

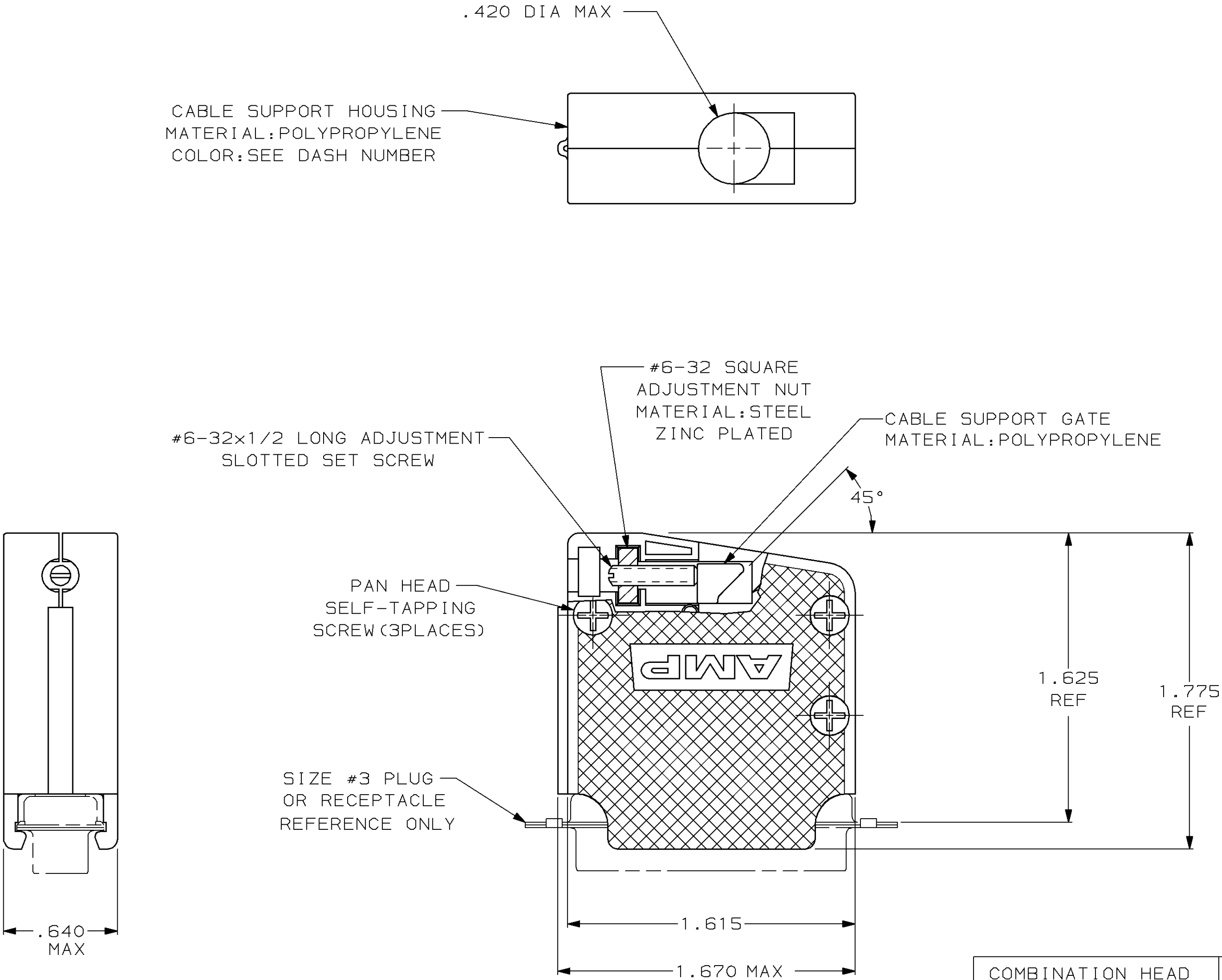
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LOC	DIST	P	F	ZONE	LTR	DESCRIPTION	DATE	APPD
FT	38				S	REDRAWN ON CAD	4-24-90	-
					T	REV PER EC 0020-782-95	06 DEC 95	CS
					U	REV PER EC 0320-22-97	09 APR 97	DK



