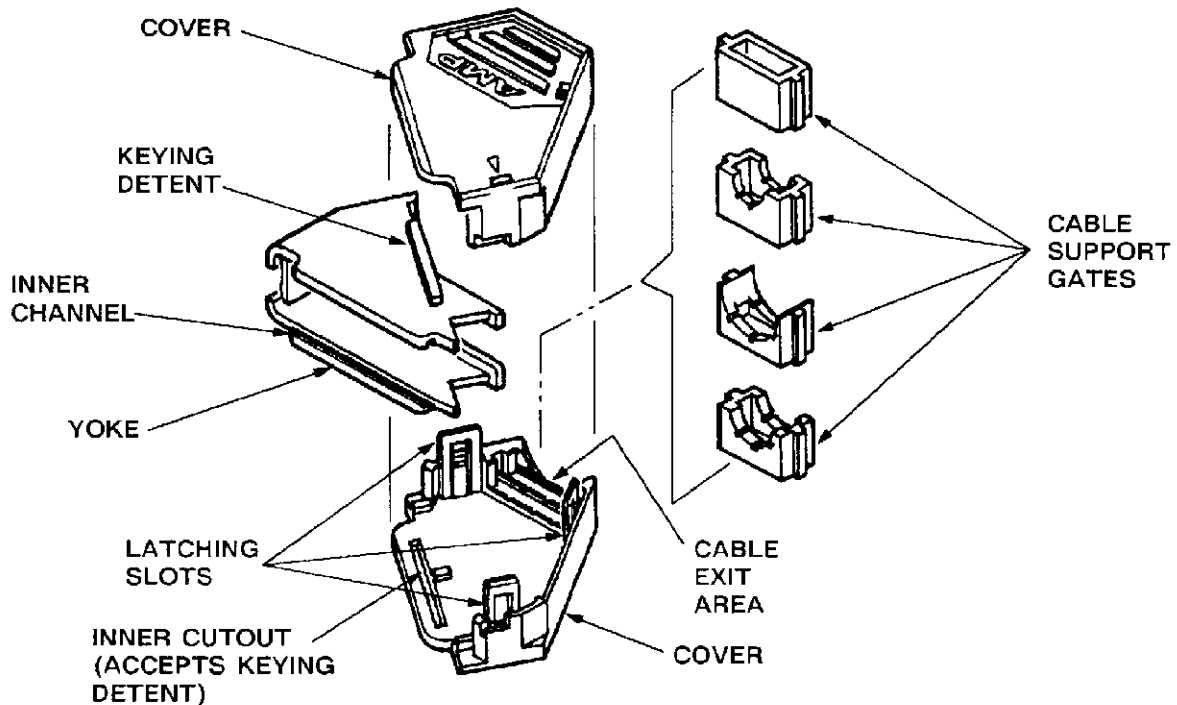


AMPAMP INCORPORATED
HARRISBURG, PA 17105CUSTOMER HOTLINE
1 800 722-1111AMP* AMPLIMITE*
HDP-20 AND HDE-20 CONNECTORS
THREE-PIECE AND TWO-PIECE
CABLE CLAMP KITS
(STRAIGHT AND RIGHT-ANGLE)

REDUCED FOR PACKAGING

IS 6659RELEASED
2-4-88

NO. OF CONT POSN	CABLE CLAMP ASSY	PART NUMBERS			CONN TYPE
		AMPLIMITE HDP-20 (Metal Shell) CONNECTORS	AMPLIMITE HDE-20 (Metal Shell) CONNECTORS	AMPLIMITE HDE-20 (All-Plastic) CONNECTORS	
25	745306	205208	745496	745211	Plug
		207464			
		205436			
37	745311	205207	745495	745209	Rcpt
		207463			
		205441			
37	745311	205210	745498	745215	Plug
		205437			
		205209			
205442					

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the assembly and application procedures for AMPLIMITE connector two- and three-piece cable clamp kits. All kits contain parts manufactured from black thermoplastic material. The three-piece kits are designed for the AMPLIMITE HDP-20 and HDE-20 connectors listed in Figure 1. The

two-piece kits are designed for the AMPLIMITE HDE-20 connectors listed in Figure 4. Read these instructions carefully before assembling any kits.

