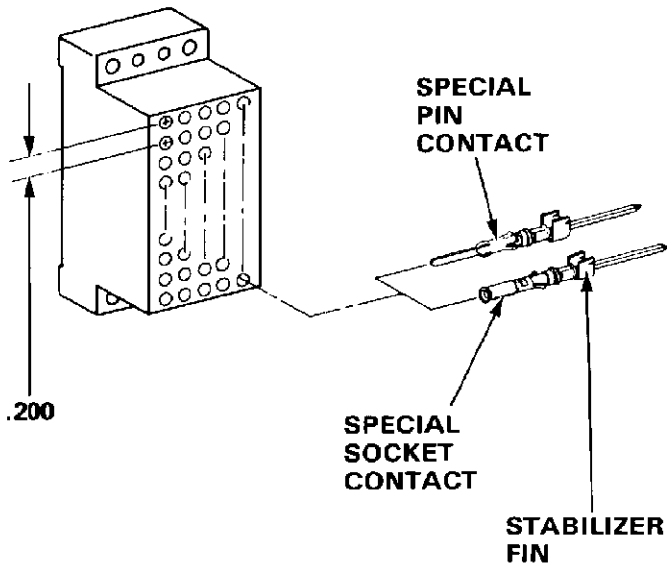


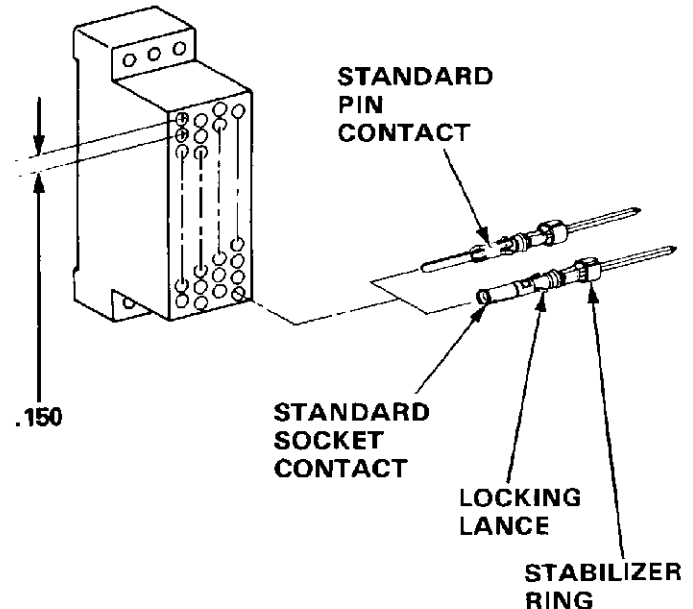
SPECIAL AUTOWIRE CONNECTORS

SPECIAL HOUSING, 50 POSN (Typ)



STANDARD AUTOWIRE CONNECTORS

STANDARD "M" SERIES HOUSING, 50 POSN (Typ)



SPECIAL POSTED CONTACTS WITH STABILIZER FIN

Type	.031 x .062	.045 ²
Pins	203627 203620	66604
Sockets	66615	66605

STANDARD POSTED CONTACTS WITH STABILIZER RING

Type	.031 x .062	.022 x .036	.045 ²	.025 ²
Pins	66468 66470	66469	66471	66460
Sockets	66459 66472	66474	66473	66461

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the AMP autowire contacts and connectors shown in Figure 1.

NOTE

All dimensions on this sheet are in inches.

2. DESCRIPTION (Figure 1)

The contacts and connectors are available in two types:

- (1) Special autowire housings with cavities on .200 centerlines that use special autowire posted pin contacts. The housings have square cavities. The contacts have two large fins that prevent them from rotating in the cavity. (The 112-position connector has cavities on staggered .250 centerlines.)
- (2) Standard "M" Series housings with cavities on .150 centerlines that use standard posted pin and socket contacts. These con-

tors will mate with any standard "M" Series connector that has similar cavity arrangements and size. Locking lances hold the contact in the connector cavity. A stabilizer ring prevents rotation of the contact in the cavity.

Connectors are usually supplied with contacts factory-loaded, although pin and socket contacts are also available in loose-piece form. Contacts are available with the following options:

- .025²; .022 x .036; .031 x .062; or .045² post sizes.
- Termination by wire wrapping or by TERMI-POINT ★ clips.
- Different post lengths to accommodate 1, 2, or 3 terminations.
- Variety of platings.

After assembly, posts can be terminated by hand, by semi-automatic machine, or by automatic machine.

3. CONTACT INSERTION (Figures 2 and 3)

Contacts are inserted by using AMP Insertion Tool 200893-2. See AMP Instruction Sheet IS 1817, packaged with the tool, for complete information on this tool.

