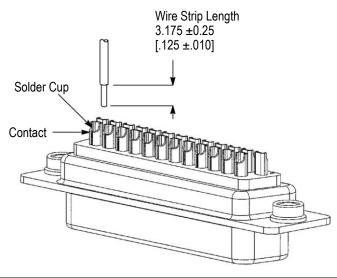


1	REVISIONS	ò				
	DESCRIPTION			DATE	DWN	APVD
)—	15-010090			16JUL201	5 AP	DG
	BLACK CI BLACK CO					
		CONTACT AF .000050] M				
		ONTACT ARE [.000050] M				
F	FULL SHEL	L				
0	00762[.00	0300] OVEF	R ENTIRF	SHFII		
PL	ATING ALL	CONTACT AF OVER 0.00 20000200 AMPERES	0127[.00			
00 1 11×	MUM.	T DC 500V	IPLIMITE	SERIES.		-
)0 N XIN TIC VIA	MUM. ON RECEPT X WIRE MIN ON C D0127[.000 NO	ACLE IN AM ONTACT ARI 2050] MIN	EA 0.002 NICKEL	229[.0000 PLATING	- 5-7479	
ю м КIN - IC ЛА]	MUM. N RECEPT X WIRE MIN ON C D0127[.000 NO YES	ACLE IN AM ONTACT ARI 2050] MIN NO YES	EA 0.002 NICKEL	229[.0000 PLATING	- 5-7479 5-7479	04-8
)0 N XIN TIC VIA	MUM. ON RECEPT X WIRE MIN ON C D0127[.000 NO	ACLE IN AM ONTACT ARI 2050] MIN	EA 0.002 NICKEL	229[.0000 PLATING	- 5-7479	904-8 904-5
ю м КIN - IC ЛА]	MUM. ON RECEPT X WIRE MIN ON C DO127[.000 NO YES NO	ACLE IN AM ONTACT ARI 2050] MIN NO YES YES	EA 0.002 NICKEL	229[.0000 PLATING	5-7479 5-7479 5-7479	904-8 904-5 904-2
ю м КIN - IC ЛА]	MUM. N RECEPT X WIRE MIN ON C DO127[.000 NO YES NO NO	ACLE IN AM ONTACT ARI DO50] MIN NO YES YES YES	EA 0.002 NICKEL	229[.0000 PLATING	5-7479 5-7479 5-7479 5-7479	904-8 904-5 904-2 94-9
10 N (IN (IN (IN (IN) (IN) (IN) (IN) (IN)	MUM. N RECEPT X WIRE MIN ON C D0127[.000 NO YES NO YES NO YES NO	ACLE IN AM ONTACT ARI DO50] MIN NO YES YES YES YES YES YES YES	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4	5-7479 5-7479 5-7479 5-74790 74790 74790	904-8 904-5 904-2 904-9 94-8 94-5
10 N (IN (IN (IN (IN) (IN) (IN) (IN) (IN)	MUM. N RECEPT X WIRE MIN ON C D0127[.000 NO YES NO NO YES NO NO NO NO NO NO NO	ACLE IN AM ONTACT ARI DO50] MIN NO YES YES YES YES YES YES NO	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4 4 4 4	5-7479 5-7479 5-7479 5-74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4
)0 N KIN TIC	MUM. N RECEPT X WIRE MIN ON C DO127[.000 NO YES NO NO YES NO NO NO NO NO NO NO NO NO	ACLE IN AM ONTACT AR DO50] MIN NO YES YES YES YES YES YES NO YES	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4 4 5 5 4	5-7479 5-7479 5-7479 5-74790 74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4 04-2
ю м КIN - IC ЛА]	MUM. N RECEPT X WIRE MIN ON C D0127[.000 NO YES NO NO YES NO NO NO NO NO NO NO	ACLE IN AM ONTACT ARI DO50] MIN NO YES YES YES YES YES YES NO	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4 4 5 5 4	5-7479 5-7479 5-7479 5-74790 74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4 04-2
	MUM. N RECEPT X WIRE MIN ON C D0127[.000 NO YES NO NO YES NO NO CLINCH NUTS	ACLE IN AM ONTACT AR DO50] MIN NO YES YES YES YES YES YES NO YES GROUNDING INDENTS	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 5 5 5 5 5 5 5 5 5 5 5 5	5-7479 5-7479 5-7479 5-74790 74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4 04-2
	MUM. N RECEPT X WIRE MIN ON C D0127[.000 NO YES NO NO YES NO NO CLINCH NUTS	ACLE IN AM ONTACT AR DO50] MIN NO YES YES YES YES YES YES NO YES	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 5 5 5 5 5 5 5 5 5 5 5 5	5-7479 5-7479 5-7479 5-74790 74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4 04-2
	MUM. N RECEPT X WIRE MIN ON C DO127[.000 NO YES NO NO YES NO NO YES NO NO CLINCH NUTS PLUG AS	ACLE IN AM ONTACT AR DO50] MIN NO YES YES YES YES YES YES NO YES GROUNDING INDENTS	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4 4 5 5 5 5 5 5 5 5 5 5	5-7479 5-7479 5-74790 74790 74790 74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4 04-2
	MUM. N RECEPT X WIRE MIN ON C DO127[.000 NO YES NO NO YES NO NO YES NO NO CLINCH NUTS PLUG AS	ACLE IN AM ONTACT ARE DO50] MIN NO YES YES YES YES YES YES NO YES GROUNDING INDENTS TE SY, SOLDE SN, HD-2	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4 4 5 5 5 5 5 5 5 5 5 5	5-7479 5-7479 5-74790 74790 74790 74790 74790 74790 74790	004-8 004-5 004-2 04-9 04-8 04-5 04-4 04-2
	MUM. N RECEPT X WIRE MIN ON C DO127[.000 NO YES NO NO YES NO NO YES NO NO CLINCH NUTS PLUG AS 9 PO CODE DRAWING	ACLE IN AM ONTACT ARE DO50] MIN NO YES YES YES YES YES YES YES YES SYES GROUNDING INDENTS TE SY, SOLDE SN, HD-2	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 4 4 5 5 5 5 5 5 5 5 5 5	5-7479 5-7479 5-74790 74790 74790 74790 74790 74790 74790	904-8 904-5 904-2 904-2 94-9 94-8 94-5 94-4 94-2 NO.
	MUM. N RECEPT X WIRE MIN ON C DO127[.000 NO YES NO NO YES NO NO YES NO NO YES NO NO PLUG AS 9 PO	ACLE IN AM ONTACT ARI DO50] MIN NO YES YES YES YES YES YES NO YES GROUNDING INDENTS GROUNDING INDENTS TE SY, SOLDE SN, HD-2	EA 0.002 NICKEL	229[.0000 PLATING 4 4 4 4 4 4 4 5 5 5 5 5 5 5 5 5 5 5 5	5-7479 5-7479 5-74790 74790 74790 74790 74790 74790 74790 74790 74790	904-8 904-5 904-2 94-9 94-8 94-5 94-4 94-2 NO.





