

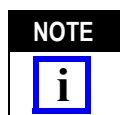
Figure 1

1. INTRODUCTION

Insertion Tool 852115-1 is designed to install shrouds onto Blindmate 2.8mm plug contacts pre-installed into power port cavities of AMPLIMITE® Subminiature D Connectors. The shrouds are used to retain plug contacts within the power port cavities of connector housings.

For product specifications and part number information, refer to the Tooling Assistance Center or Product Information. For cable preparation, assembly, and crimping procedures, refer to instruction sheets 408-9585 and 408-6788.

Read this instruction sheet carefully before using the tool.



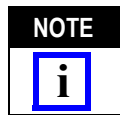
Dimensions on this sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this document are provided in Section 6, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The insertion tool consists of a tool tip with a handle. The tool tip is inserted into the power port cavity (through the front of the connector housing) which snaps the shroud into place.

3. INSTALLATION PROCEDURE



For information concerning the installation of the plug contact into the connector housing, refer to instruction sheet 408-9585.

1. Insert the shroud (smaller diameter end first) into the power port cavity through the front of the connector housing. See Figure 2.

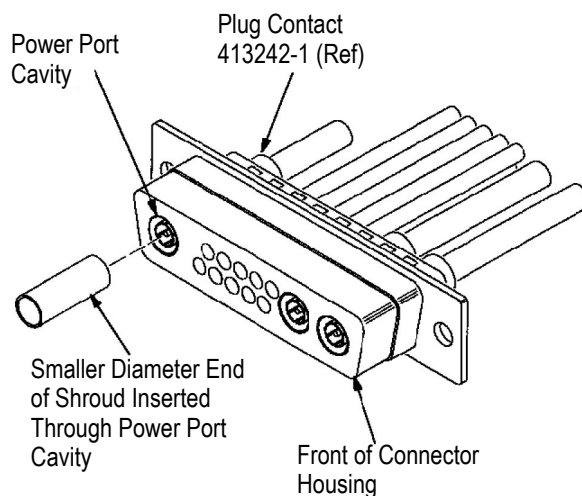


Figure 2

2. Position the tool tip against the shroud; then push the tool toward the plug contact to snap the shroud into place. See Figure 3. The plug contact must stay seated against the rear face of the connector insert while pushing the shroud into place. See Figure 4.

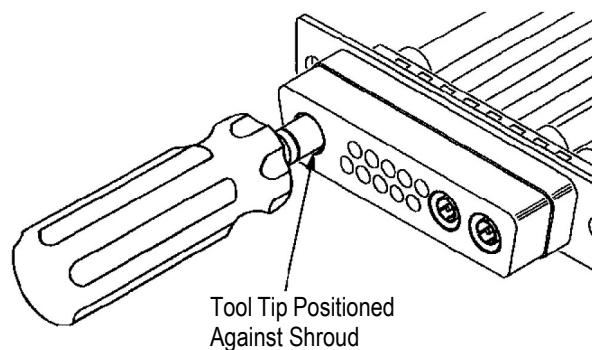


Figure 3

3. Pull back on the wire to ensure that the shroud is fully seated on the contact. The shroud is properly installed if it is seated against the shell of the contact. See Figure 4.

4. MAINTENANCE AND INSPECTION

Insertion Tool 852115-1 is inspected before shipment. It is recommended that the tool be inspected immediately upon arrival at your facility to ensure that the tool has not been damaged during shipment, and that the tool conforms to the dimensions provided in Figure 5.

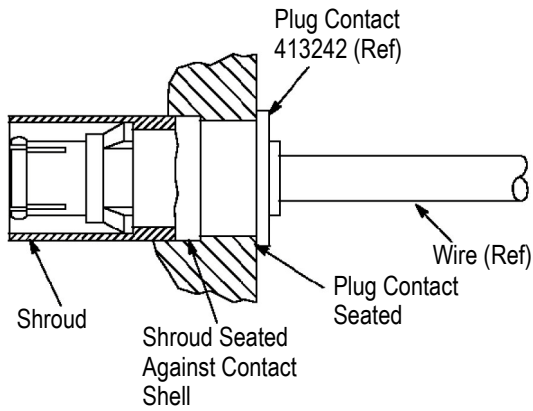


Figure 4

To ensure that the tool remains in functional condition, it should be stored in a clean, dry area and kept clean with a soft, lint-free cloth.

5. REPLACEMENT

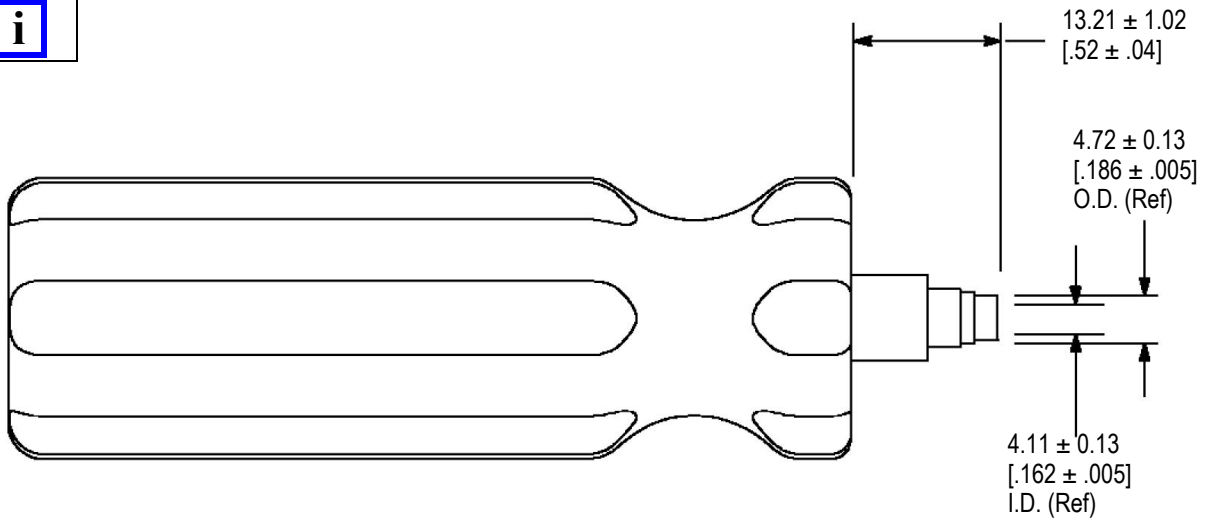
The tool is not repairable, and should be replaced when worn or damaged. Replacement tools may be purchased from:

CUSTOMER SERVICE (038-035)
 TYCO ELECTRONICS CORPORATION
 PO BOX 3608
 HARRISBURG PA 17105-3608

6. REVISION SUMMARY

Since the previous release, the TE logo has been applied.

NOTE *Not to Scale*



Weight: 42.45 g [1.5 oz]

Figure 5