

| WIRE SIZE (AWG) | INSUL SIZE   | CONTACT NO. |                       | WIRE STRIP LENGTH  |
|-----------------|--------------|-------------|-----------------------|--------------------|
|                 |              | LP          | STRIP                 |                    |
| 20 to 16        | .080 to .110 | 350066-1    | 61347-1*<br>61342-2** | 3/16 in.<br>(.187) |
|                 | .105 to .130 | —           | 350490-1              | 7/32 in.<br>(.218) |

\*Contacts for standard applicators.

\*\*Contacts for miniature applicators.

FIGURE 1

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## 1. INTRODUCTION

These instructions cover the relay base connector shown in Figure 1. This connector is designed to be panel mounted and accepts contacts with a wire range of 20 to 16 AWG. Read this material carefully before assembling the connector.

## 2. CONTACTS

**Selection** — Determine the wire and insulation size to be used. Refer to the chart in Figure 1, and select the proper contact and wire strip length — then strip the wire to the specified length.

**Crimping** — The AMP Hand Crimping Tool 90088 can be used to crimp the contacts listed in Figure 1. Use the crimp section marked with the letter code B. We recommend hand tool applications for repair and prototype work, and when only small quantities are to be crimped.

AMP automatic and semi-automatic machines are recommended for assembly line production. They are

designed to crimp strip form contacts only. Consult your local AMP Representative for the machine that will best suit your needs.

**Insertion** — Notice that all contact cavities have two locking lance cavities. This makes it possible to insert the contact with the lance UP (as shown in Figure 1) or DOWN.

To insert the contact, grip the wire between your thumb and forefinger and align the contact with the proper contact cavity. Insert the contact into the cavity until it bottoms, then pull back lightly on the wire to be sure the contact is locked in place.

**Extraction** — The AMP Extraction Tool 693597-2 is designed to remove contacts from these connectors. To extract a contact, determine the lance cavity being used and insert the tool tip straight into that cavity until the tool bottoms. See Figure 1. Pull back on the wire and the contact will come out of the connector.