NOTE

All dimensions presented on this instruction sheet are in inches.

2. DESCRIPTION

Three-piece kits 745306 and 745311 can be used in either 90° (right-angle) or 180°(straight) cable-exit applications. Each three-piece kit features a yoke, two mating covers and cable support gates. The yokes contained in kits 745306 and 745311 feature inner channels which slide onto the connector flange during assembly. The yoke also has two keying detents to accept the inner channels of the covers. Each cover features three latching areas and a cable-exit area. One cover has latching slots which are secured to the latching tabs of the other cover. Each cover also features an inner cutout which snaps over the detent bars of the yoke. The cable-exit areas will accept one of the four available cable support gates supplied with the kit.

Except for kit 745550, each two-piece kit features two mating covers and assorted cable support gates. Kit 745550 consists of two covers with "built-in" cable support gates. Two-piece kits 745547, 745553, and 745560 are designed for 180° cable-exit applications only and kit 745550 is used with 90° cable-exit applications only. Two-piece kits have the same latching features as the three-piece kits: one cover has latching slots which are secured to the latching tabs of the other cover.

The cable support gates are designed to restrict the aperture diameter of the cable exit area depending on the diameter of the cable or wire bundle being used. The cable support gates should provide sufficient closure of the cable exit areas to provide strain relief for the conductor bundle or jacketed cable being used. The cable-exit areas of kits 745306, 745311, and 745560 will accommodate discrete wires or jacketed

cable up to .550 in. in diameter. The cable-exit area of kits 745547 and 745550 will accommodate up to .330 in. in diameter and the cable-exit area of kit 745553 will accommodate up to .425 in. in diameter.

NOTE

If you are using a three-piece kit, follow the procedures in Sections 3 and 5; if you are using a two-piece kit, proceed to Sections 4 and 5.

3. ASSEMBLY PROCEDURE, THREE-PIECE KITS

Determine that you have the correct cable clamp kit for the connector you are using. Then proceed as follows:

1. Terminate the conductors in the connector you are using according to the instructions packaged with the tooling.

NOTE

Ensure that you maintain 1-in. length on individual conductors when using jacketed cable.

2. Slide the yoke onto the connector flange.
3. Lay the cover with the latching slots on a flat surface with the slots in an upright position. See Figure 1.
4. Depending on the cable-exit orientation you desire (straight or right angle), lay the yoke and connector assembly in the cover. See Figures 2 and 3.

