

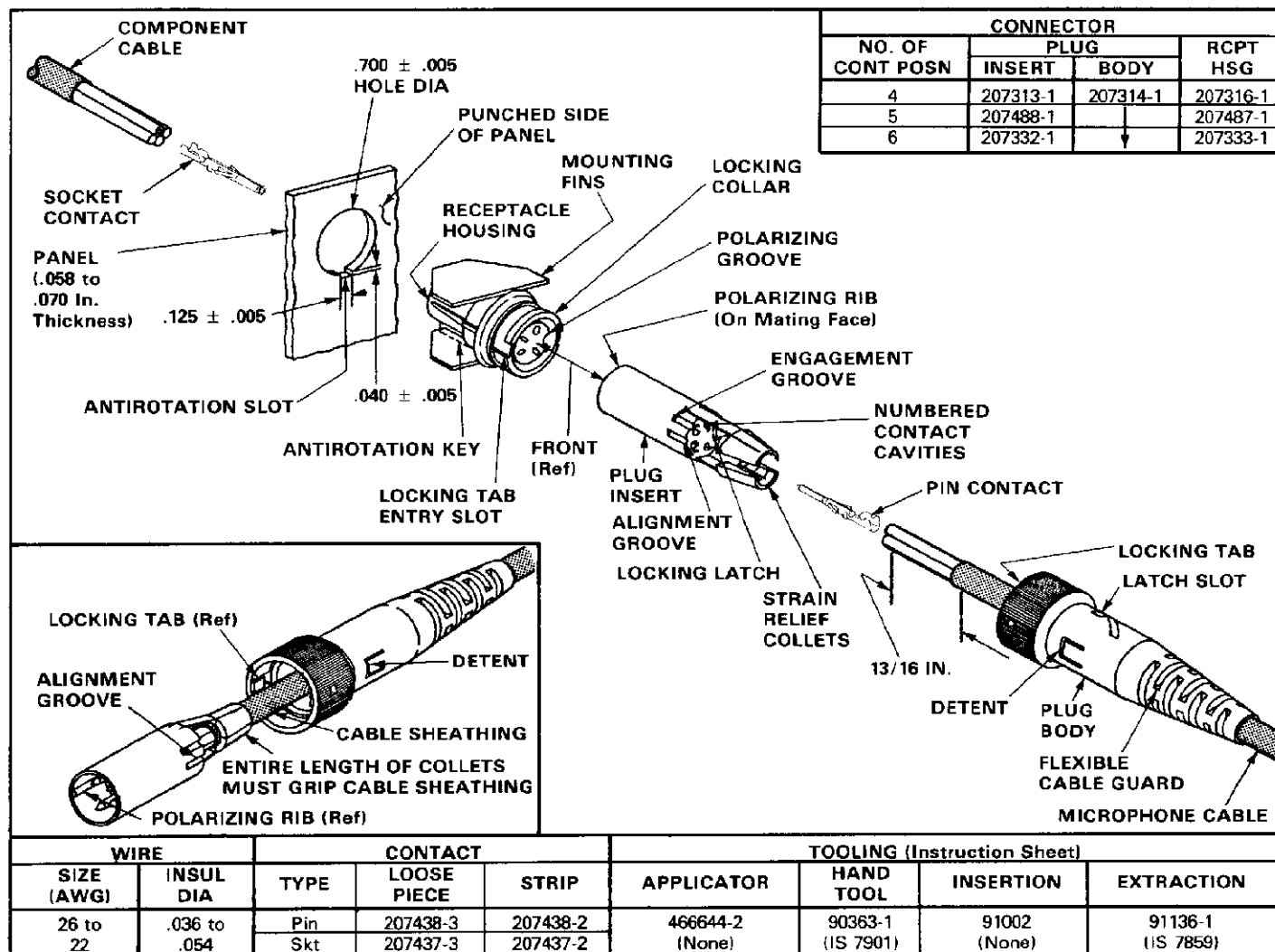


Fig. 1

1. INTRODUCTION

This instruction sheet provides the recommended procedures for assembling the AMP Audio Instrument plug and receptacle connectors listed in Figure 1. Read this sheet, and applicable referenced material, before assembling connectors.

NOTE All dimensions presented on this instruction sheet are in inches, unless otherwise stated.

2. DESCRIPTION (see Figure 1)

Mating connectors include a panel mounted receptacle connector and a free hanging plug connector.

The receptacle connector consists of a receptacle housing and the specified number of socket contacts. The housing features a locking collar, two locking tab entry slots, an antirotation key, and four mounting fins.

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The plug connector consists of a plug insert, a plug body, and the specified number of pin contacts. The insert features two cable strain relief collets, a locking latch, an alignment groove, and an engagement groove. The body features two locking tabs, a latch slot, a detent, and a flexible cable guard.

Each receptacle has a polarizing groove and each plug (insert) has a polarizing rib to ensure proper mating. Contact cavities are numbered on the BACK of each connector to provide circuit identification.

3. ASSEMBLY PROCEDURES (see Figure 1)

Refer to the chart for the applicable pin and socket contacts, crimp tooling, and instructional material. Make sure selected cable contains the required number of wires within the specified size (AWG) and insulation diameter.

