

**AMP**AMP INCORPORATED  
HARRISBURG, PA 17105

REDUCED FOR PACKAGING

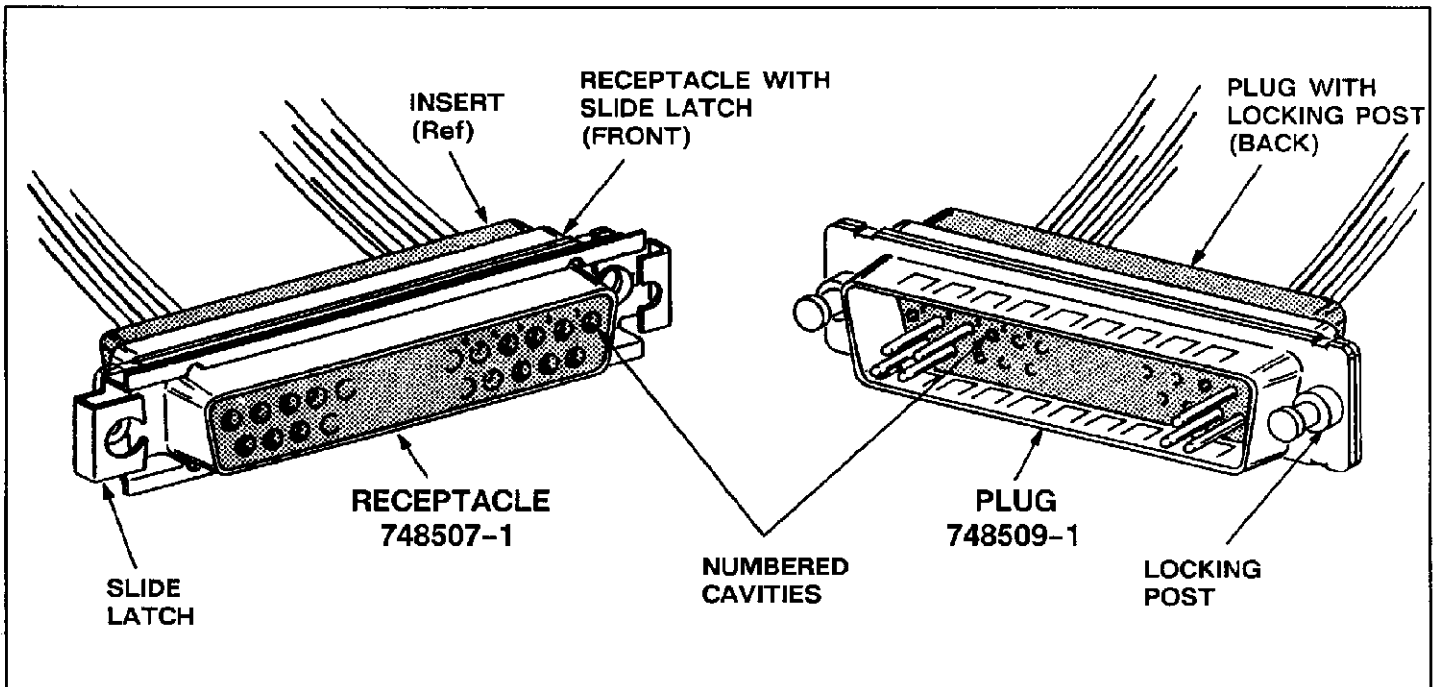
**AMPLIMITE\* HIGH DENSITY  
(HDP-20) CONNECTORS  
WITH  
PRE-ASSEMBLED HARDWARE****IS 9456**CUSTOMER HOTLINE  
1 800 722-1111RELEASED  
9-7-88

Fig. 1

**1. INTRODUCTION**

This instruction sheet (IS) covers contact and wire selection, hand tool application, attaching hardware, and engaging and disengaging procedures for AMPLIMITE High Density (HDP-20) Connectors listed in Figure 1. Read these instructions, and those referenced, before assembling any connectors.

**NOTE**

All dimensions on this sheet are in inches.

**2. DESCRIPTION (Figure 1)**

The connectors are designed for REAR insertion and extraction of size 20, precision formed contacts. The HDP-20 connectors feature steel shells and black nylon inserts with plastic contact retention tines.

**3. CONTACTS (Figure 2)****A. Selection**

Refer to the Chart in Figure 2, and select strip or loose-piece pin and socket contacts, according to the wire size and insulation diameter used.

Notice that each contact cavity is number-coded (FRONT and BACK). Insert pin contacts into the BACK of the plug and mating socket contacts into the BACK of the receptacle. Be sure that the plug and receptacle are loaded in a mirror-image. If all cavities are NOT used, distribute contacts evenly throughout the connector.

**B. Crimping**

Strip-form contacts are designed to be crimped by an AMP\* semi-automatic or automatic machine and applicator. Consult your local AMP representative for assistance in selecting the machine and applicator for your application. Loose-piece precision formed contacts are designed to be crimped with the AMP hand crimping tools listed in the chart in Figure 2. Refer to the instruction sheet, packaged with the tool, for specific crimping procedure and tool inspection information.

