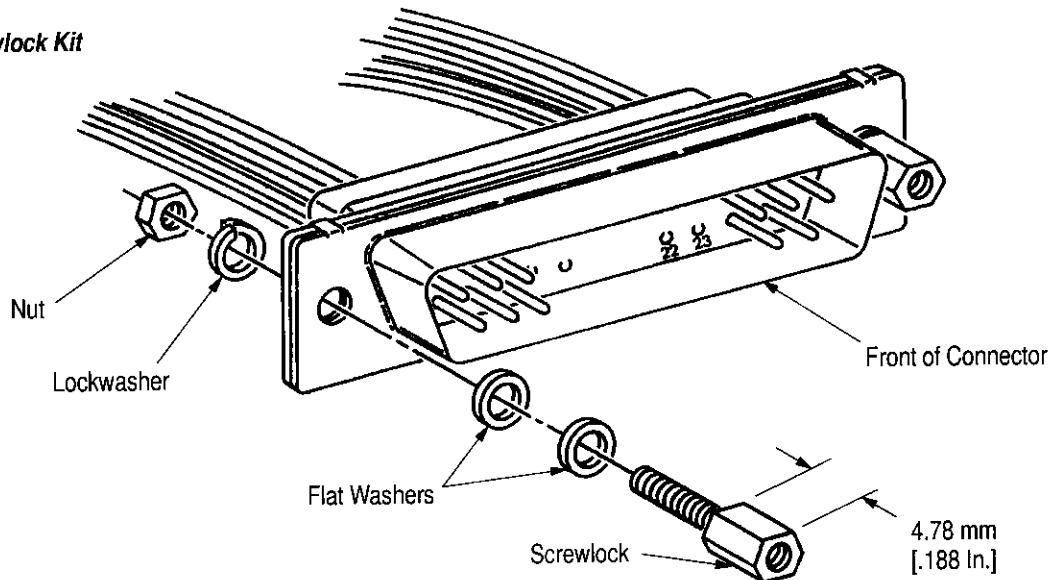


Female Screwlock Kit



PART NUMBER FEMALE SCREWLOCK KIT	THREAD SIZE	THREAD LENGTH	CONNECTOR SHELL	PART NUMBER FEMALE SCREWLOCK KIT	THREAD SIZE	THREAD LENGTH	CONNECTOR SHELL
205817-1	4-40	7.92 [.312]	Metal	207952-1	4-40	6.35 [.250]	Plastic
207719-1	4-40	14.22 [.560]	Metal	745563-1	4-40	6.35 [.250]	Metal
207872-1	M3 x .05	7.92 [.312]	Metal	747223-3	2-56	14.22 [.560]	Metal

NOTE: Kits used on plastic shell connectors have square nuts instead of hex nuts and lockwashers.

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of the AMP* Female Screwlock Kits and the AMP Male Screw Retainer Kits onto AMPLIMITE* connectors.

These kits are designed to secure mating connectors in panel-mounted or free-hanging applications. For panel-mount applications, it is recommended that the female screwlock kit be assembled on the panel-mounted connector. Read these instructions thoroughly before assembling either kit.

NOTE

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

Reasons for reissue are provided in Section 7, REVISION SUMMARY.

2. DESCRIPTION

The screwlock kit contains two identical screwlock component assemblies. Each assembly consists of one screwlock, two flat washers, one lockwasher, and one nut (see Figure 1).

The screw retainer kit contains two identical screw retainer component assemblies. Each assembly consists of one retainer and one retainer screw.

The screwlock kits and the corresponding screw retainer kits are available in various dimensions, with applications for a full range of contact sizes on both metal and plastic connector shells. See Figure 1 table for female screwlock kits and Figure 2 table for male screw retainer kits.

