

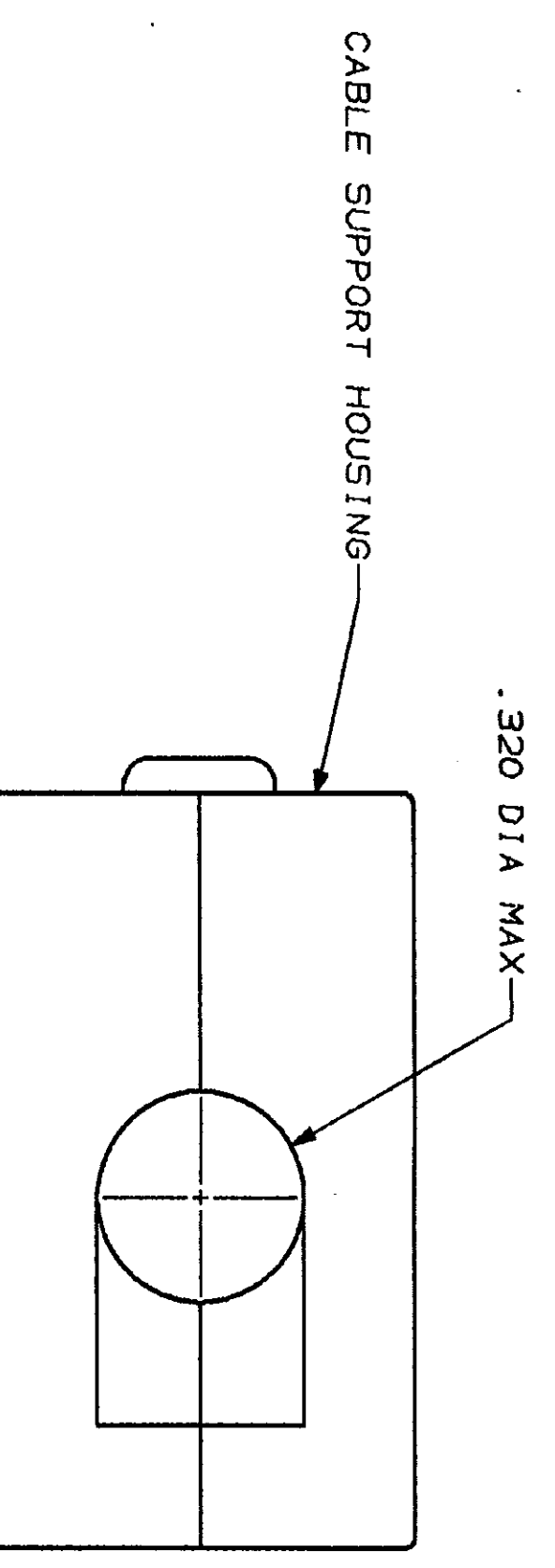
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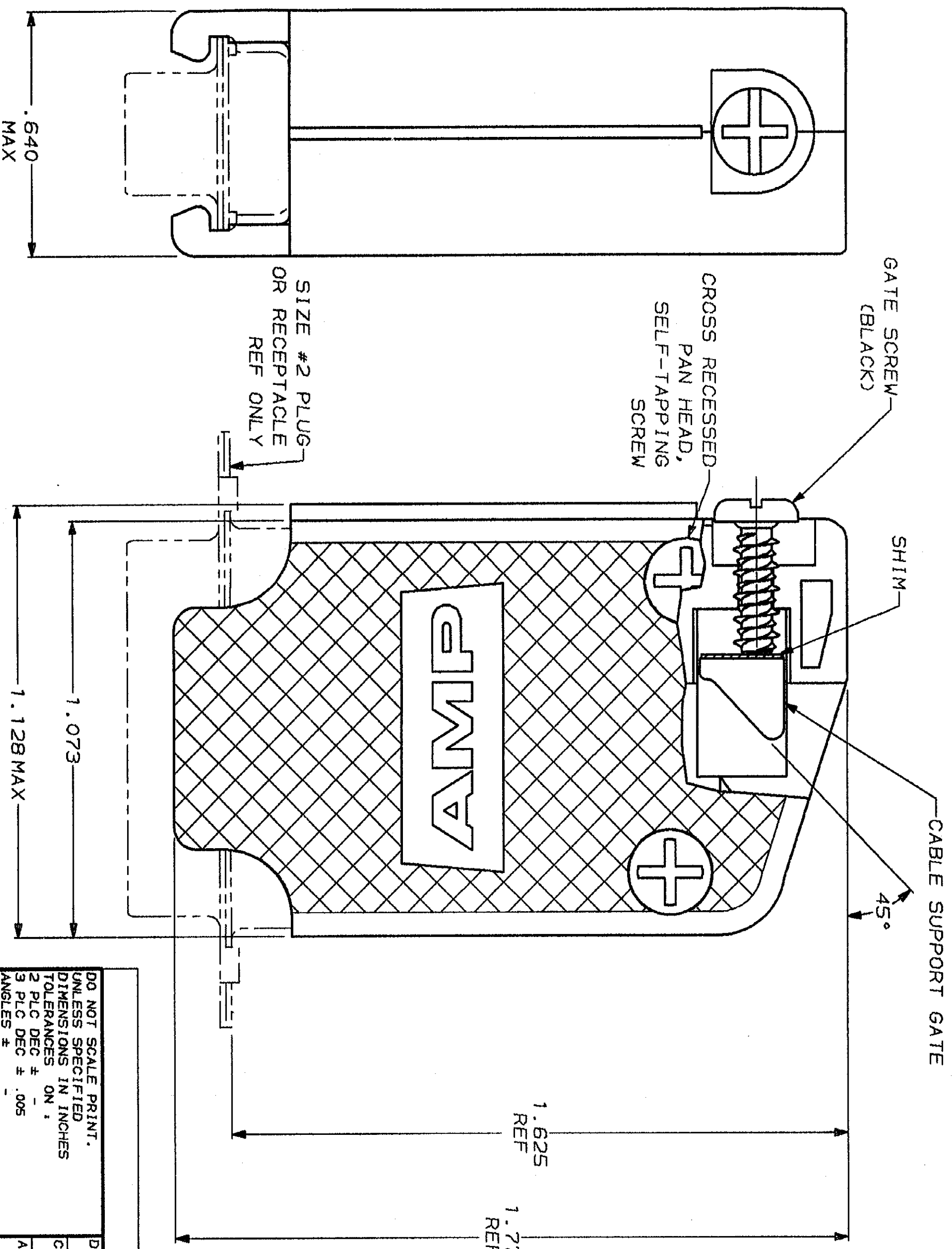
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MOD	LOC	QTY	P	R	ZONE	LTR	DESCRIPTION	DATE	APPD
22	BD	39					REDRAWN ON CAD	4/27/90	-