CON	CONNECTOR		
PLUG	RECEPTACLE	NUMBER OF POSITIONS	
747904-[]	747905-[]	9	
747908-[]	747909-[]	15	
747912-[]	747913-[]	25	
747916-[]	747917-[]	37	
	Figure 1		

1. INTRODUCTION

This instruction sheet describes contact soldering and application for the AMPLIMITE HDP-20 connectors with solder cup contacts listed in Figure 1.

Association of Connecting Electronics Industries (IPC)-S-815, "General Requirements for Soldering Electronic Interconnections" is recommended for establishing quality solder guidelines.

Read these instructions and all referenced material carefully before soldering any contacts.



NOTE

Dimensions on this instruction sheet are in millimeters [with inch equivalents in brackets]. Figures are for reference only and are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

Each connector is completely assembled with duplex tin/copper finished non-removable solder cup contacts. The metal connector shells are available in either EMI/RFI-shielded or non-shielded. All plug connectors feature grounding indents. The contacts will accept solid or stranded wire with a maximum individual wire size of 20 AWG. The contacts accept tinned leads and will provide secure strain relief for the wires when properly soldered.

The connectors will mate with other corresponding AMPLIMITE connectors regardless of termination type.

3. CONTACT SOLDERING



Make sure to follow all local safety practices when working with solder.

1. Ensure that the surfaces of the connector and wire(s) to be soldered are clean and free of any contaminants that may inhibit solderability.

© 2015 TE Connectivity family of companies All Rights Reserved *Trademark TOOLING ASSISTANCE CENTER 1-800-722-1111 PRODUCT INFORMATION 1-800-522-6752 This controlled document is subject to change. For latest revision and Regional Customer Service, visit our website at www.te.com.

TE Connectivity, TE connectivity (logo), and TE (logo) are trademarks. Other logos, product, and/or company names may be trademarks of their respective owners.



- 2. Strip the wire(s) to the dimension given in Figure 1.
- 3. Using a rosin flux and lead-free SAC305 or SAC405 solder, coat the stripped portion of the wire(s) with the flux. Insert a wire into a solder cup until the conductor is bottomed in the cavity.



NOTE

It is common to use heat-shrink tubing over solder joints to insulate the exposed solder connection at the cup. If using heatshrink tubing, ensure that tubing sections are cut to the proper length and placed on the wire(s) prior to soldering. After wires are soldered, slide the tubing over the solder connections and shrink it with an appropriate heat source.

- 4. Using a low-wattage soldering iron, heat the solder cup and allow the solder to flow into the cup until the cup is filled, but not overfilled.
- 5. Continue soldering wires until all terminations are complete.
- 6. Clean the soldered connections with a suitable alcohol and water rinse to remove flux and solder residue.



NOTE

DO NOT re-use a terminated contact by removing the wire.

4. REVISION SUMMARY

- Updated document to corporate requirements
- Corrected text in Paragraph 3.3