

Figure 1

1. INTRODUCTION

AMP M-Series V.35 Cable Connector Kits meet the requirements of ISO 2593 for CCITT V.35 interfacing. Available in plug (AMP Base Part Number 213684), receptacle (AMP Base Part Number 213685) or shield kit (AMP Base Part Number 213765) versions, the kits are used primarily in high-speed data transmission applications.

NOTE

All dimensions on this document are in metric units [with U.S. customary units in brackets].

See Section 5, REVISION SUMMARY for reasons for reissue.

2. DESCRIPTION

The connector kits are essentially the same, with exceptions being the plug or receptacle connector housings, a pin hood which comes with some 212684 (plug) kits, and different diameters on cable clamps.

Shield kit 213765 connector housings, cable clamps, and pin hoods are sold separately.

Each kit contains a connector housing, male and female jackscrew, cable clamp, two-piece shield, and assembly hardware. The cable clamps come in two sizes, depending on the kit, to accommodate the following cable diameters:

KIT PART NUMBER	CABLE DIAMETER
231684-1 and -3●	10.16 to 15.24 [.400 to .600] max.
231684-2 and -4●	6.35 to 10.16 [.250 to .400]
213685-1	10.16 to 15.24 [.400 to .600] max.
213685-2	6.35 to 10.16 [.250 to .400]

● -3 and -4 kits include pin hoods

Figure 2

Refer to AMP instruction sheet 408-1379 for selection of contacts to be used in connector housings and applicable hand tool or machine applicator for crimping contacts onto conductors.

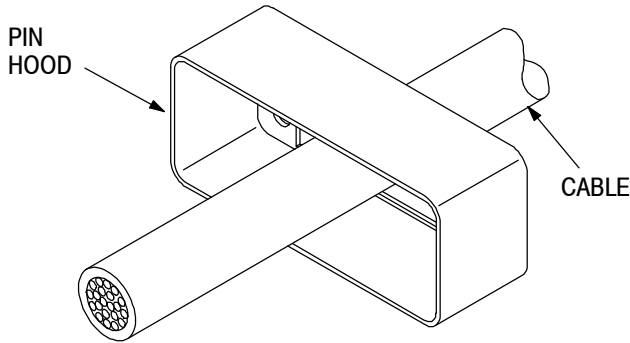


Figure 3

3. ASSEMBLY

1. Place pin hood (if used) over cable with the open end toward the end of the cable to be terminated in the connector. See Figure 3.

NOTE *If using a pin hood, it is very important to have it on the cable and correctly oriented; otherwise an unusable connector assembly may result.*

2. Trim the outer jacket of the cable 38.1 mm [1.50 in.] back from the ends of the conductors, taking care not to nick or cut the cable shield or the conductor insulation.

3. Pull the exposed cable shield back over the outer jacket of the cable.

4. Trim conductors to length and strip insulation from individual conductors according to instructions packaged with selected contacts.

5. Crimp contacts onto conductors and install into connector housing according to the “wiring run list” (note that contact locations are designated with letters “A” through “NN” on the housing).

6. Slide the pin hood (if used) down to connector housing and align mounting holes. See Figure 4.

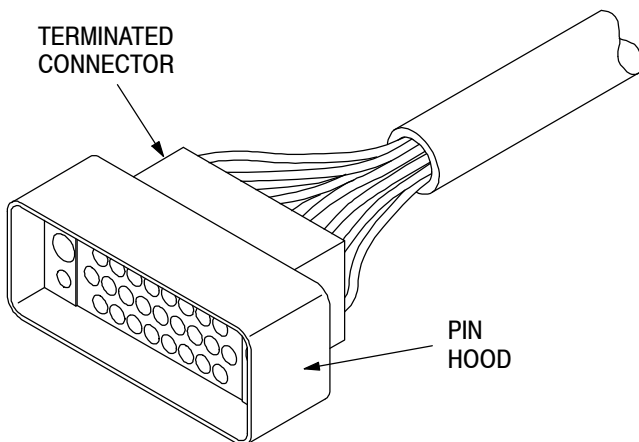


Figure 4

7. Place the jackscrews into the center holes of the connector housing flange (and pin hood if used). For plug connectors (pin contacts) the female jackscrew is located at the “A” position end of the housing. For receptacle connectors (socket contacts) the male jackscrew is at the “A” position end.

8. Place a shield half under the connector housing with the grooves in the jackscrew shafts resting in the semicircular notches on the shield flanges. Use two of the four short screws supplied with the kit to secure the shield half to the connector housing. See Figure 5.

