

CERTI-LOK TERMINAL (Base Part Number)	MATERIAL (Connector In)	INSERTION TOOL
41278, 41640, 42600, 66113	Resilient	380310-1
41496, 41646	Rigid	380310-2
41222, 41223, 41647, 41648, 41649, 41650, 41651, 41652, 41653, 41656, 41657, 41658, 41991, 41992	Rigid	380310-3
42107	Rigid	1-380310-0 380310-8

Note: Resilient material is, for example, soft rubber or polyurethane.

Figure 1

1. INTRODUCTION

AMP® CERTI-LOK Taper Pin Insertion Tools (with pull-test feature) 380310-[] are designed to insert CERTI-LOK terminals listed in Figure 1 into receptacle connectors. Read these instructions thoroughly before attempting to insert any terminals.

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

The insertion tool consists of a pull-test sleeve and tip mounted onto a body. When correctly inserted into the connector terminal cavity, the tip holds the terminal in place during insertion. The sleeve is used to ensure that the terminal is set in the connector.

3. INSERTION PROCEDURE

1. Position the wire barrel of the terminal into the slot in the tip of the tool. Make sure that the shoulder of the terminal butts against the end of the tip. See Figure 2.
2. Hold the terminal in the tool tip and allow the wire to slant out through the side of the tip.
3. Align the tool tip with the desired connector terminal cavity and insert the terminal straight into the cavity. Make sure to keep the tool, terminal, and connector in a straight line. See Figure 3.

NOTE When aligning the tool, make sure that there is clearance for removing the tool after insertion.

4. With a straight, steady motion, push the tool toward the connector until the tool tips.

CAUTION Use only ONE stroke for each insertion. Extra strokes may damage the connector.

5. Slowly pull the pull-test sleeve just until it moves the tool. If the terminal remains in place, the connection is good; if the terminal pulls out, repeat the insertion procedure. If terminal pulls out again, make sure that the connector is not damaged.

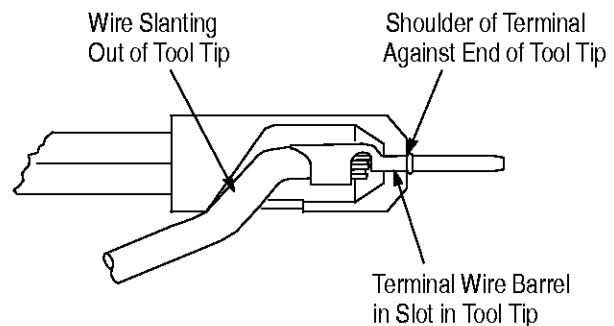


Figure 2

6. Remove tool from terminal. Do not bend or twist the terminal. If the terminal is bent or twisted during tool removal, remove the terminal from the connector and re-insert it.

4. TOOL MAINTENANCE

It is recommended that the insertion tool be inspected when you receive it and at regularly scheduled intervals. Store the tool in a clean, dry place and clean the tool with a soft, lint-free cloth.

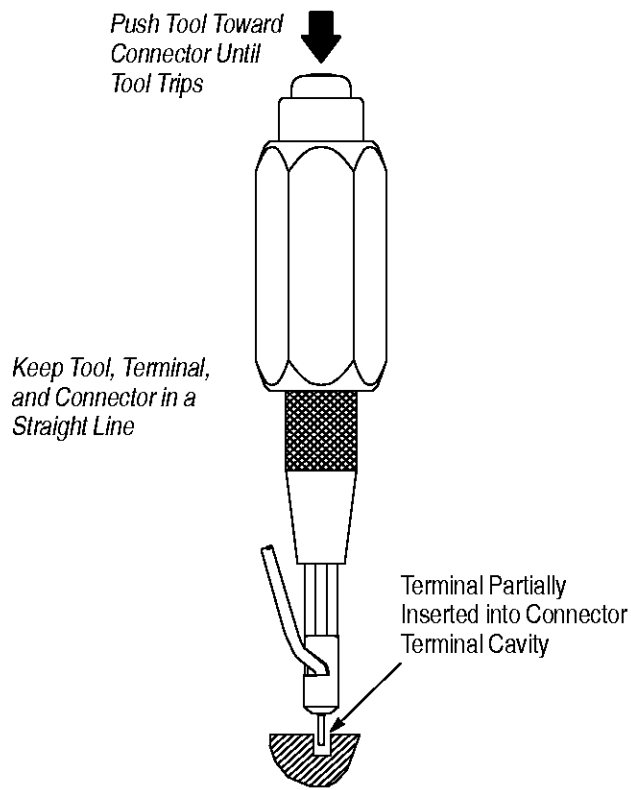


Figure 3

Additional tools can be purchased from:

CUSTOMER SERVICE (38-25)
AMP INCORPORATED
PO BOX 3608
HARRISBURG PA 17105-3608

NOTE

For information concerning adjustment and repair of the insertion tool, refer to Instruction Sheet 408-7163.

5. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0723-97 include:

- Added Tool 1-380310-0
- Removed obsolete terminal part numbers
- Removed obsolete Insertion Tools 380310-4, -7-, and -9