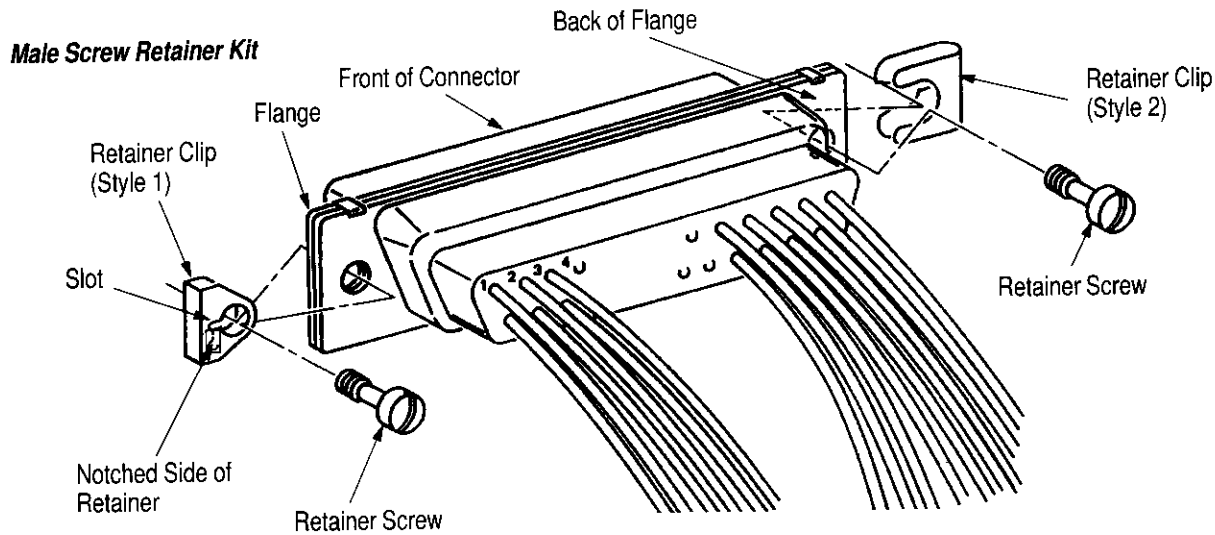
3. ASSEMBLING SCREWLOCK KITS

Screwlock component assemblies must be installed on the connectors as follows:

NOTE

Recommended torque for the screwlock assemblies is .45 N•m [4 in.-lb.].

1. For free-hanging application, install two flat washers on the screwlock and insert the screwlock through the connector flange. Secure the assembly with lockwasher and nut.



PART NUMBER SCREW RETAINER KIT	THREAD SIZE	CONNECTOR SHELL	STYLE RETAINER CLIP	PART NUMBER SCREW RETAINER KIT	THREAD SIZE	CONNECTOR SHELL	STYLE RETAINER CLIP
205980-1	4-40	HDP/HDE-Metal	1	745136-1	4-40	HDP/HDE-Metal	2
207871-1	M3 x .05	HDP/HDE-Metal	1	745647-1	4-40	HDE-All Plastic	1

Figure 2

2. For front-mounted panel applications, install two flat washers on the screwlock and insert the screwlock through the connector flange and panel. Secure assembly with a lockwasher and nut.

3. For rear-panel mounted applications, install as follows: NO flat washers on screwlock if panel thickness is 1.52 mm [.060 in.] or greater; ONE flat washer if panel is 0.66 to 1.52 mm [.026 to .060 in.] thick; TWO flat washers if panel thickness is less than 0.64 mm [.025 in.]. Insert screwlock (with appropriate number of flat washers installed) through the panel and the connector flange. Secure with lockwasher and nut.

4. ASSEMBLING SCREW RETAINER KIT (Figure 2)

Both screw retainer component assemblies must be installed on the connector. Install each assembly as follows:

Style 1 Retainer:

1. Align the slotted side of the retainer with the BACK of connector flange.
2. Slide retainer onto flange and align holes.
3. Thread retainer screw through retainer from BACK of flange.

Style 2 Retainer:

1. Align the notched side of the retainer with the FRONT of connector flange.

2. Mount retainer screw onto connector flange.

3. Slide retainer clip around the connector flange and the mounting screw.

NOTE

The clip will snap in place when properly assembled.

5. ENGAGING CONNECTORS

Align connector mating faces. Push connectors together until retainer screws are started into screwlocks. Alternately thread the retainer screws CLOCKWISE into screwlocks until connectors are fully engaged. Recommended torque is .22 N•m [2 in.-lb.].

6. DISENGAGING CONNECTORS

Alternately thread the retainer screws COUNTERCLOCKWISE until released from screwlocks. Pull connectors straight apart.

7. REVISION SUMMARY

Since the previous release of this sheet, the following additions were made:

Per EC 0990-0863-96

- In Section 3, added note regarding "recommended torque is .45 N•m [4 in.-lb.]"
- In Section 5, added "recommended torque is .22 N•m [2 in.-lb.]"