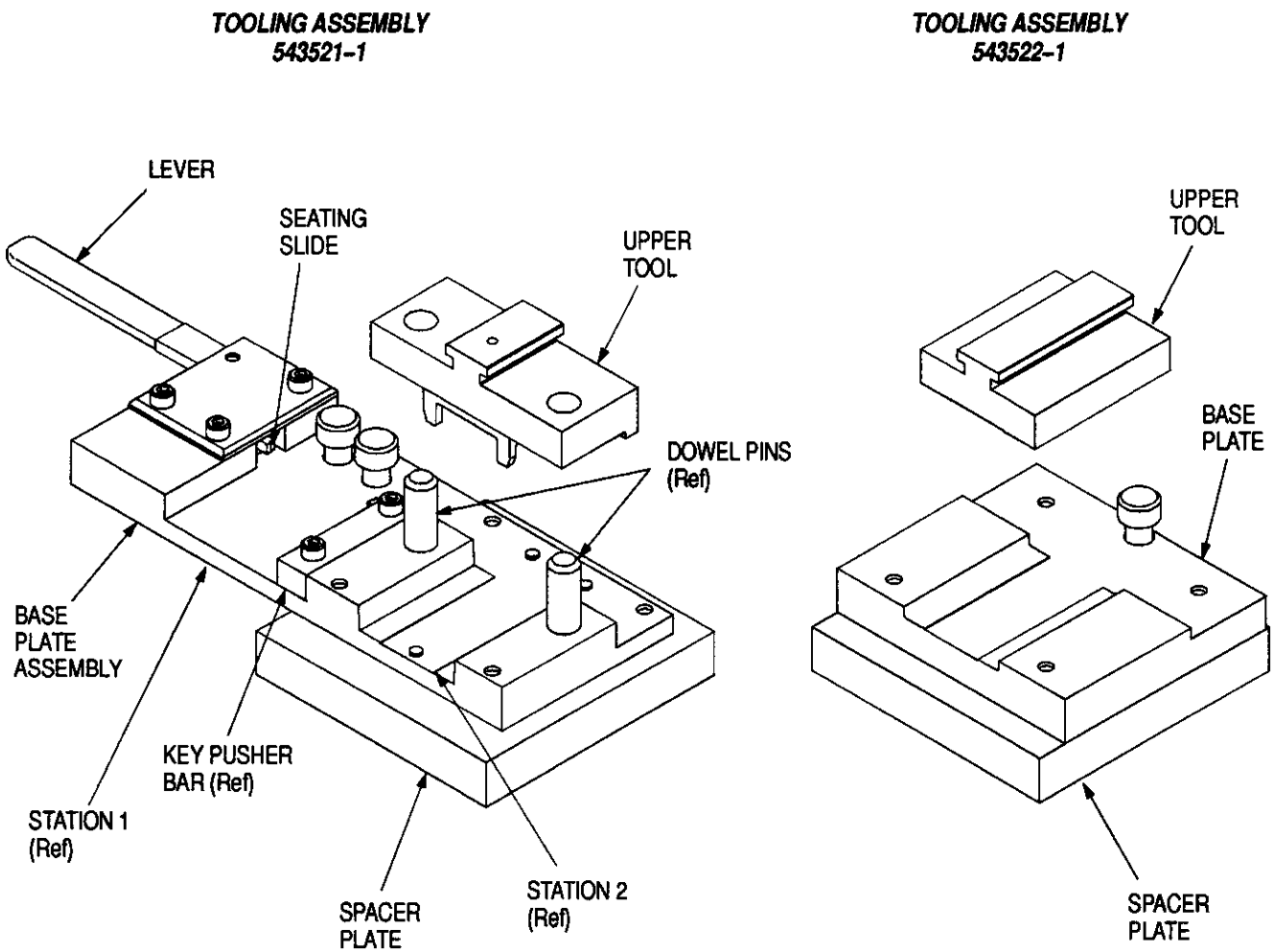

Figure 1

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1. INTRODUCTION

This instruction sheet covers the setup and application of AMP Tooling Assemblies 543521-1 and 543522-1. The tooling assemblies are used with the AMP Manual Miniature Applicator Frame Assembly 91295-1 and are used to assemble the AMP AMPLIMITE* .050 Series Slimline Connectors. For details concerning the setup and operation of the applicator frame assembly, refer to instruction sheet 408-9817.

Read these instructions carefully before using the tooling assemblies.

NOTE *Dimensions on this instruction sheet are in millimeters [followed by inches in brackets].*

2. DESCRIPTION

AMP Tooling Assembly 543521-1 consists of a spacer plate, a base plate assembly, a seating slide, a lever, and an upper tool, as shown in Figure 1. The tooling assembly is designed with two tooling stations: Station 1 seats the keys into the respective slots of the backshell assembly, and Station 2 inserts the backshell assembly into the lower plastic cover.

