

**PROPER USE GUIDELINES**

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. AMP hand tools are intended for occasional use and low volume applications. AMP offers a wide selection of powered application equipment for extended-use, production operations.

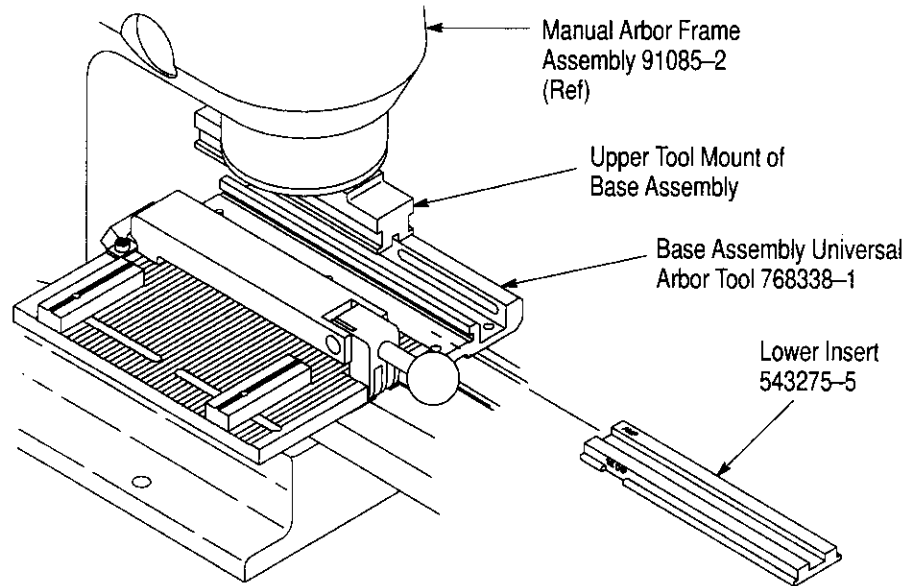


Figure 1

**1. INTRODUCTION**

AMP\* Lower Insert 543275-5 is designed to be installed into AMP Base Assembly Universal Arbor Tool 768338-1 to terminate AMP IDC Terminator Assembly 787910-1 onto ribbon cable. For detailed information concerning the base assembly, refer to Instruction Sheet 408-9827.

The base assembly is used with AMP Manual Arbor Frame Assembly 91085-2 (408-7777), AMP Pneumatic Auto-Cycle Unit 91112-2 (408-7763), or 91112-3 (408-6732). Read this and all referenced material before terminating any connectors.

**NOTE**

*Dimensions on this sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

**2. DESCRIPTION**

The lower insert positions the connector on the tooling and applies an even force over the length of the connector during termination. The insert is marked "1X1 DIP."

**3. SETUP** (Figure 1)

Install the base assembly onto the manual arbor frame or pneumatic auto-cycle unit according to the instructions packaged with the base assembly.

Install the lower insert onto the base assembly as follows:

1. Loosen, but do not remove, the two setscrews in the lower tooling assembly.
2. Slide lower insert into the slot of the lower tooling assembly. Secure into position with the setscrews.
3. Remove the locators and cable stop from the base assembly.
4. Slide the lower tooling assembly under the tool mount to ensure proper clearance of the tool mount and lower tool. If interference exists, a ram height adjustment may be required.

**NOTE**

*Because of the height of the connector, no upper tool is used to terminate the connector. The upper tool mount of the base assembly provides the necessary pressure for the connector.*

**DANGER**

*To avoid personal injury when using pneumatic units, ALWAYS install guards onto the unit before terminating any connectors.*

