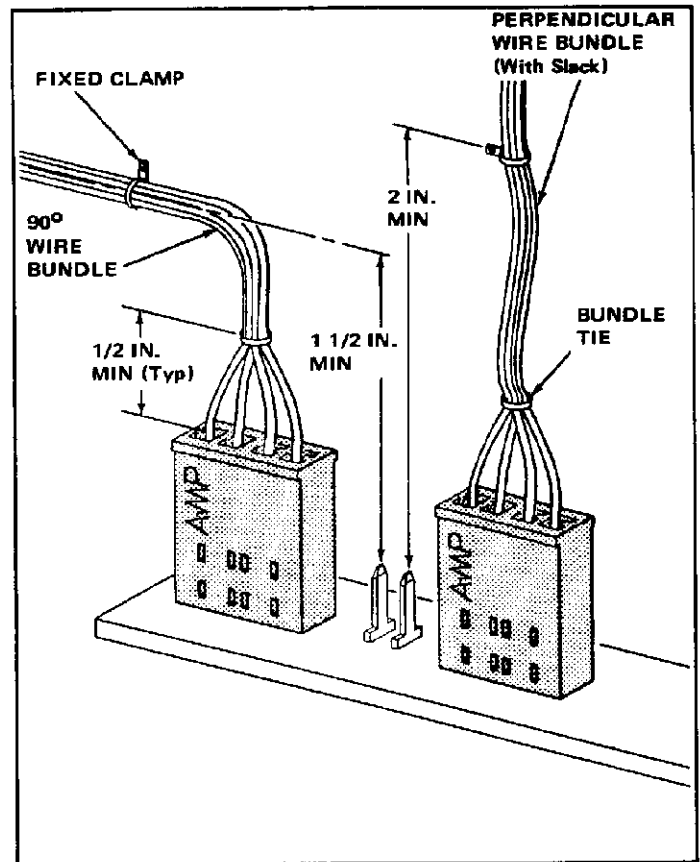


Fig. 4