CAUTION

Because the centerline of the post is offset from the center of the cavity, the contacts must all be inserted with the same orientation, particularly if the termination is to be made by semi-automatic or automatic machine, or if the posts are to be inserted into a printed circuit board or panel. In other words, the seam of the stabilizer ring of standard contacts (or fins of special contacts) must point in the same direction for all contacts. In some board-mounted applications, the posts will also need to be oriented in relation to the mounting holes of the connector. See Figure 2.

1. Orient the contact with the connector cavity as shown in Figure 2 and partially insert it into the cavity.

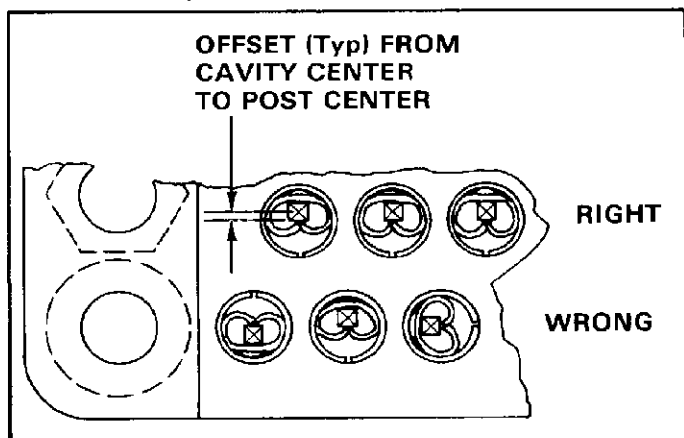


Fig. 2

2. Place the tip of the insertion tool against the shoulder of the stabilizing ring. The post will rest in the tool slot. See Figure 3.
3. Align the tool tip with the connector cavity and push the contact straight in until it bottoms in the cavity.
4. Insert all the contacts in this manner. Make sure each contact has the same orientation as those previously inserted.
5. Check to make sure that all contacts have the same orientation, and if a contact is incorrectly oriented, remove and re-insert it.

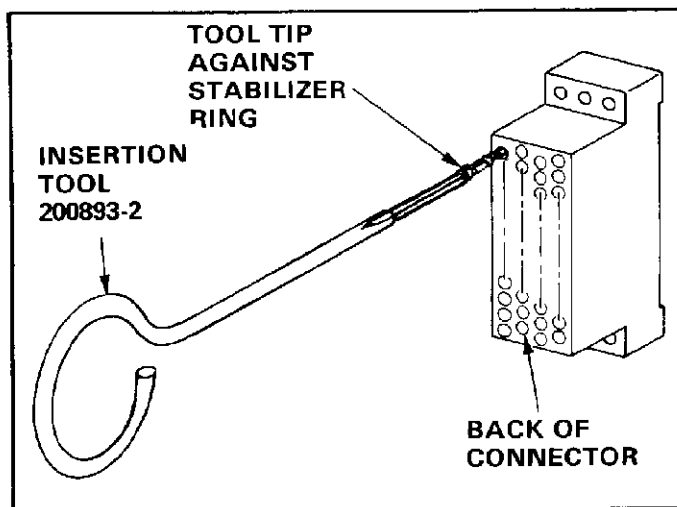


Fig. 3

4. CONTACT REMOVAL (Figure 4)

Contacts are removed by using AMP Extraction Tool 305183. See AMP Instruction Sheet IS 1216, packaged with the tool, for complete information on the tool.

1. Place the end of the extraction tool sleeve over the end of the contact to be removed.
2. Push the sleeve into the cavity as far as it will go. The push rod will back out of the handle when the end of the contact is engaged.
3. Rotate the handle to ensure that the locking lances have released.
4. Keep the tool firmly bottomed in the cavity, and depress the push rod button. The contact will be ejected as the rod bottoms in the tool.

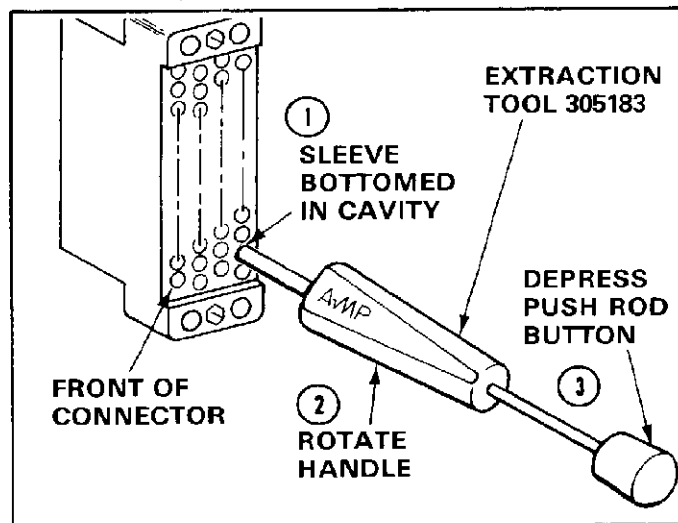


Fig. 4