



Figure 1

1. INTRODUCTION

This Instruction Sheet covers the AMPLIMITE pin and socket solder pot contacts shown in Figure 1. Read this material thoroughly before starting.

Reasons for reissue are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

These contacts can be used in any of the AMPLIMITE housings that accept crimp type contacts. The wire barrel of the contacts will receive various wire sizes with a maximum size of 18 AWG.

The wire barrel has a beveled wire entry which provides an even flow of solder.

3. SOLDERING WIRE IN CONTACT

The contact must be stabilized during soldering. This can be done with the connector itself, or with a suitable, non-metallic soldering support. When the connector is used, the contact shoulder should be inserted into the back of the contact cavity (wire side of connector), just enough to stabilize the contact.

NOTE



Do NOT over insert the contact in the connector, or you may NOT be able to solder the contact - or you may damage the connector.

1. Place the contact in a stabilizer as shown in Figure 1.

2. Strip 3.5 mm [9/64 in.] of insulation from the conductor, as indicated in Figure 1.

3. Insert the wire into the wire barrel of the contact until bottomed.

4. Solder the wire in the contact.

4. CONTACT INSERTION AND EXTRACTION

Contacts with wires that are stiff enough to withstand insertion force can be inserted without the use of a tool. A tool will be required for contacts with fragile wires, and to remove contacts from the connector. Use Insertion/Extraction tool 91067-1 and refer to Instruction Sheet 408-7508, packaged with the tool.

1. Insert a contact by aligning it with the back of the contact cavity and inserting it straight in until bottomed. Pull back lightly to be sure it is locked into the cavity.
2. Extract a contact by inserting the extraction tool tip into the back of the contact cavity until it is bottomed. Grip the wire and tool, and pull the contact straight out of the connector.

5. REVISION SUMMARY

The format of this document was updated to meet corporate requirements.