

NUMBER OF POSITIONS	FEMALE BLOCK NUMBER	MALE BLOCK NUMBER	TYPE OF COMBINATION
20 HVC*	203908-□	203909-2	M-DM
34	200838-□	200837-□	M-SM
50	200277-□	201357-□	M-DM
		200276-□	M-SM
		201358-□	M-DM

\* HIGH VOLTAGE CONNECTOR

FIGURE 1

## 1. INTRODUCTION

These instructions cover the recommended procedures for assembling the A-MP 20 HVC, 34 and 50 position Series "M" Connectors listed in Figure 1. The instructions for accessories are packaged with the specific items. Read these instructions and those packaged with the accessories before starting.

## 2. CONNECTOR BLOCK AND CONTACT SELECTION

Select the Male and Female Blocks from the chart in Figure 1. Note the possible combination between the connector halves:

1. First, the Female Block is standard and accepts both Pin and Socket contacts.
2. The M-SM designation indicates a Shallow Male Block which accepts Pin contacts only.

3. The M-DM designation indicates a Deep Male Block which accepts both Pin and Socket contacts.

The A-MP Type II, III, III Plus and Subminiature COAXICON ★ Pins and Sockets are used in Series "M" Connector Blocks. The contacts can be arranged to provide Polarization for each connector assembly. Using IS 1379, select the proper Contacts and Crimping Tool to be used.

## 3. ASSEMBLY PROCEDURES

The following steps indicate the proper sequence for attaching the components of the Connector Assembly to the Connector Block(s).