- 1 PARTS PACKAGED UNASSEMBLED.
- 2 COMPONENTS INDIVIDUALLY BULK PACKED & SHIPPED AS A UNIT PACKAGE KIT.



DO NOT SCALE PRINT.
 UNLESS SPECIFIED
 DIMENSIONS IN INCHES
 TOLERANCES ON:
 1 PLC DEC # .005
 2 PLC DEC # .005
 3 PLC DEC # .005
 ANGLES #
 MATERIAL SHIM-BRASS
 SCREENS-CRS PER ASTM A108
 HOLED PARTS-POLYPROPYLENE
 BLACK
 FINISH GATE SCREW-BLACK CHROMATE
 HOUSING SCREW-CLEAR CHROMATE
 BOTH SCREWS ZINC PLATED PER
 ASTM B633, TYPE 2, CLASS SC1

DR 4/27/90
 A. STAUB BG
 CHK - 6-15-90
 APPD - 7-16-90
 PRODUCT SPEC
 APPLICATION SPEC
 WEIGHT -

COMBINATION DRIVE	AS SHOWN	205730-3
COMBINATION DRIVE	AS SHOWN	205730-1
SCREW VERSION	PACKAGING	PART NO

AMP INCORPORATED
 Homebush, Pa. 17105
 NAME
 SELF TAPPED 45°/180° CABLE
 SUPPORT CLAMHELL, SIZE 2
 ASSEMBLY, AMPLIMITE™ HD-20
 SIZE FSCM NO DRAWING NO
 C 00779 205730
 SCALE 4:1 SHEET 1 OF 1

