

ASSEMBLY INSTRUCTIONS
FOR A-MP* 42 POSITION
SERIES "M" CONNECTORS

IS 7179	
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REVISED	

CONNECTOR PRODUCTS
DIVISION

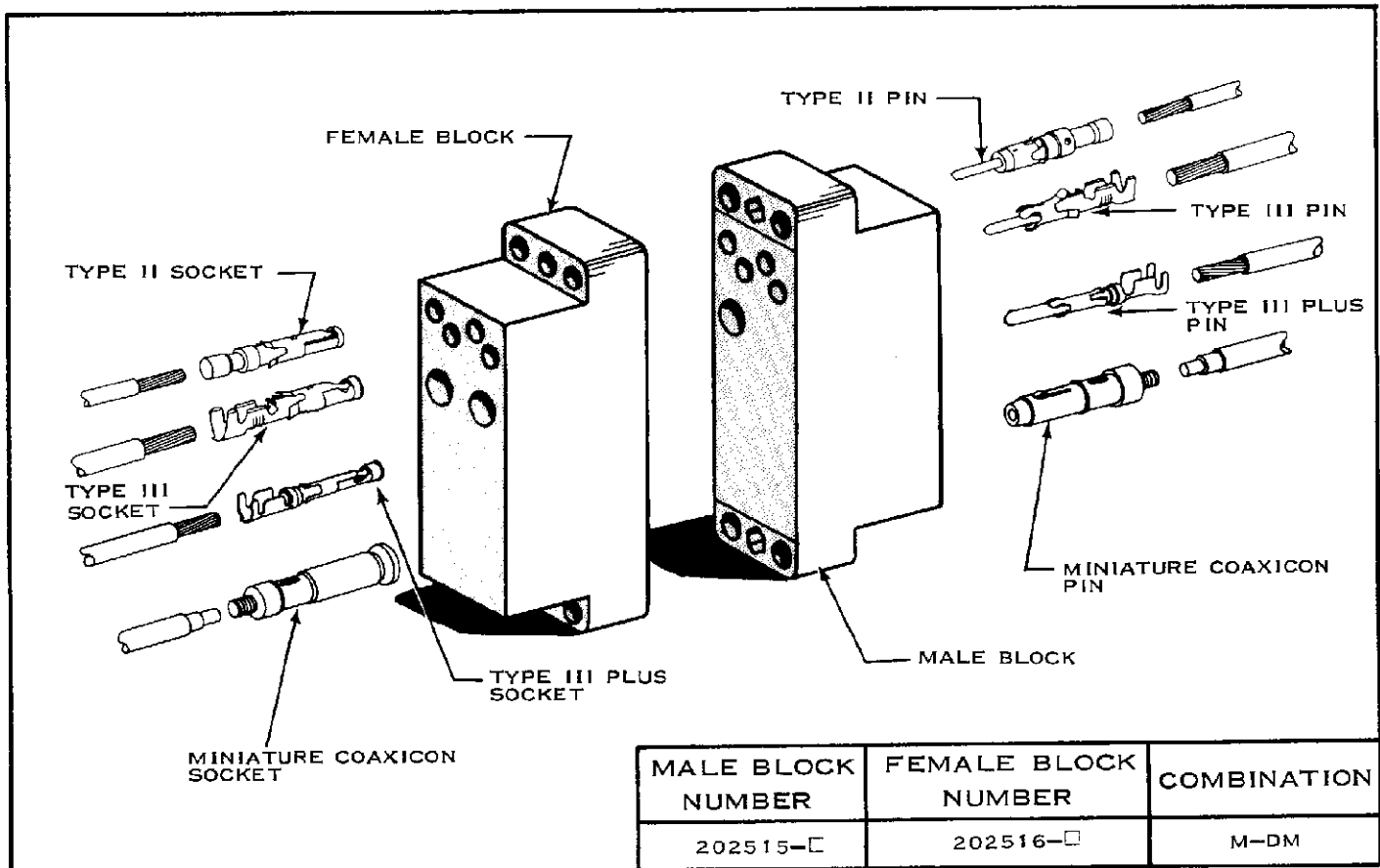


Fig. 1

1. These instructions cover the A-MP 42 Position Series "M" Connectors shown in Figure 1. Read them carefully before assembling the Connector.

2. CONTACT SELECTION

- Select proper A-MP Miniature COAXICON® Contacts for use in these Connectors from AMP Instruction Sheet No. 1770.
- Select A-MP Type II, III or III Plus Contacts for use in these Connectors from AMP Instruction Sheet No. 1379.

3. CONTACT CRIMPING

- Crimp A-MP Miniature COAXICON Contacts according to AMP Instruction Sheet No. 1770.

- Crimp A-MP Type II, III and III Plus Contacts using the Tools and instructions referenced on AMP Instruction Sheet No. 1379.

4. CONTACT INSERTION

- Push Contact all the way into Connector Block. See Figure 1.
- Pull back lightly on Wire to make sure Contact is properly inserted.

NOTE: When inserting Contacts crimped to small, flexible Wire, use AMP Insertion Tool No. 91002.

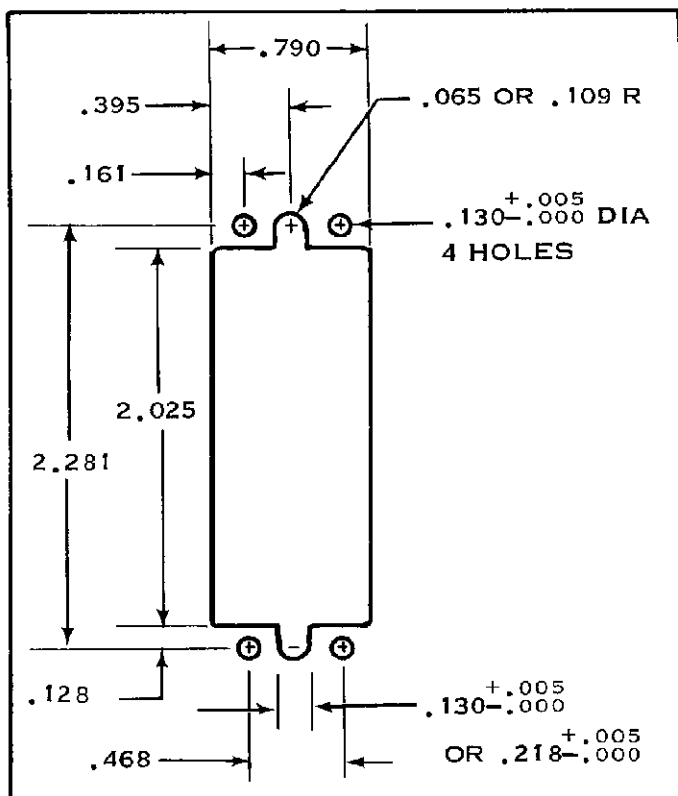


Fig. 2

5. CONTACT EXTRACTION

- Extract A-MP Miniature COAXICON Contacts according to AMP Instruction Sheet No. 1770.
- Remove A-MP Type II, III and III Plus Contacts using A-MP Extraction Tool No. 305183. See AMP Instruction Sheet No. 1216.

6. PANEL MOUNTING

- Make a cutout in the Panel using the Panel Cutout Dimensions in Figure 2.
- Mount the Connector Block to the Panel using A-MP Series "M" Guide Pins and Sockets (see AMP Instruction Sheets No. 7054 or 7055) or 4-40 Screws.

NOTE: The AMP Instruction Sheets referenced above are packaged with A-MP Tools, Connectors and Accessories.