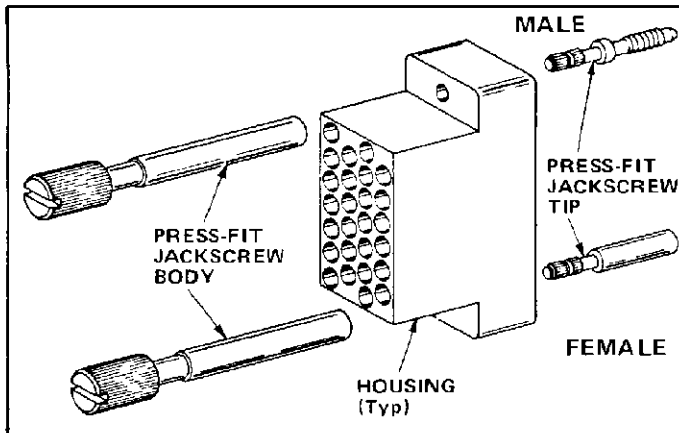




## AMP★ PRESS-FIT JACKSCREWS FOR AMP "M" SERIES CONNECTORS

REDUCED FOR PACKAGING

Instruction Sheet  
**IS 7485**  
RELEASED 7-22-75



JACKSCREW ASSEMBLIES				
DESCRIPTION	PRESS-FIT		FIXED	
	MALE	FEMALE	MALE	FEMALE
Short	205197	205198	200874	200875
Long	205190	205191		
Short-Short	205195	205196		
Long-Long	205268	205269		

FIGURE 1

### 1. INTRODUCTION

This instruction sheet covers the recommended assembly procedures for the AMP press-fit jackscrew assemblies listed in Figure 1. Read these instructions thoroughly before starting.

### 2. DESCRIPTION

A jackscrew assembly consists of a male or female tip and a body (see Figure 1). When properly installed, the tip will bottom in the body and leave sufficient space for assembly to rotate freely.

These press-fit turnable jackscrew assemblies will mate with existing "M" Series fixed jackscrew assemblies (see chart in Figure 1).

### 3. ASSEMBLY PROCEDURES

Two pieces of equipment are required for pressing the jackscrew body onto the tip — an arbor press (with 250 force pounds) and a support fixture. Construct a support fixture according to the dimensions provided in Figure 2.

**NOTE** *The depth of the hole must NOT exceed the maximum dimension indicated, or the tip will not bottom in the jackscrew body.*

Install the support fixture in the press and proceed as follows:

1. Insert mating portion of jackscrew tip into appropriate male or female hole in support fixture.

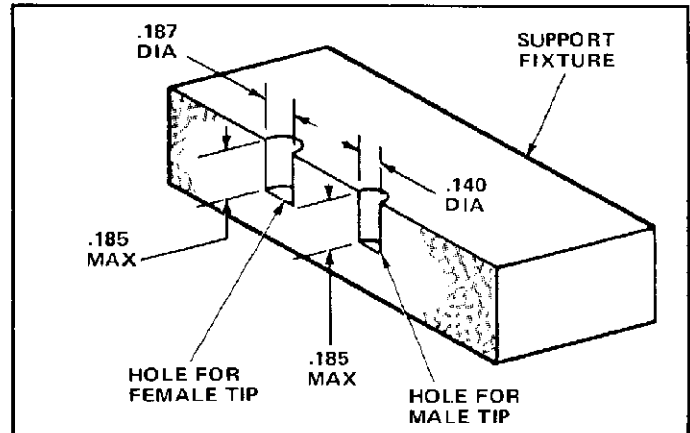


FIGURE 2

2. Position housing jackscrew hole over knurled end of tip as shown in Figure 3.
3. Align body with tip — make certain both are perpendicular to support fixture and press ram. Apply pressure until tip bottoms in body.

**CAUTION**

*Do NOT use excessive pressure. Over-insertion could deform the jackscrew assembly and/or damage the housing.*

4. Release pressure and remove assembly from press.

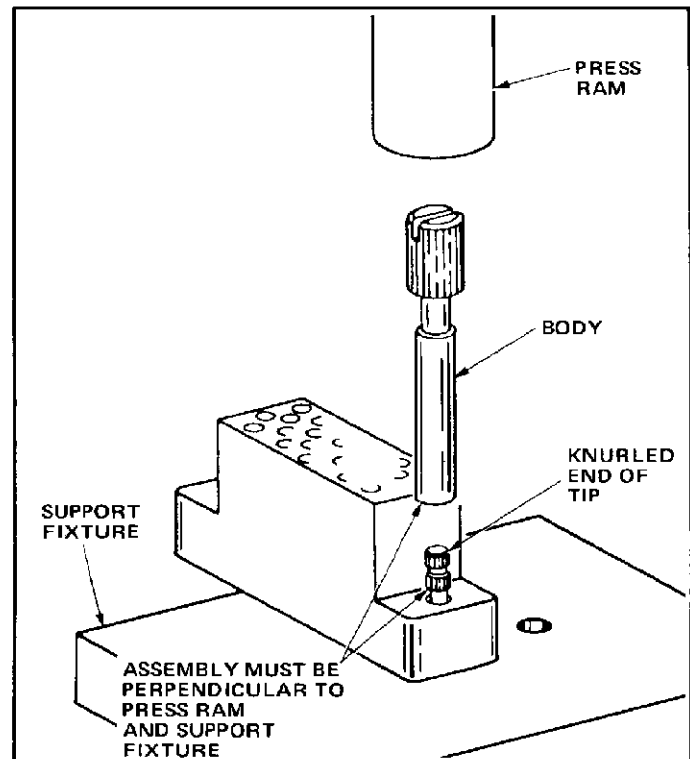


FIGURE 3

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