**C. Insertion and Extraction**

AMP Insertion/Extraction Tool 91285-1 is available for use with these products. AMP Instruction Sheet IS 9404 provides procedures on using the tool.

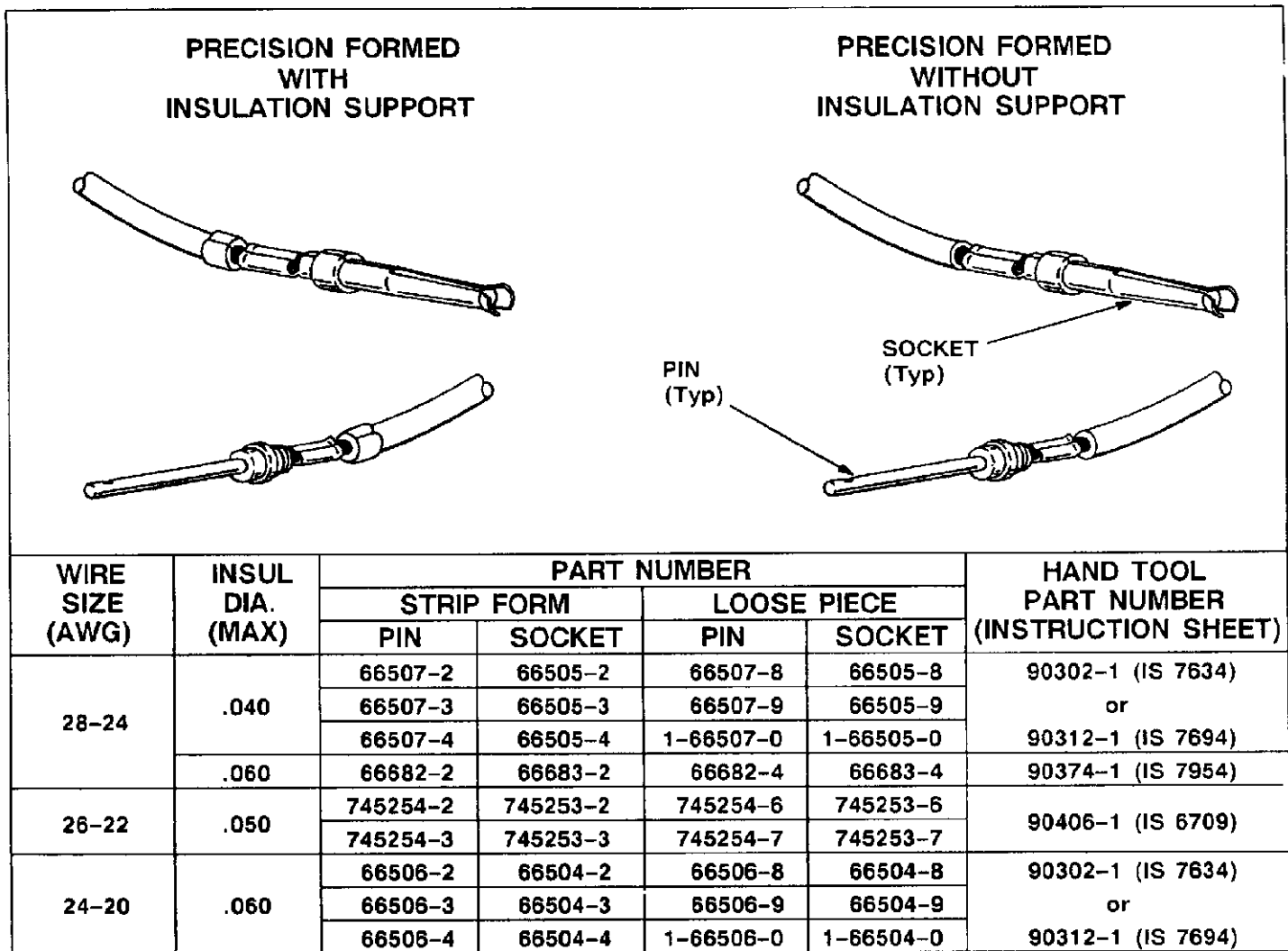


Fig. 2

**4. HARDWARE**

A shield and cable clamp assembly is used with the connector to house the cable or wires projecting from the rear of the connector and for strain relief of the cable or wires. For additional information concerning the use of the shield and cable clamp assembly, refer to AMP Instruction Sheet IS 7555, 6609, and 6769.

**5. ENGAGING CONNECTORS**

These steps are recommended to engage the connectors:

1. Position the slide latch so that the large latch opening is directly over a slide latch screw.

2. Align the connector mating faces and engage the two connectors.

3. Move the slide latch to lock the two connectors together.

**6. DISENGAGING CONNECTORS**

These steps are recommended to disengage the connectors:

1. Move the slide latch to the unlocking position.
2. Grasp the connectors and pull straight apart.