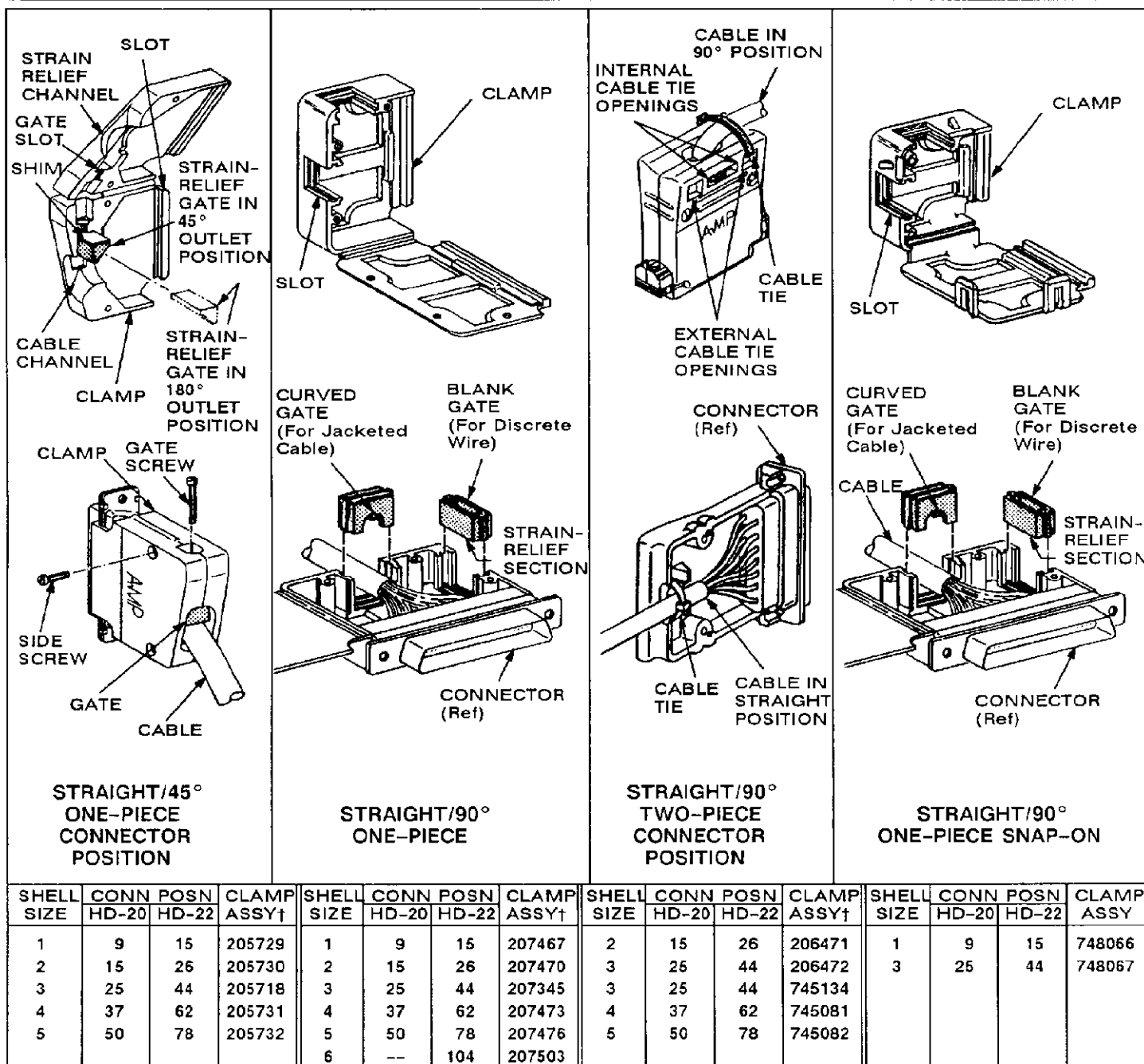
- 1 PARTS PACKAGED UNASSEMBLED.
- 2 COMPONENTS INDIVIDUALLY BULK PACKED & SHIPPED AS A UNIT PACKAGING KIT.

