

Fig. 1

## 1. INTRODUCTION

This instruction sheet (IS) covers the use of the AMP Insertion Tool 274249-1 which inserts AMP loose-piece Mag-Mate .050 Tab (Small Box) Terminals listed in Figure 1 into plastic cavities. Read these instructions carefully before inserting any terminals into the cavities.

NOTE

All dimensions presented on this instruction sheet are in inches.

## 2. DESCRIPTION (Figure 1)

The insertion tool features a grooved handle and a clip which holds the terminal while inserting it into the cavity to terminate the magnet wire.

Termination is accomplished by a variation of the insulation displacement technique which consists of inserting the wire into a slotted terminal beam to form

a reliable electrical connection between the wire and terminal.

## 3. INSERTION PROCEDURES (Figure 1)

Insert the terminal as follows:

1. Place clip of insertion tool over terminal tab, making sure tab is FULLY seated in slot in clip.

NOTE

The setscrew must be secured tightly when inserting the terminal tab. If not, the terminal tab will slide out from beneath clip.

2. Bottom magnet wire into plastic cavity slots.
3. Align terminal insulation displacement slots over wire and push terminal into cavity until tool contacts top of cavity.
4. Remove insertion tool from terminal.

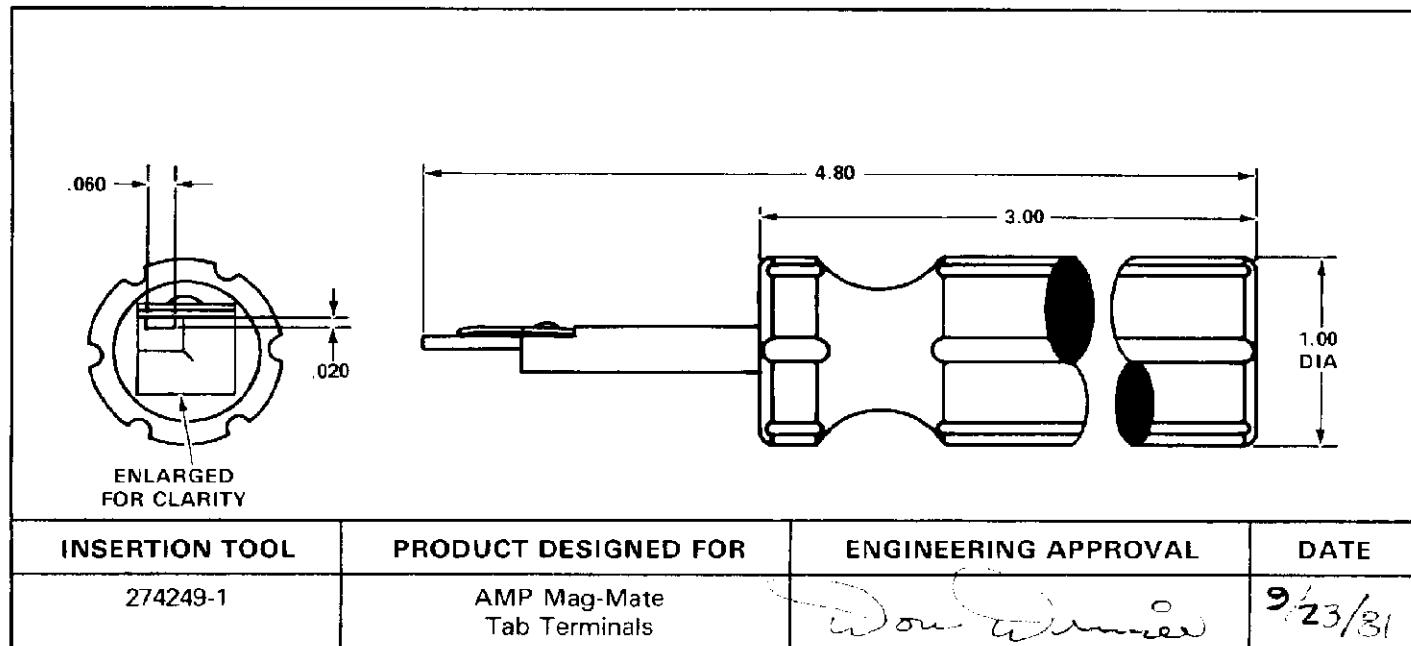


Fig. 2

**4. TOOL CERTIFICATION**

The tool listed in this instruction sheet should be certified with the information provided in Figure 2.

We recommend that you inspect the tool immediately upon arrival in your factory, and at regularly sched-

uled intervals, to ensure that the tool has not been damaged.

Additional tools can be purchased from:

AMP Incorporated  
 Eisenhower Boulevard  
 Harrisburg, PA 17105