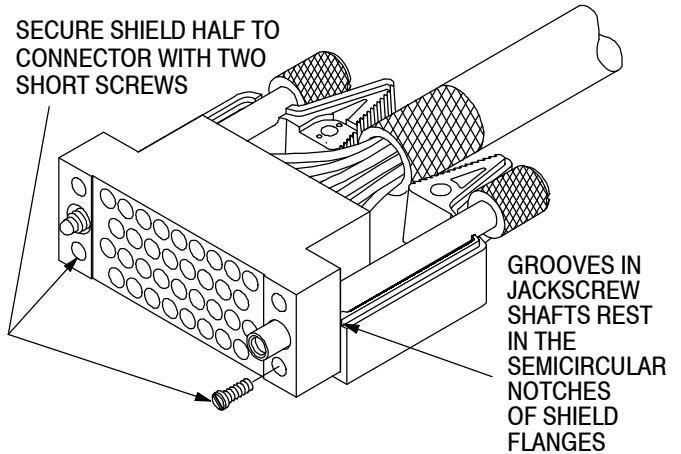


Figure 5

9. On the left, inside of each shield half, a pad has been provided for shield connection using a ring-tongue terminal. The shield assembly has not been tested as an EMI/RFI shield.

10. Place the other shield half over the cable and housing so that both shield halves align with one another.

11. Install the two long screws in opposite sides of the shield halves. See Figure 6.

ASSEMBLED AMP M-SERIES V.35 CABLE CONNECTOR (Non-Pin Hood Version Shown)

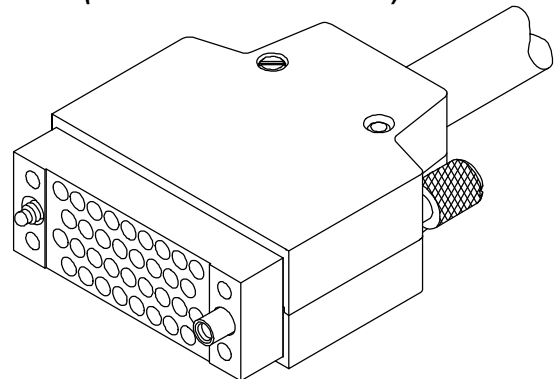


Figure 6

12. Install the remaining two short screws through the housing and into the shield.

CAUTION Avoid overtightening. Screws are thread-forming type.

13. Place cable clamps on both sides of the cable at the cable outlet of the shield. See Figure 7.

CABLE CLAMP ORIENTATION

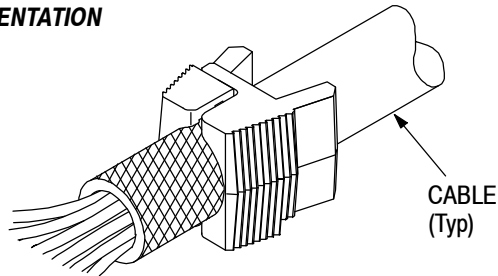


Figure 7

14. Pull lightly on the cable and squeeze cable clamps together in the shield's cable outlet.

15. Press the cable clamps into the cable outlet evenly, firmly, and sufficiently to lock them into the cable outlet. Seating fixture part number 91296-1 may be required to fully seat cable clamp inserts.

16. Pull on the cable to ensure that the clamps are locked in the cable outlet of the shield assembly.

17. Trim exposed cable shield to the edge of the cable clamps, taking care not to cut the cable jacket, and check all screws to ensure that they are secured.

4. INSTALLATION

When installing completed connectors, it is important to note the following:

— When turning jackscrews in by hand, tighten to the point of being snug with fingertips.

— If it is necessary to use a screwdriver to tighten jackscrews, use a screwdriver with a small blade and a handle less than 19.05 mm [.75 in.] diameter.

— If using an air driver, place on low torque setting.

It will be necessary to turn jackscrews alternately (a single turn on one and then a single turn on the other) until the connector is fully mated to its corresponding connector.

CAUTION Do NOT overtighten jackscrews. Excessive force on the jackscrews could result in breakage.

5. REVISION SUMMARY

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

Per EC 0020-1163-93:

- Added shield kit, base part number 213765
- Added Figure 2, renumbered subsequent figures
- Clarified procedures in Section 3, ASSEMBLY

Per EC 0990-0252-93:

- New document format
- Metric measurements added
- EC numbers, Revision Summary added