CUSTOMER DRAWING

AMP

AMP INCORPORATED
HARRISBURG, PA 17105

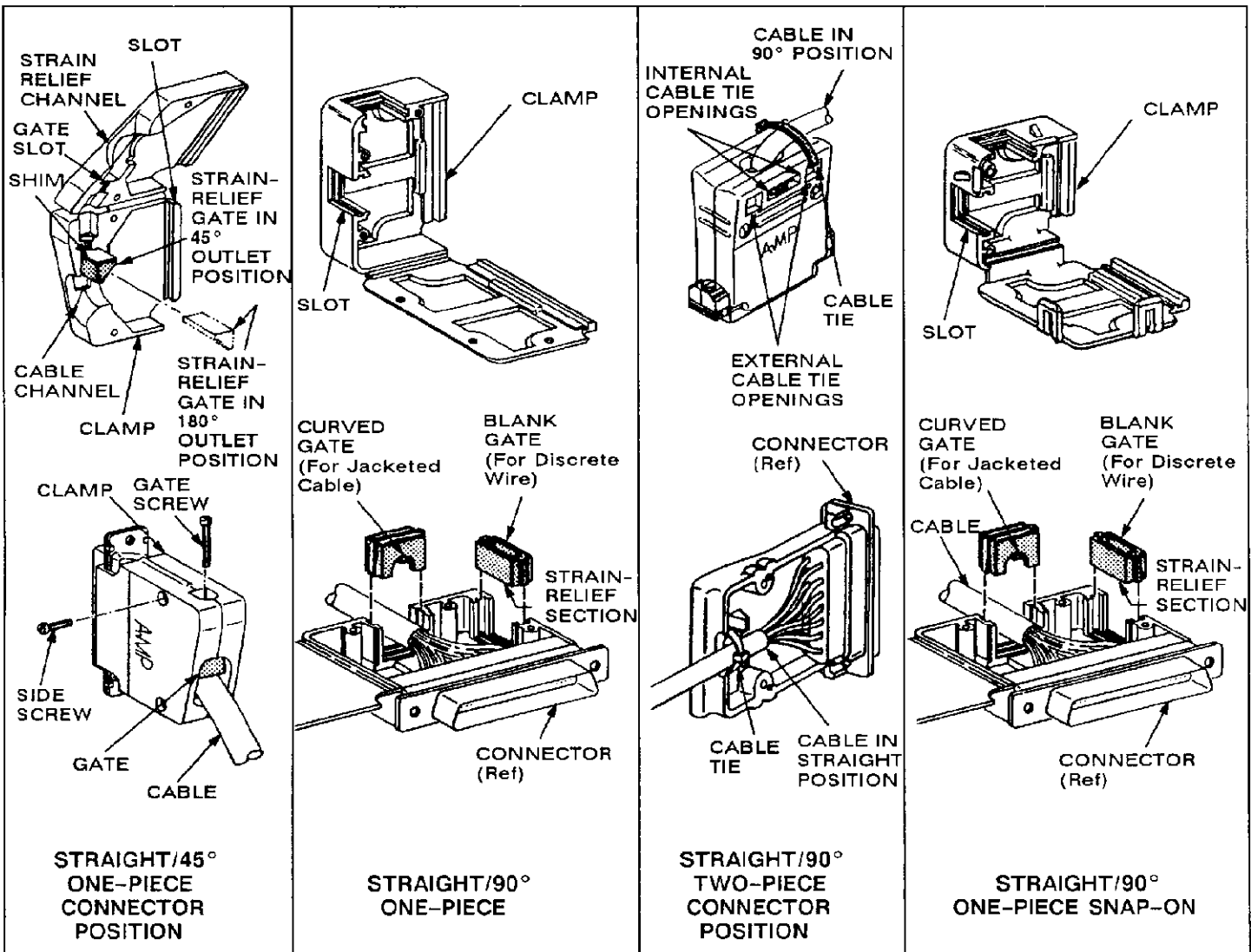
REDUCED FOR PACKAGING

IS 7555

CUSTOMER HOTLINE
1 800 722-1111

AMP* CABLE CLAMP ASSEMBLIES FOR AMPLIMITE* HD-20 AND HD-22 CONNECTORS

RELEASED
8-15-88



SHELL SIZE	CONN HD-20	POSN HD-22	CLAMP ASSY†	SHELL SIZE	CONN HD-20	POSN HD-22	CLAMP ASSY†	SHELL SIZE	CONN HD-20	POSN HD-22	CLAMP ASSY†	SHELL SIZE	CONN HD-20	POSN HD-22	CLAMP ASSY
1	9	15	205729	1	9	15	207467	2	15	26	206471	1	9	15	748066
2	15	26	205730	2	15	26	207470	3	25	44	206472	3	25	44	748067
3	25	44	205718	3	25	44	207345	3	25	44	745134				