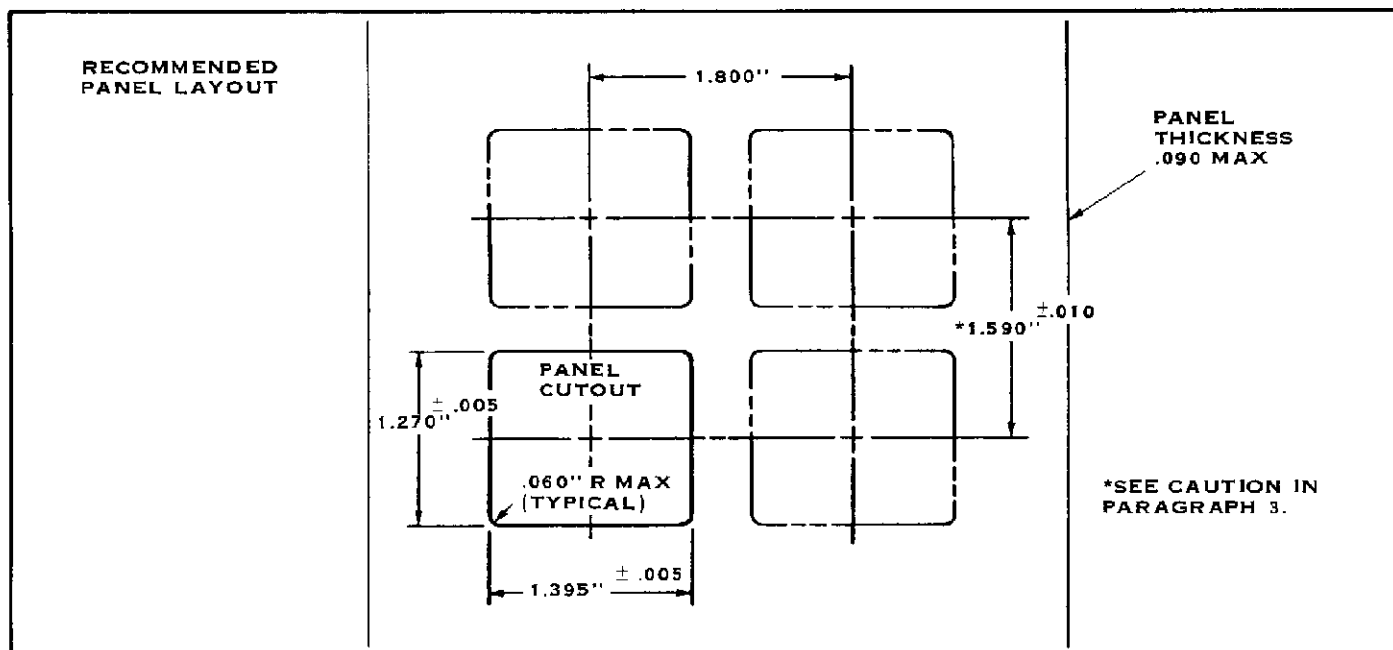


FIGURE 2

### 3. PANEL CUTOUT

Make a cutout in the panel using the dimensions shown in Figure 2. When more than one connector is to be mounted on the same panel, the center dimension for the cutout must be within the tolerance shown in Figure 2.

#### CAUTION

To mount relay connectors as close as shown in Figure 2, all double stationary tabs **MUST** face the same direction (see Figure 4).

### 4. INSERTING CONNECTOR INTO PANEL

Align the connector with the back of the panel cutout. Then tilt the connector and place the tension tab against the edge of the panel as shown in Figure 3. Press against the tab until it is deflected enough to allow the single stationary tab to enter the cutout. Make sure the panel is between the stationary tab and the supports, then release the connector. See Figure 4.

To remove the connector, grip the sides firmly and press toward the tension tab. When the tab is deflected, pull back and the connector will come out easily.

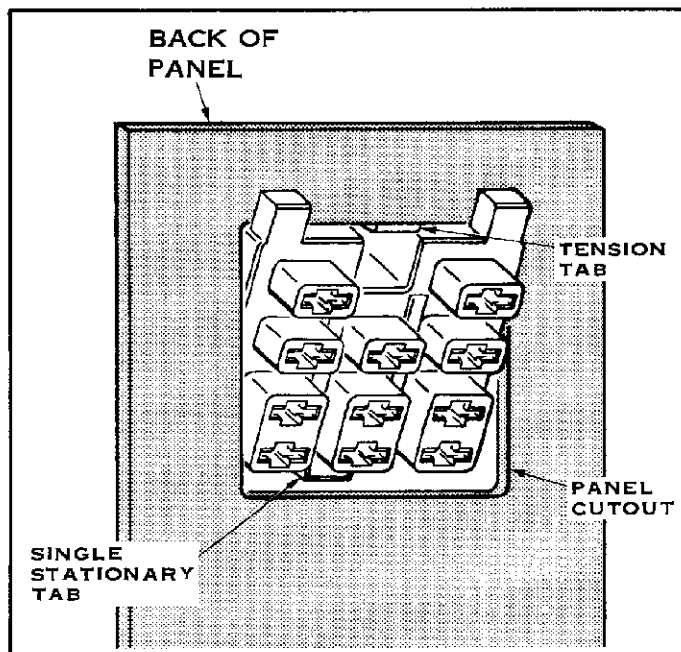


FIGURE 3

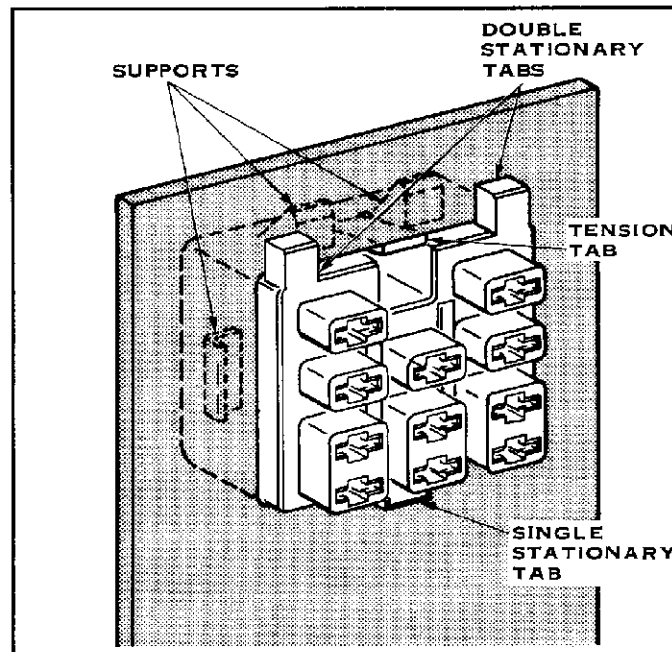


FIGURE 4