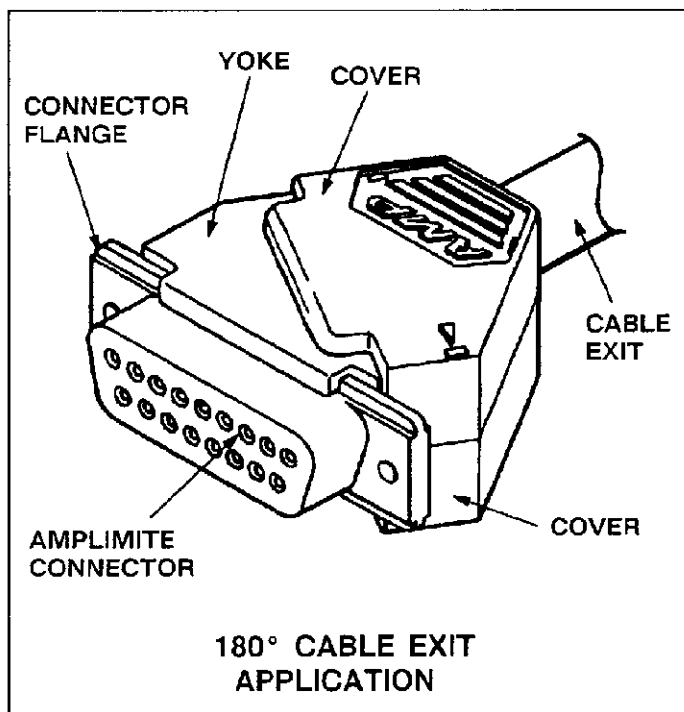


Fig. 2

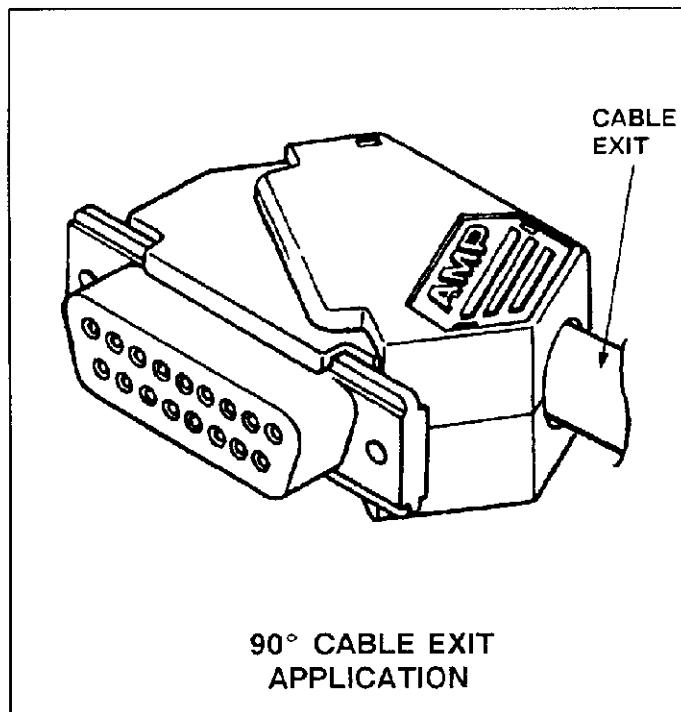


Fig. 3

NOTE

The keying detents of the yoke fit into the inner cutouts of the cover. If the cable exit is 180° and you desire 90°, reverse the position of the yoke and place the keying detents in the channel reversed to the original position.

5. Remove the four cable support gates from the bar to which they are attached and insert the one that provides strain relief for the cable or conductor bundle into the slot provided in the cable-exit area of the cover.

