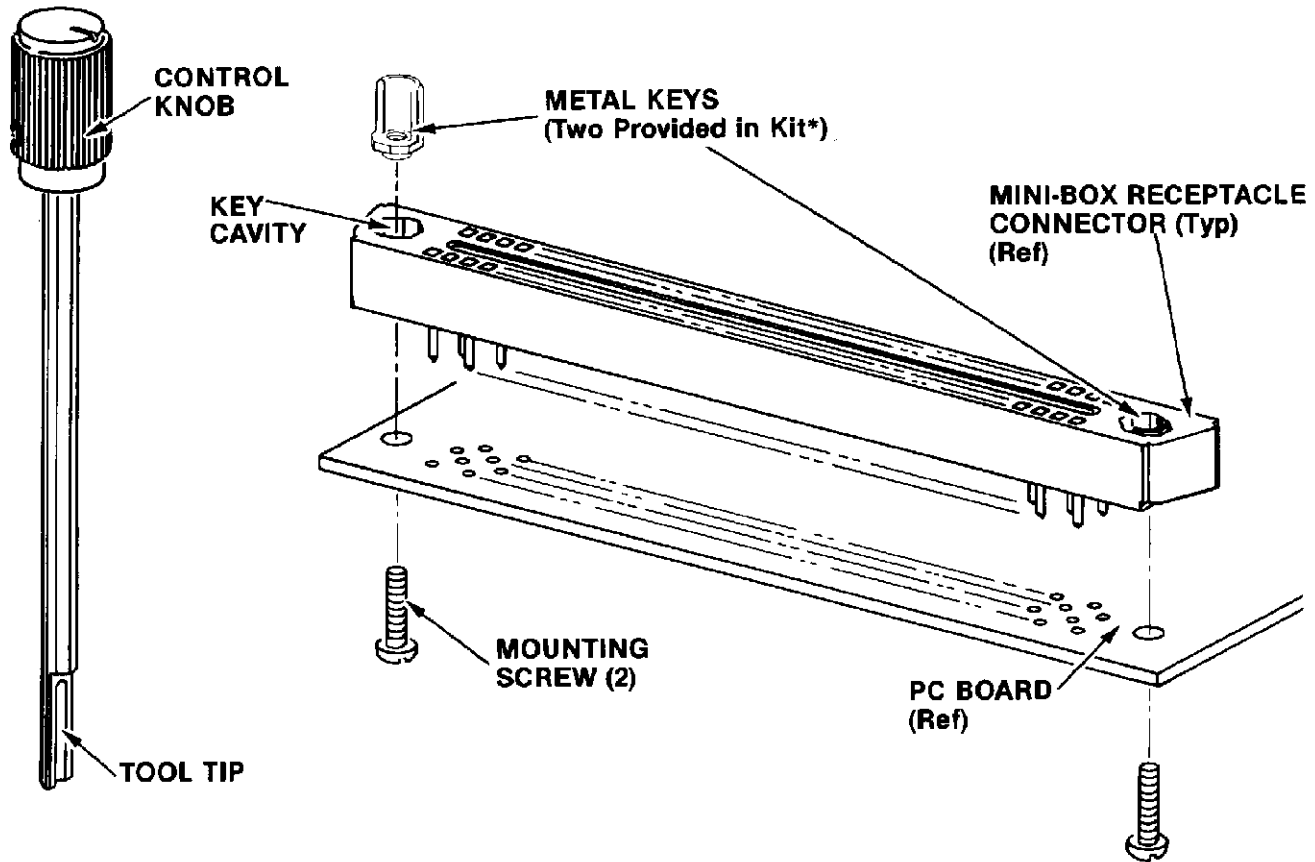


CUSTOMER SERVICE HOTLINE 1-800-722-1111

REDUCED FOR PACKAGING

**ALIGNMENT
TOOL 58300-1
(Used with AMP Keying
Kit No. 530721-3)**



*KEYING KIT 530721-3, WHICH INCLUDES TWO STAINLESS STEEL KEYS AND TWO NO. 2-56 SCREWS, MUST BE ORDERED SEPARATELY.

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Alignment Tool 58300-1 which is used with AMP Mini-Box receptacle connectors. The tool helps align external metal keys into their proper positions and prevents rotation during keying installation. External keys provide polarization of multiple connectors to prevent mismatching. Read these instructions and other references thoroughly before proceeding.

2. DESCRIPTION (Figure 1)

The tool features a stationary control knob and an octagonal tool tip. AMP Keying Kit No. 530721-3

includes two stainless steel metal keys and two No.2-56 stainless steel screws which mount the keys and fasten the assembly to the printed circuit (pc) board.

The tip of the tool and the raised sides of the metal key are identical. When positioned together, they nest firmly in the octagonal mounting ear without rotating.

NOTE

If the color of the Mini-Box receptacle is BLACK, use AMP Clinching Tool 91117-2 and procedures in IS 7894 to press-fit key into keyhole prior to screw installation. If receptacle color is BROWN, hand-insert keys into keyholes.