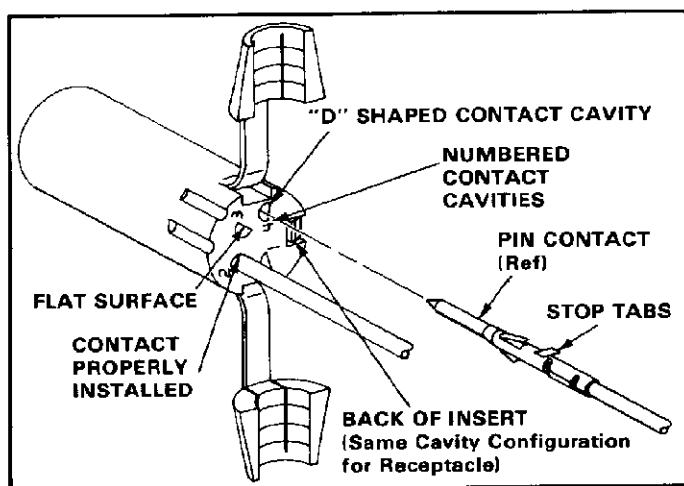
A. Plug Connector

Proceed as follows:

1. Slide plug body onto cable before removing cable jacket.
2. Remove 13/16-in. of cable jacket (outer insulation). Strip wires and crimp pin contacts according to instruction material packaged with crimp tooling.
3. Insert crimped contacts into BACK of plug insert. Grip insulation of wire (directly behind contact) and align contact with desired contact cavity. Orient stop tabs with flat surface of "D" shaped cavity and insert contact straight into cavity until it bottoms. Pull back lightly on wire to be sure contact is locked in place. See Figure 2.

NOTE

Normally an insertion tool is NOT needed. However, if the wires are too fragile or difficult to handle, use the insertion tool listed in Figure 1.

**Fig. 2**

4. Position strain relief collets against cable jacket. Make sure jacket extends within entire length of collets — if NOT — twist jacket (360° max) and push it toward insert until jacket extends within collets.
5. Align insert alignment groove with body detent and push insert into body until bottomed (make sure cable jacket remains extended within collets).
6. Check to be sure insert locking latch is engaged. If not, press on insert mating face and simultaneously push cable toward insert. When a slight relaxation on the cable is felt, simultaneously pull back on cable and press insert into body until locking latch engages body latch slot.

The plug is now assembled. If necessary to disassemble, depress insert locking latch and push in-

ward on cable — insert should come out of body with ease. AMP Extraction Tool 91136-1 is used for removing pin contacts from the plug insert. The tool is inserted into the FRONT of the insert and the contact is removed from the BACK of the insert. Refer to AMP Instruction Sheet IS 7859, packaged with the tool, for the proper extraction procedure.

B. Receptacle Connector

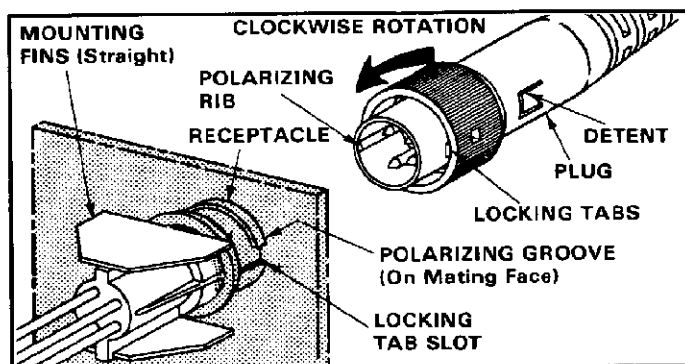
Proceed as follows:

1. Make a cutout on the panel using the recommended dimensions provided in Figure 1.
2. Remove 13/16-in. of cable jacket (outer insulation). Strip wires and crimp socket contacts according to instruction material packaged with crimp tooling.
3. Insert terminated cable through BACK of panel cutout.
4. Insert crimped contacts into BACK of receptacle housing. Grip insulation of wire (directly behind contact) and align contact with desired contact cavity. Orient stop tabs with flat surface of "D" shaped cavity and insert contact straight into cavity until it bottoms. Pull back lightly on wire to be sure contact is locked in place. See Figure 2.

NOTE

Normally an insertion tool is NOT needed. However, if the wires are too fragile or difficult to handle, use the insertion tool listed in Figure 1.

5. Align receptacle antirotation key with panel cutout antirotation slot (punched side — burless). Push receptacle through panel cutout until shoulder bottoms against panel.
6. Allow mounting fins to spring away from center until straight — do NOT allow them to bow toward center. See Figure 3.

**Fig. 3**

The receptacle is now assembled. If necessary to disassemble, deflect mounting fins toward receptacle and push receptacle out FRONT (punched side) of panel. AMP Extraction Tool 91136-1 is used for

removing socket contacts from the receptacle housing. The tool is inserted into the FRONT of the housing and the contact is removed from the BACK of the housing. Refer to AMP Instruction Sheet IS 7859, packaged with the tool, for the proper extraction procedure.

4. MATING THE CONNECTORS

Proceed as follows:

1. Check plug connector to be sure insert polarizing rib is aligned with body locking tabs.

2. Orient polarizing rib with receptacle polarizing groove and insert plug until bottomed.

3. Rotate plug CLOCKWISE 45° until detent snaps into engagement groove (audible click). The connectors are now fully mated.

To unmate connectors, rotate plug COUNTER-CLOCKWISE 45° until detent enters alignment groove — then pull plug out of receptacle.