AMP Tooling Assembly 543522-1 consists of a spacer plate, a base plate, and an upper tool, as shown in Figure 1. The tooling assembly is designed to seat the upper plastic cover onto the lower plastic cover.

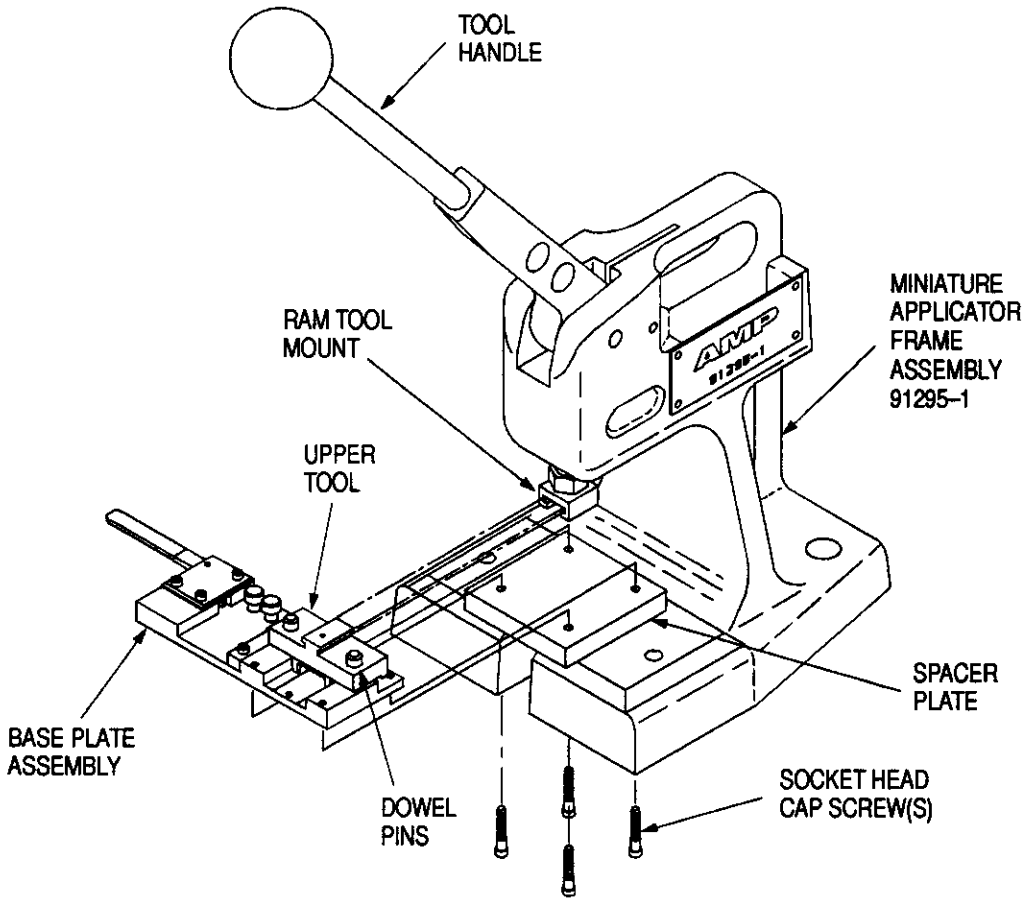

Figure 2 cad

3. SETUP PROCEDURES (Figures 3 and 4)

NOTE

AMP recommends that two Manual Miniature Applicator Frame Assemblies 91295-1 be used to assemble the AMPLIMITE .050 Series Slimline Connectors. Each tooling assembly must be installed separately in each frame assembly, as described in this section. The shut height adjustment for each frame assembly (refer to Section 4, ASSEMBLY PROCEDURE) should be made after the tooling is installed in the frame assembly.

A. Tooling Assembly 543521-1 (Figure 2)

1. Slide upper tool onto the dowel pins of the base plate assembly.

2. Position the spacer plate onto the base of the frame assembly.

3. Place base plate assembly (assembled with upper tool) onto spacer plate, allowing the upper tool to slide into the ram tool mount simultaneously. Align the holes in the spacer plate with the holes in the base plate assembly. Secure the base plate assembly and spacer plate to the frame assembly using the four socket head cap screws (included with the tooling assembly).