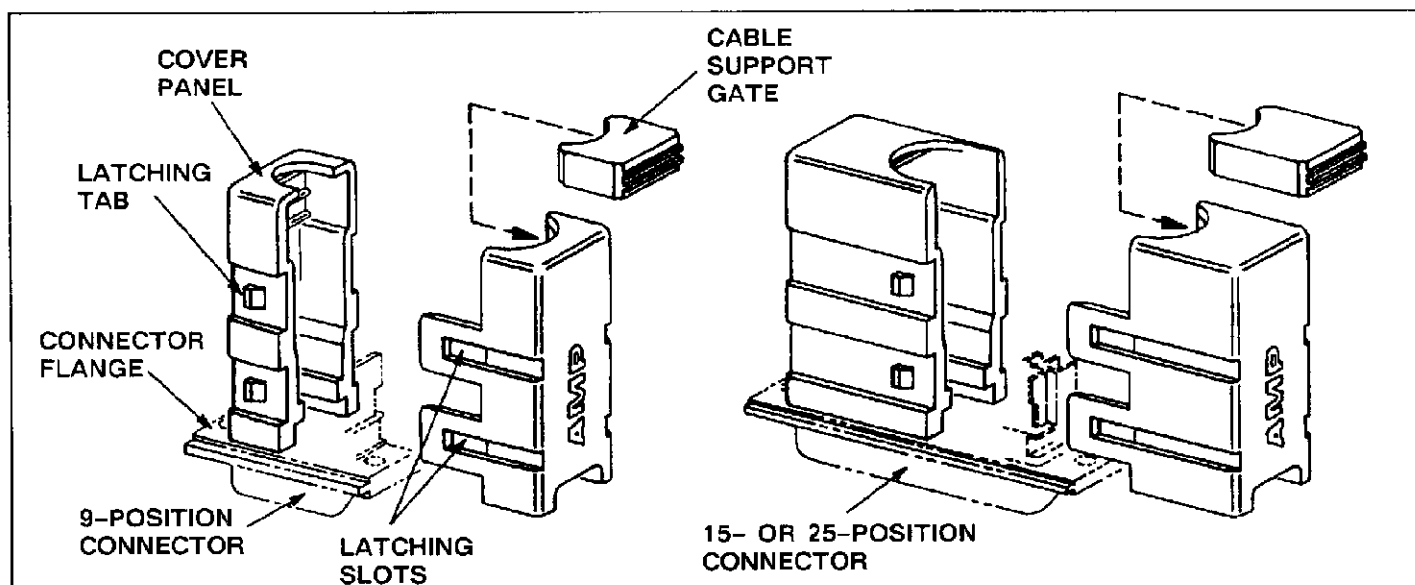
NOTE

If using a large-diameter cable (.550 in. max), a cable support gate may not be required.

6. Align the tabs of the other cover with the slots of the cover on the flat surface. Then gently press the upper cover into place, allowing the tabs to engage in the latching slots, ensuring that no conductors are pinched between the covers.

NOTE

If the covers will not latch, or if it appears that they will be distorted when closed, re-open the covers by inserting a narrow-blade screwdriver into the slots provided in the upper cover, beginning with the slot marked with an arrow. Remove the upper cover, replace the cable support gate with another which allows for a larger diameter, and re-assemble.



NO. OF CONT POSN	CABLE CLAMP ASSY	PART NUMBERS			CONN TYPE
		AMPLIMITE HDP-20 (Metal Shell) CONNECTORS	AMPLIMITE HDE-20 (Metal Shell) CONNECTORS	AMPLIMITE HDE-20 (All-Plastic) CONNECTORS	
9	745547 745550	---	745492	745203	Plug
		---	745491	745201	Rcpt

