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OPERATION AND MAINTENANCE OF AMP TOOLING KIT 734155-1

Instruction Sheet
I - 042 - 160
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INTRODUCTION.

This tooling kit is designed to assemble AMP-Latch type connectors using round conductor ribbon cable. Read these instructions carefully before using the tooling assembly.

DESCRIPTION.

The tooling kit consists of :

1. Pistol grip handtool 169756-1.
2. Head (change) 734169-1.
3. Adapter holder 734154-1.
4. Table clamp 169754-1.
5. Case 169753-1.

The pistol grip handtool features the following :
a cam handle that actuates the terminating mechanism inside the head, and a ratchet pawl that can be used to release the handle before it is fully closed.
The ratchet will not release the cam handle untill it is fully bottomed.

Note : The head can also be used on AMP electric press, p.n. 169770-1.

SET-UP PROCEDURE.

Assemble the kit like fig. 1.

Place the appropriate adaptor to correspond to the product you want to terminate in the tool fig. 2.

(Adapters must be ordered separately) refer to fig. 5 for recommended adapters.
The adapter features a fluted plate and a cable stop, they will accept the full complement of connector sizes through 64 positions.

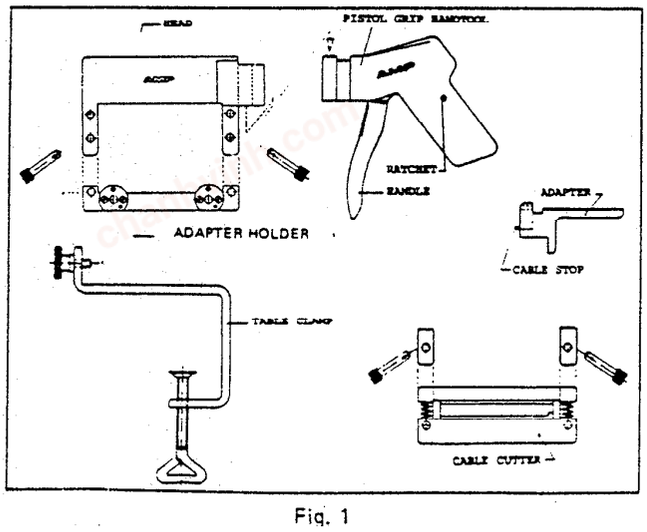


Fig. 1

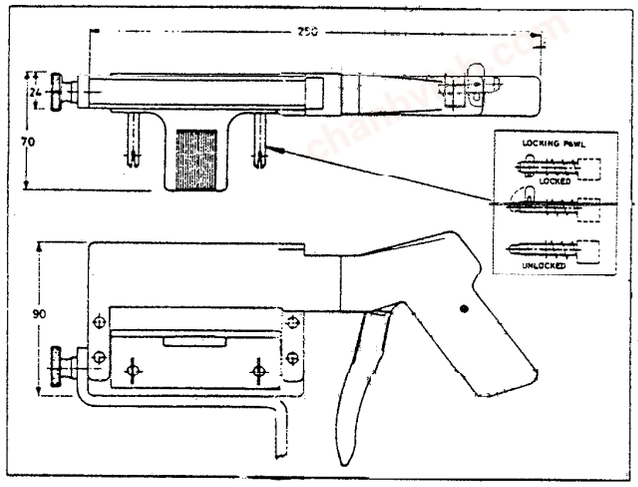
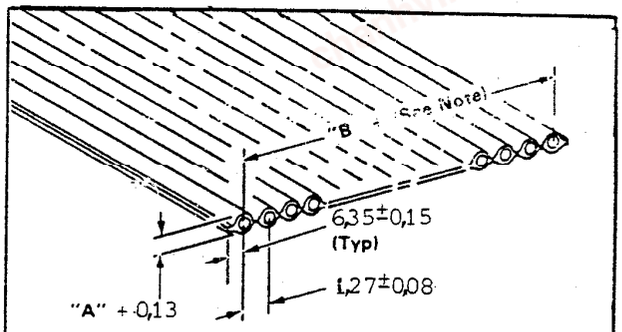


Fig. 2

CABLE REQUIREMENTS.

The tooling assembly will terminate ribbon cable refer to fig. 3, for the recommended cable dimensions. The cable end must be cut 90 degr. to the edge of the cable, otherwise a improper termination will result.
We suggest you use a guillotine-type cable cutt such as tool pn. 169767 that can be affixed to the pistol grip tool assy, fig. 1 or handtool p.n. 169305.



NOTE: ACCUMULATIVE TOLERANCE FOR CABLE CONDUCTORS 1 THROUGH 34 IS ±0,25 AND THROUGH 60 IS ± 0,38

CONDUCTOR		DIMENSION	
SIZE (AWG)	TYPE	"A"	"B"
26	Solid	0,94	1,27 x (Total No. of Conductors Minus One)
28	Stranded or Solid	↓	
30	Solid		

Fig. 3

APPLICATION PROCEDURE (fig 4).