**4. TERMINATION PROCEDURE** (Figure 2)

1. Slide lower tooling forward and open the cable clamp assembly.

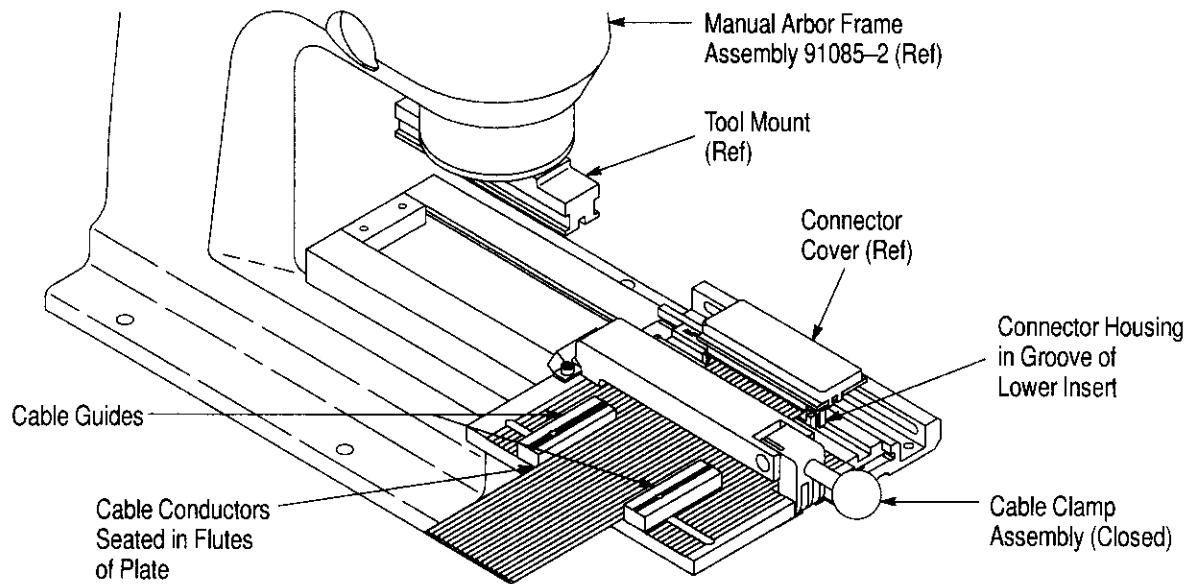


Figure 2

- Place the cable onto the center of the fluted plate. Make sure to seat the cable conductors into the flutes of the plate.

**NOTE**

Cable conductors must stay in the same flutes for the entire length of the fluted plate.

- Position the cable guides against each side of the cable and secure in place.
- Slide the connector, cover up, onto the end of the cable and place the connector housing into the groove in the lower insert.
- Slide the cable until the connector is in the proper position on the cable, then close the cable clamp assembly.
- Cycle the tool to terminate the connector as follows:
  - When using the manual arbor frame, slide the lower tooling assembly under the tool mount and pull down on the tool handle.
  - When using the pneumatic auto-cycle unit (-2), press the foot switch to initiate the cycle. The foot switch may be released immediately, with the unit cycle time adjustable for proper termination.
  - When using the pneumatic auto-cycle unit (-3), slide the lower tooling to the rear of its travel in the base plate. The ram will automatically cycle and terminate the cable to the connector.

- When the ram has moved to the top of its motion, slide the lower tooling out of the crimping area, open the cable clamp, and remove the terminated connector.

- Inspect the connector to make sure that the cover is seated on the housing.

**NOTE**

Refer to the connector customer drawing for specific inspection requirements.

**5. MAINTENANCE AND INSPECTION****5.1. Maintenance**

The lower insert requires little maintenance other than to keep it clean. Remove debris and contaminants from the insert with a clean, soft, lint-free cloth or a clean, soft brush. When not in use, store the insert in a clean, dry area.

**5.2. Inspection**

The lower insert should be inspected and verified with the information provided in Figure 3 immediately upon arrival at your facility and at regularly-scheduled intervals thereafter to ensure that it has not been damaged. Examine the insert for any signs of damage or excessive wear during inspections.

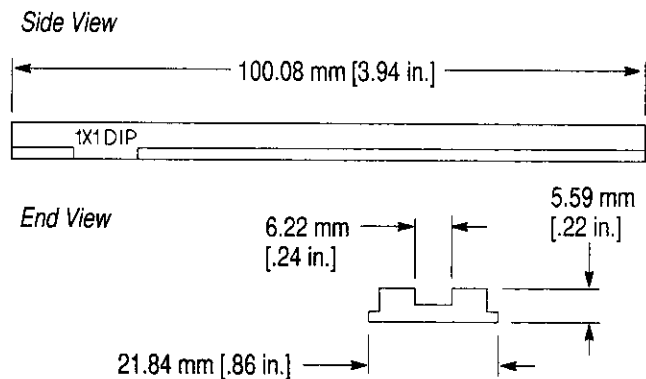


Figure 3