3. KEY INSTALLATION PROCEDURE

Before proceeding, make certain that the pc board layout, keying pattern, receptacle connectors, and keying kits are compatible. Refer to Figures 2 and 3 and proceed as follows:

1. Orient key in proper keying position in octagonal hole in connector ear. Insert key by hand (in BROWN connectors), or with AMP Clinching Tool 91117-2 (in BLACK connectors). Refer to Figure 2.

NOTE

AMP Clinching Tool 91117-2 must be used to insert keys before positioning black connectors on the board.

2. Start screw from bottom side of the pc board. Do NOT tighten screw.
3. Position tool tip in opposite half of octagonal ear, so that metal key and tool tip fill the key hole. Make sure the tool is bottomed, and hold it in place. Refer to Figure 3.
4. Torque (tighten) screw to 2 in.-lb. Remove tool.
5. Repeat procedure for each keying location.

NOTE

External keys can be oriented eight ways in each ear — allowing 64 different keying combinations when both ears are used. Check established keying plan before proceeding.

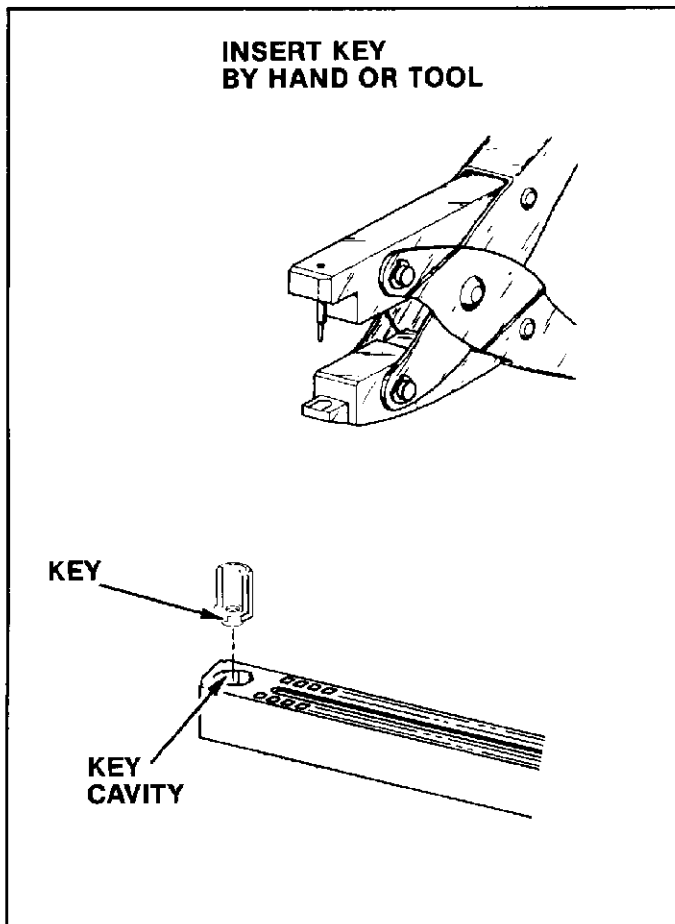


Fig. 2

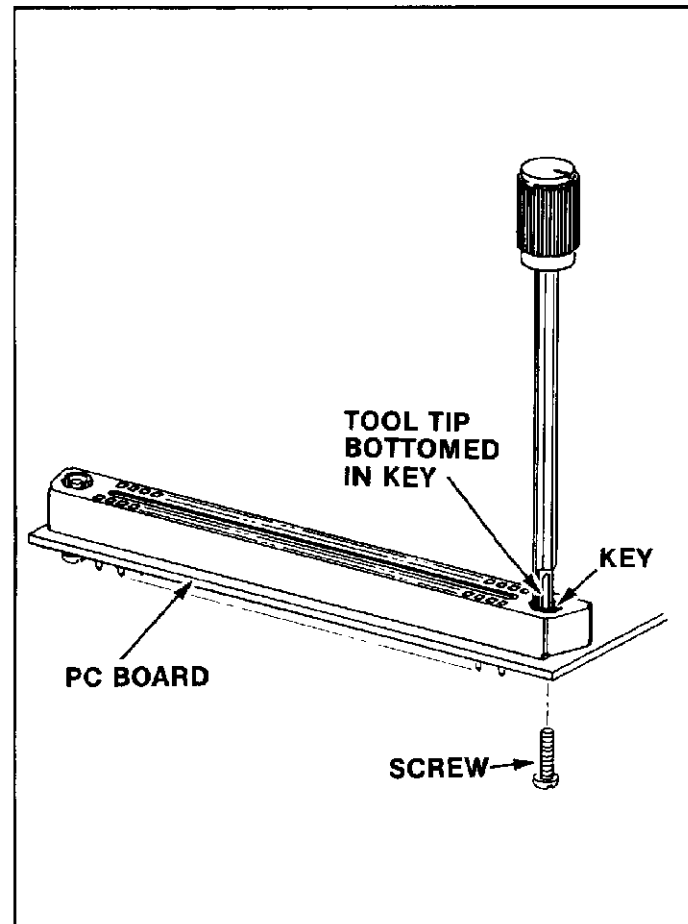


Fig. 3