### A. One-piece Shield (if applicable)

1. Slide the Shield over the cable or wires before inserting the contacts.

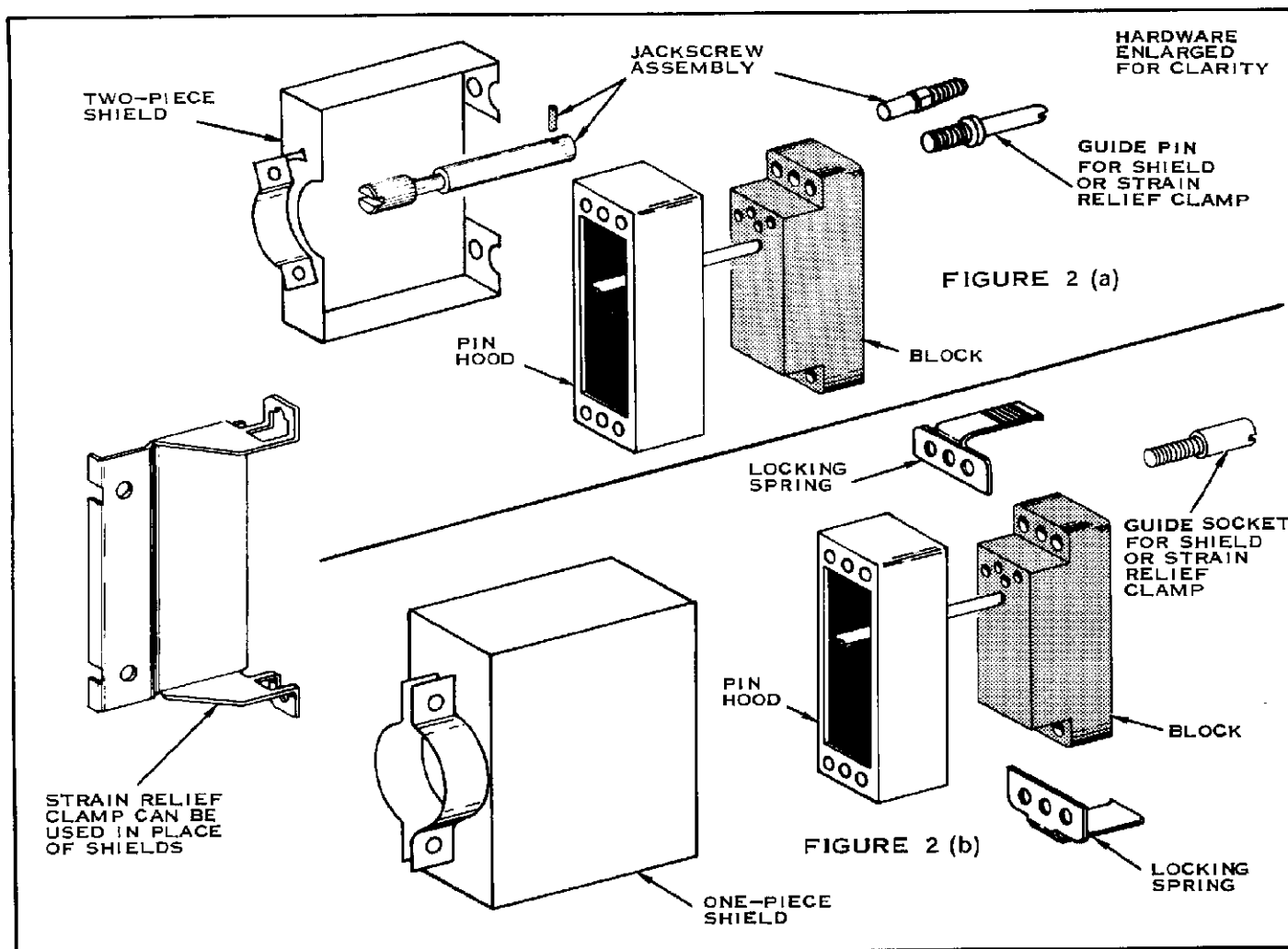


FIGURE 2

**B. Pin Hood (if applicable)**

1. Slide the Pin Hood over the cable or wires before inserting the contacts.

**C. Inserting Contacts**

1. Push the contact into the connector until it bottoms. Pull back slightly on the wire to make certain the contact is properly inserted.

**NOTE** Use an insertion tool to install contacts that are crimped to small, flexible wire to prevent possible damage. We recommend the A-MP Insertion Tool 91002-□

**D. Installation of Jackscrews (if applicable) See Figure 2(a).**

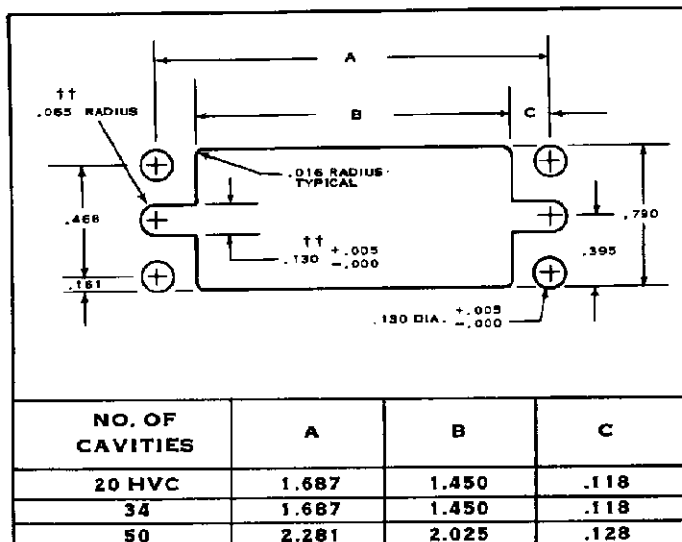
1. Position the Pin Hood on the Block.

2. Attach the Jackscrews to the Block. We recommend the A-MP 91016 Tool for installing the Pin in the Jackscrew Assembly. Read the instructions (IS 7126) packaged with the tool.

3. Attach the Two-piece Shield or Strain Relief Clamp to the Block using No. 4-40 machine screws or Guide Pins and Sockets.

**E. Installation of Locking Springs (if applicable) See Figure 2(b).**

1. Position the Locking Springs on the Block.
2. Position the Pin Hood over the Locking Springs.
3. Attach the Locking Springs, Pin Hood and One-piece Shield or strain Relief Clamp to the Block using No. 4-40 machine screws or Guide Pins and Sockets.



†† .130 may be .218 and .065 may be .109 to accommodate Pre-Mounted Fixed Jack Screws.

FIGURE 3

#### 4. PANEL MOUNTING

To panel-mount a connector Block, first make a cutout in the panel using the dimensions shown in Figure 3. Then mount the Block to the panel using No. 4-40 Machine Screws, Guide Pins and Socket or Fixed Jackscrews.

#### 5. CONTACT EXTRACTION

Use an extraction tool to remove the contacts from the Connector Block. We recommend the A-MP Extraction Tool 305183. Read the instruction sheet (IS 1216) packaged with tool.