15	745553	---	745494	745207	Plug
		---	745493	745205	Rcpt

25	745560	---	745496	745211	Plug
		---	745495	745209	Rcpt

Fig. 4

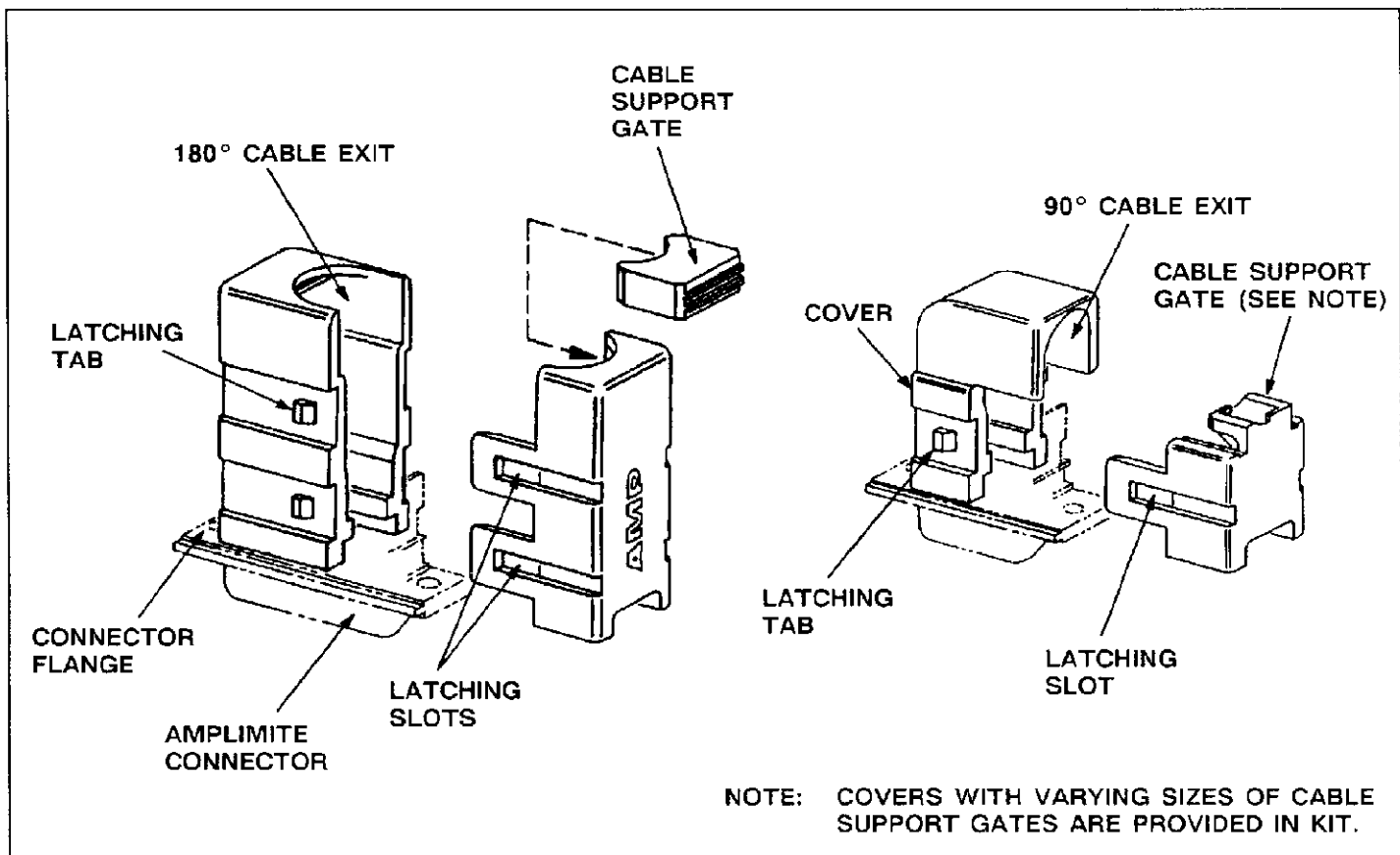


Fig. 5

7. Examine the assembly for cover symmetry and adequate strain relief of the cable or conductor bundle.

4. ASSEMBLY PROCEDURE, TWO-PIECE KITS

Determine that you have the correct cable clamp kit for the connector you are using. Then proceed as follows:

1. Terminate the conductors in the connector you are using according to the instructions packaged with the tooling.

NOTE

Ensure that you maintain 1-in. length on individual connectors when using jacketed cable.

2. Slide the cover with the latching tabs onto the channel of the connector, as shown in Figure 5.

3. Select the appropriate gate and slide it into the back of the cover with the latching slots. If using the two-piece kit for the 90° cable-exit application, the cable support, supplied in three options, is an inherent part of the cover with the latching slots. (See right portion of Figure 5.)

4. Refer to Figure 5 and slide the cover with the latching slots onto the connector from the other side. Then snap the two together so that the slots fit into the latching tabs.

NOTE

If the covers will not latch, or if it appears that they will be distorted when closed, disengage the latches and remove the covers. Replace the cable support gate with another which allows for a larger diameter. Then re-assemble and examine for proper latching and adequate strain relief.

5. APPLICATION

The completed assembly may be used in free-hanging or in panel-mounted applications. Various hardware accessories are available for use with the assembly for securing it to a mating connector. Consult your local AMP representative for information regarding hardware applications and availability, or contact:

AMP Incorporated
P.O. Box 3608
Harrisburg, PA 17105-3608