

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly of AMP\* M Series 104-Position Plug and Receptacle Connectors 201532-[ ] and 201692-[ ], and describes the hardware used to fasten, guide, and protect the connectors for cable-to-panel applications.

To choose the correct connector/contact/hardware combination for your application, refer to AMP Catalog 82003 or AMP Instruction Sheet 408-1379. AMP Application Specifications 114-10004 (Type III+ contacts) and 114-10026 (Type II contacts) provide the termination requirements and application data for the contacts.

**NOTE**

*Dimensions on this sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

## 2. DESCRIPTION

The standard (unloaded) plug and receptacle connector housings are designed to accept various crimp contacts: Type II, Subminiature COAXICON\* contacts, and Type III+. The connectors are available with a slotted or "T" center fastener (as shown in Figure 1) and accept both pin and socket contacts in either housing.

## 3. CONTACT INSERTION

**NOTE**

*For application tooling information, refer to AMP Catalog 82003. Refer to 408-7347 for detailed instructions on contact insertion and 408-1216 for contact extraction, packaged with the tooling.*

1. Position tool insertion tip behind the contact.
2. Align contact with the back of the connector cavity. Insert the contact into the cavity until it bottoms. Pull back gently on the wire to ensure that the contact is locked in place.

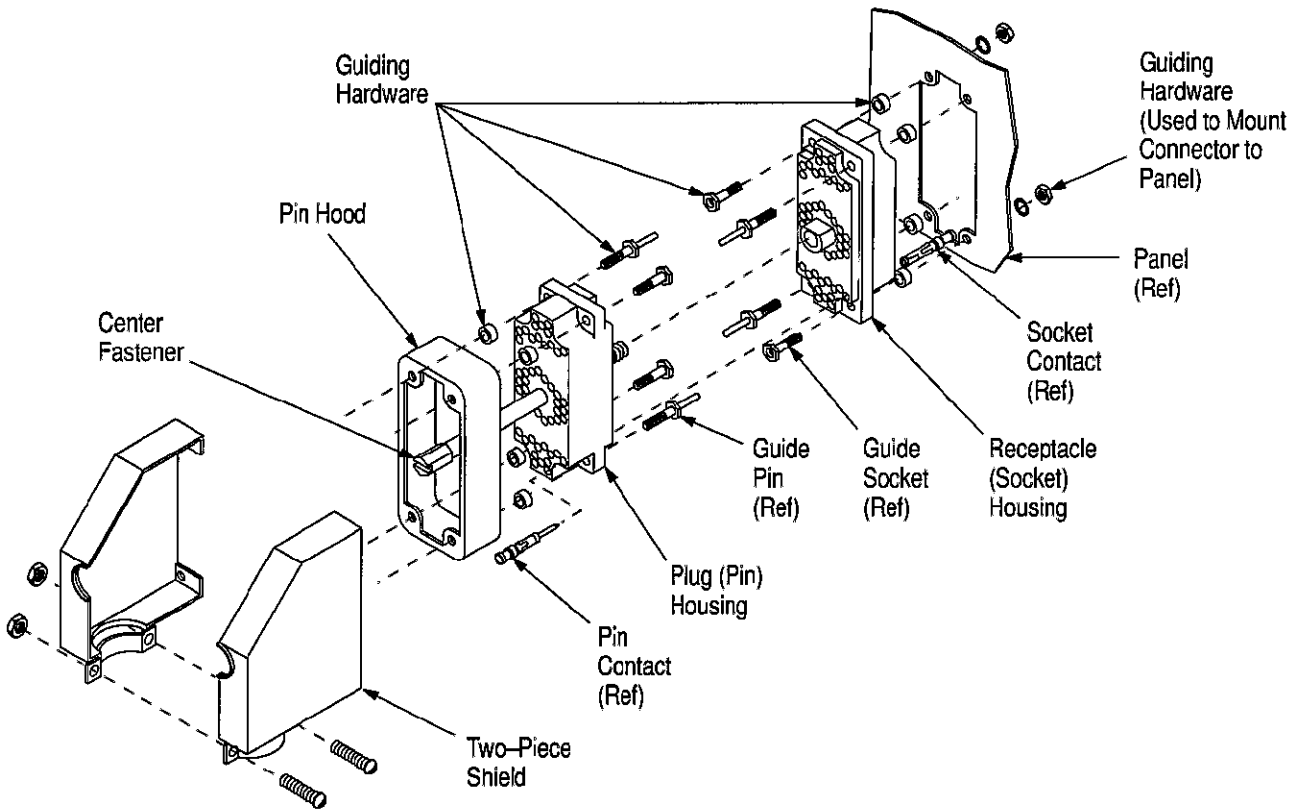


Figure 2

**4. CONNECTOR ASSEMBLY**

**NOTE** Guiding hardware is required to mount the connector to the panel: a two-piece shield (for strain relief and protection), an external closed end pin hood (to protect the pin contacts that protrude from the housing), a combination of AMP guide pins and sockets (for alignment and keying), and 6-32 Fillister head screws with lockwashers. Refer to 408-7121 for information concerning the use of guide pins and sockets.

1. Assemble the plug and receptacle housings using the hardware shown in Figure 2. Use a  $\frac{5}{16}$ -in. socket hex wrench to secure the center fastener. See Figure 2.

**NOTE** Do not exceed 5.65 N•m [50 in.-lb] torque.

2. Mount the connector to the panel, using the hardware shown in Figure 2. Refer to Figure 3 for the recommended panel cutout dimensions.

**NOTE** When dressing wire, a minimum distance of 51 [2.0] must be maintained between the back of the connector housing and the first cable tie; and between the housing and the first wire bend.

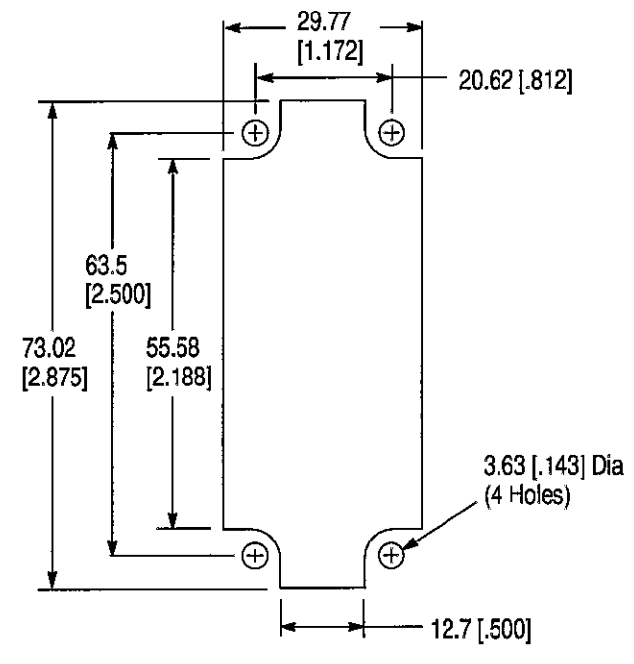


Figure 3

**5. REVISION SUMMARY**

Per EC 0990-0082-97:

- Added NOTE to Section 4