1. Slide adapter away from head.
2. Set cable stop in position, for flush termination or daisy chaining termination.
3. Place connector, with cover down in the middle of the adapter.

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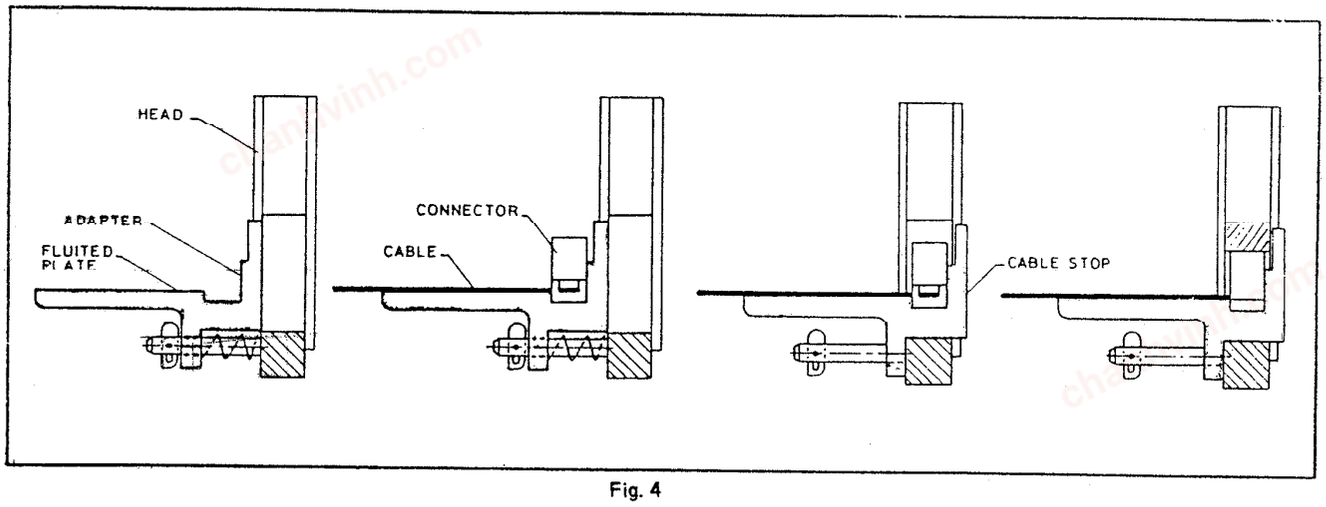


Fig. 4

Note :
If you are terminating a HDF plug connector, place a insert into mating face of the plug to prevent possible damage to pin protector wall during termination (inserts are packet by the adaptor).

3. Place cable on fluted plate.
   Slide cable in the connector untill it bottoms on cable stop, or coming thru for daisy chaining application.
4. Align cable against flute plate and hold it.

Note : If terminating latch receptacle connectors, align receptacle locator with connector.

Slide adapter toward the head untill the adapter butts against the adapter holder assembly.

6. Squeeze handle of pistol grip till ratchet releases.
7. Release handle and remove connector.
8. Check to be sure housing assembly is bottomed on cover. This completes the termination procedure.

Adapter	Partnumber
Dutch/US latch rec.	734143-1
Italian Latch rec.	734144-1
Japanese Latch rec.	734145-1
Card Edge	734146-1
HDF female	734147-1
*HDF Male	734148-1
Champ Latch	734149-1
Eurocard conn.	734151-1
HDF female 50 pos.	734152-1
HDF Male 50 pos.	734153-1
DIL LATCH	

Fig. 5

* Incl. inserts.

Note : Inserts for HDF male p.n. 169760-1.

TOOL CERTIFICATION.

The procedures described in the following text have been established to assure quality and reliability of AMP Terminating Tools. A brief check should be made daily and a more detailed inspection should be scheduled by your quality control group.

1. DAILY MAINTENANCE.

Each operator should be aware of, and responsible for the following :

a. Remove dust, moisture and other contaminants with a clean brush, or soft, lint free cloth.
   Do NOT use objects that could damage the tool.
b. Make sure all components are in place and properly secured.
c. Actuate handle assembly to ensure mechanism inside head move smoothly.

2. QUALITY CONTROL MAINTENANCE.

Regular inspections should be performed by your quality control personnel with a record of quality control inspections remaining with the personnel responsible for the tool. We recommend one inspection a month; however, operator training and skill, amount of use, ambient working conditions and your company's established standards are all factors in establishing frequency of inspections. These inspections should be done in the following sequence :

a. Remove any accumulated film with a suitable cleaning agent that will NOT affect plastic material.
b. Make sure all components are in place and properly secured.
c. Make a few test terminations and inspect the termination.
d. Check for worn, chipped, cracked, or broken areas. If damage is evident, return the tool to AMP for evaluation and repair.