4	37	62	205731	4	37	62	207473	4	37	62	745081				
5	50	78	205732	5	50	78	207476	5	50	78	745082				
				6	--	104	207503								

† RECOMMENDED ONLY FOR HDM, HDC, AND HDP CONNECTORS

Fig. 1

1. INTRODUCTION

This instruction sheet covers the installation of cable clamp assemblies for AMPLIMITE HD-20 and HD-22

connectors, types HDM, HDC, HDP, and HDE. See Figure 1. Read this instruction sheet thoroughly before attempting to install the cable clamp assemblies.

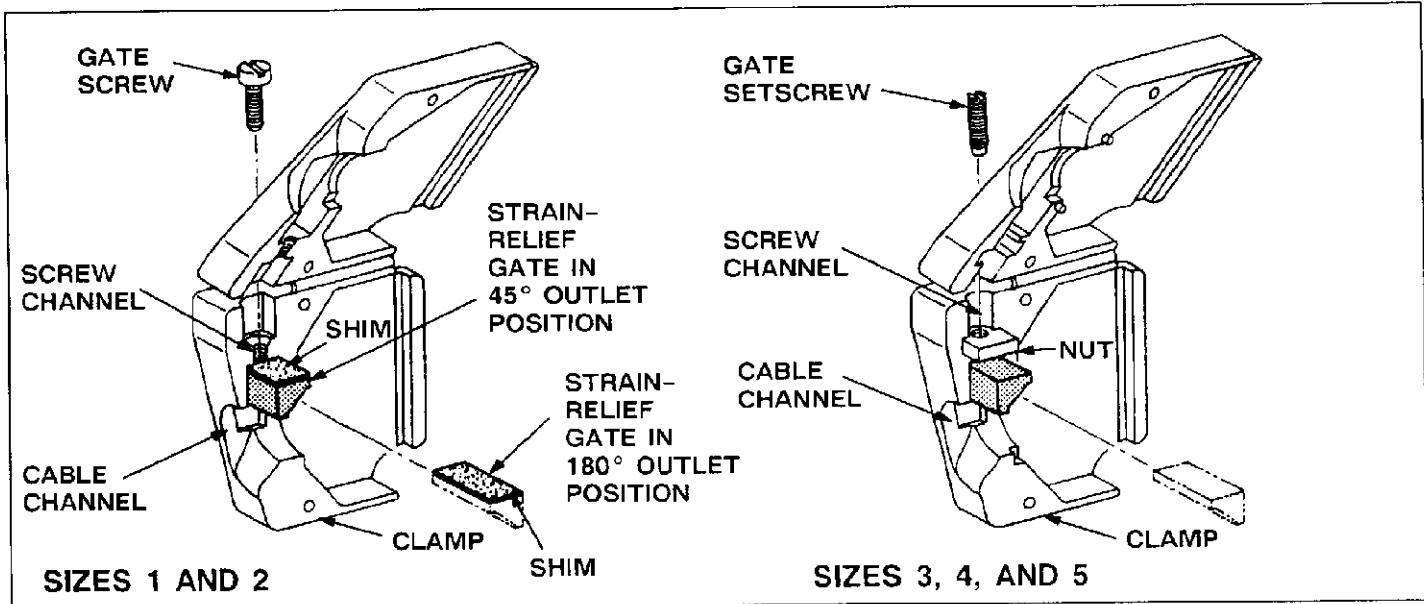


Fig. 2

2. DESCRIPTION

There are four types of cable clamp assemblies covered in this instruction sheet:

- Straight/45° one-piece
- Straight/90° one-piece
- Straight/90° two-piece
- Straight/90° one-piece snap-on

Except for the snap-on version, the clamp assemblies are held together by screws supplied in the kit.

The cable clamp assemblies can be used on either plug or receptacle connectors.

3. ATTACHING CABLE CLAMP ASSEMBLIES

Insert the contacts into the connector as described on IS 7514, the instruction sheet packaged with the connector. Select the proper cable clamp from the table of Figure 1.

A. Straight/45° One-Piece Assembly

1. Position the flange of the connector into the cable clamp slot shown in Figure 1. Place the longer row of contact positions in the bottom so that the wires are not pinched when the clamp is closed.
2. Position the cable in the strain-relief channel.
3. Position the strain-relief gate in the clamp for either a 45° or a 180° outlet. The gate must enter the gate slot in the clamp.

4. For Size 1 or 2 shell, place the brass shim between the gate and the screw channel. See Figure 2.

5. Position the cable in the cable channel and close the clamp.

6. Secure the clamp with self-tapping screws, as follows:

- 1 screw for shell size 1
- 2 screws for shell size 2
- 3 screws for shell sizes 3, 4, or 5.

7. Secure the gate screw or gate setscrew. Thread the gate screw in until the gate is firmly holding the cable. Do NOT overtighten the screw.

NOTE

Size 1 and 2 shells use a black gate screw. Size 3, 4 and 5 shells use a gate setscrew and nut instead of the black gate screw.

8. Push a small amount of wire into the clamp to provide strain relief on the wire bundle. Thread the gate screw in until the gate is firmly holding the wires. Do NOT overtighten the screw.

B. Straight/90° One-Piece Assembly

A carrier strip with strain-relief gates is packaged with each assembly. The size of the gate used depends on the diameter of the cable. Discrete-wire bundles use blank gates; jacketed cables use curved gates.

1. Remove the proper gate from the carrier strip.
2. Insert the connector into the clamp with the longer row of contacts in the bottom. Position the cable in the strain-relief channel.
3. Insert the gate into the cable clamp slot, as shown in Figure 1.

NOTE

The largest blank (unused outlet) can be installed with either flat side in the slot. The other blank gates should be installed with the strain-relief section touching the cable.

4. Position the cable over the gate and close the cable clamp.
5. Thread the screws into the holes in the cable clamp and tighten them to complete the assembly.

C. Straight/90° Two-Piece Assembly

1. Lay the connector and cable in one half of the clamp. Thread a cable tie through the internal tie openings and secure the cable to the clamp as tightly as possible.
2. Install the other clamp half, and captivate the two mounting screws.
3. Secure the assembly with the fillister-head screws and hex nuts supplied.

NOTE

If the wire bundle is dressed at 90°, use cable ties through the external tie openings after the clamp halves are assembled. The cable tie knots should be tucked into the cable clamp for a neater appearance.

D. Straight/90° One-Piece Assembly (Snap-On)

A carrier strip with strain-relief gates is packaged with each assembly. The size of the gate used depends on the diameter of the cable. Discrete-wire bundles use blank gates; jacketed cables use curved gates.

1. Remove the proper gate from the carrier strip.
2. Insert the connector into the clamp with the longer row of contacts in the bottom. Position the cable in the strain-relief channel.
3. Insert the gate into the cable clamp slot, as shown in Figure 1.

NOTE

The largest blank (unused outlet) can be installed with either flat side in the slot. The other blank gates should be installed with the strain-relief section touching the cable.

4. Close the cable clamp.
5. Snap the clamp tightly together, making sure the latches are firmly latched.