COMBINATION HEAD		205718-4
COMBINATION HEAD	AS SHOWN	205718-1
SCREW VERSION	PACKAGING	PART NO

DO NOT SCALE PRINT. UNLESS SPECIFIED DIMENSIONS IN INCHES TOLERANCES ON : 2 PLC DEC ± - 3 PLC DEC ± .005 ANGLES ± 0°30'	DR 04/24/90 A. STAUB BG CHK 06/15/90 W.G. LENKER APPD 07/09/90 J. WESTMAN APPD 07/16/90 J. ASSINI PRODUCT SPEC - APPLICATION SPEC - WEIGHT -	<div><div>AMP</div><div>AMP INCORPORATED Harrisburg, Pa. 17105</div></div> <div>NAME SELF TAPPED 45°/180° CABLE SUPPORT CLAMSHELL, SIZE 3 ASSEMBLY, AMPLIMITE™ HD-20</div> <div>SIZE <b>C</b></div> <div>FSCM NO 00779</div> <div>DRAWING NO 205718</div> <div>SCALE 2:1</div> <div>SHEET 1 OF 1</div>		
MATERIAL MOLDED PARTS: BLACK POLYPROPYLENE HARDWARE: COLD ROLLED STEEL PER ASTM A108	FINISH HARDWARE: ZINC PLATED PER ASTM B633, TYPE 2, CLASS SC1			

**AMP**AMP INCORPORATED  
HARRISBURG, PA 17105

REDUCED FOR PACKAGING

**IS 7555**CUSTOMER HOTLINE  
1 800 722-1111AMP\* CABLE CLAMP ASSEMBLIES  
FOR  
AMPLIMITE\* HD-20 AND HD-22 CONNECTORSRELEASED  
8-15-88

† RECOMMENDED ONLY FOR HDM, HDC, AND HDP CONNECTORS

Fig. 1

**1. INTRODUCTION**

This instruction sheet covers the installation of cable clamp assemblies for AMPLIMITE HD-20 and HD-22

connectors, types HDM, HDC, HDP, and HDE. See Figure 1. Read this instruction sheet thoroughly before attempting to install the cable clamp assemblies.

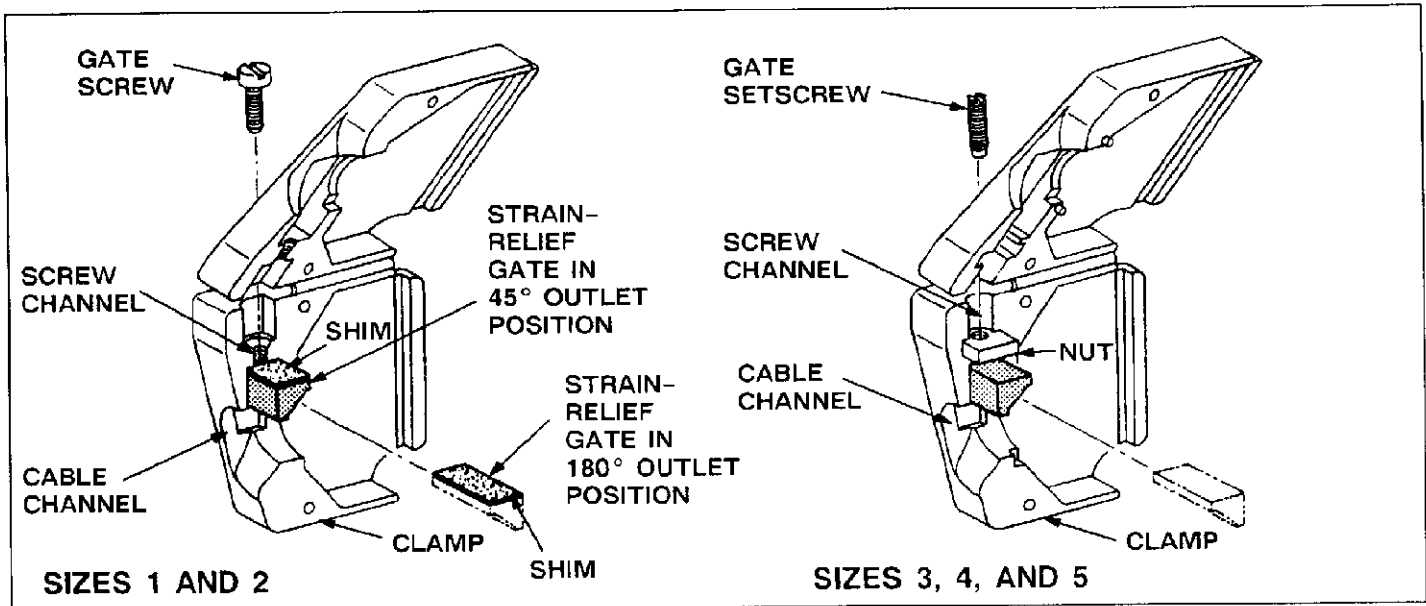


Fig. 2

## 2. DESCRIPTION

There are four types of cable clamp assemblies covered in this instruction sheet:

- Straight/45° one-piece
- Straight/90° one-piece
- Straight/90° two-piece
- Straight/90° one-piece snap-on

Except for the snap-on version, the clamp assemblies are held together by screws supplied in the kit.

The cable clamp assemblies can be used on either plug or receptacle connectors.

## 3. ATTACHING CABLE CLAMP ASSEMBLIES

Insert the contacts into the connector as described on IS 7514, the instruction sheet packaged with the connector. Select the proper cable clamp from the table of Figure 1.

### A. Straight/45° One-Piece Assembly

1. Position the flange of the connector into the cable clamp slot shown in Figure 1. Place the longer row of contact positions in the bottom so that the wires are not pinched when the clamp is closed.
2. Position the cable in the strain-relief channel.
3. Position the strain-relief gate in the clamp for either a 45° or a 180° outlet. The gate must enter the gate slot in the clamp.

4. For Size 1 or 2 shell, place the brass shim between the gate and the screw channel. See Figure 2.

5. Position the cable in the cable channel and close the clamp.

6. Secure the clamp with self-tapping screws, as follows:

- 1 screw for shell size 1
- 2 screws for shell size 2
- 3 screws for shell sizes 3, 4, or 5.

7. Secure the gate screw or gate setscrew. Thread the gate screw in until the gate is firmly holding the cable. Do NOT overtighten the screw.

#### NOTE

*Size 1 and 2 shells use a black gate screw. Size 3, 4 and 5 shells use a gate setscrew and nut instead of the black gate screw.*

8. Push a small amount of wire into the clamp to provide strain relief on the wire bundle. Thread the gate screw in until the gate is firmly holding the wires. Do NOT overtighten the screw.

### B. Straight/90° One-Piece Assembly

A carrier strip with strain-relief gates is packaged with each assembly. The size of the gate used depends on the diameter of the cable. Discrete-wire bundles use blank gates; jacketed cables use curved gates.

1. Remove the proper gate from the carrier strip.
2. Insert the connector into the clamp with the longer row of contacts in the bottom. Position the cable in the strain-relief channel.
3. Insert the gate into the cable clamp slot, as shown in Figure 1.

**NOTE**

*The largest blank (unused outlet) can be installed with either flat side in the slot. The other blank gates should be installed with the strain-relief section touching the cable.*

4. Position the cable over the gate and close the cable clamp.
5. Thread the screws into the holes in the cable clamp and tighten them to complete the assembly.

**C. Straight/90° Two-Piece Assembly**

1. Lay the connector and cable in one half of the clamp. Thread a cable tie through the internal tie openings and secure the cable to the clamp as tightly as possible.
2. Install the other clamp half, and captivate the two mounting screws.
3. Secure the assembly with the fillister-head screws and hex nuts supplied.

**NOTE**

*If the wire bundle is dressed at 90°, use cable ties through the external tie openings after the clamp halves are assembled. The cable tie knots should be tucked into the cable clamp for a neater appearance.*

**D. Straight/90° One-Piece Assembly (Snap-On)**

A carrier strip with strain-relief gates is packaged with each assembly. The size of the gate used depends on the diameter of the cable. Discrete-wire bundles use blank gates; jacketed cables use curved gates.

1. Remove the proper gate from the carrier strip.
2. Insert the connector into the clamp with the longer row of contacts in the bottom. Position the cable in the strain-relief channel.
3. Insert the gate into the cable clamp slot, as shown in Figure 1.

**NOTE**

*The largest blank (unused outlet) can be installed with either flat side in the slot. The other blank gates should be installed with the strain-relief section touching the cable.*

4. Close the cable clamp.
5. Snap the clamp tightly together, making sure the latches are firmly latched.