4. Tighten the setscrew in the ram tool mount to secure the upper tool.

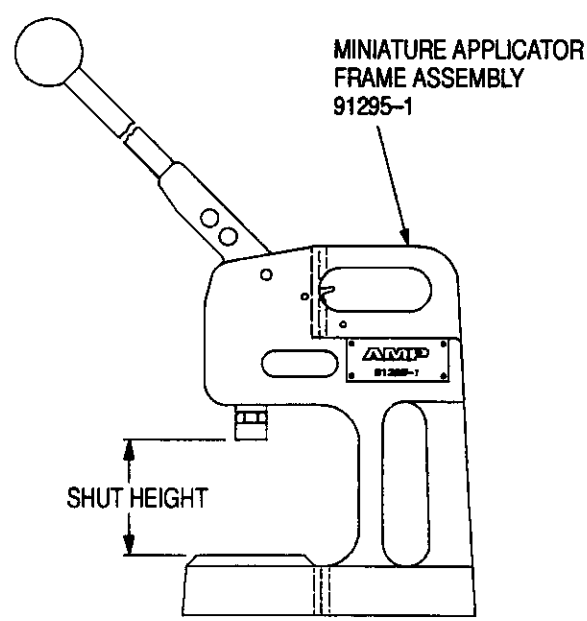

Figure 3 cad

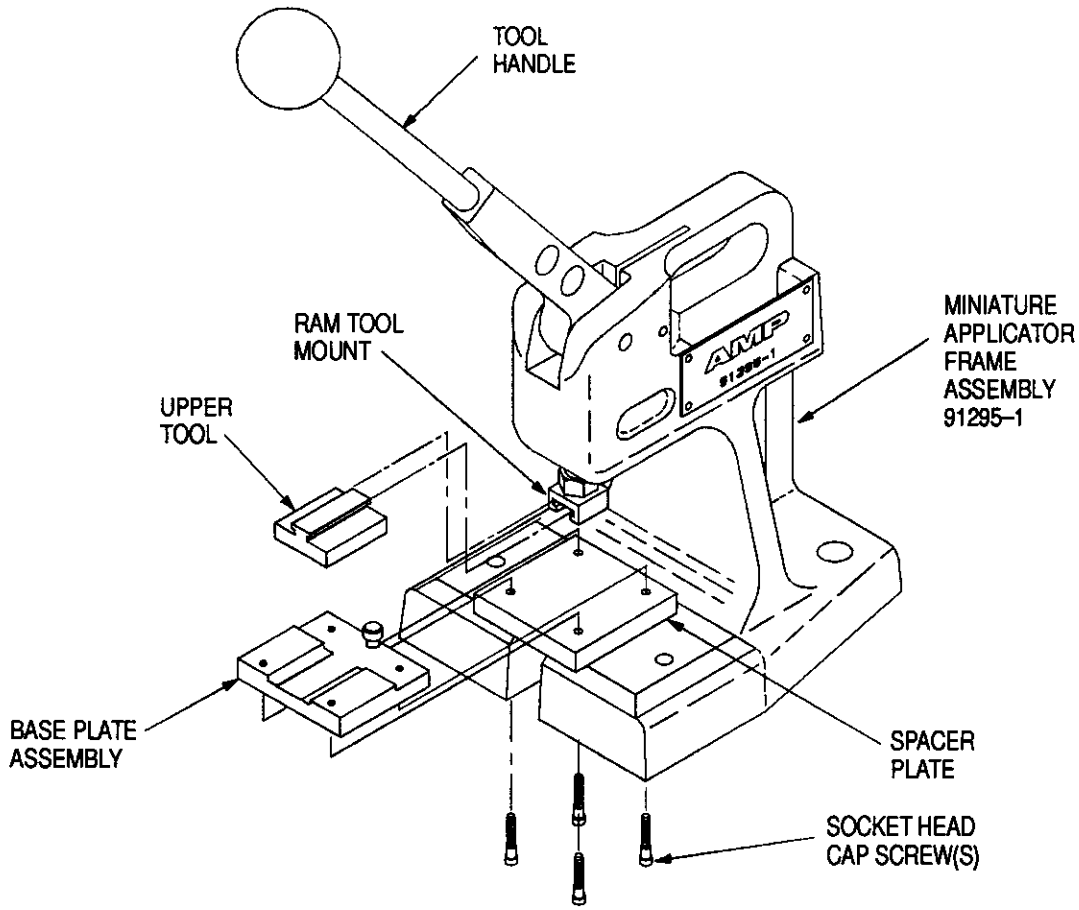

Figure 4

cad

5. Pull down on the tool handle and check the alignment of the upper tool with the dowel pins. The upper tool should slide over the dowel pins. If any binding occurs, loosen the socket head cap screws, re-align the base plate assembly with the upper tool, and retighten the four screws.

B. Tooling Assembly 543522-1 (Figure 4)

1. Position spacer plate onto the base of the frame assembly.

2. Place base plate assembly onto spacer plate, aligning the holes in the spacer plate with the holes in the base plate. Secure spacer plate and base plate to frame assembly using the four socket head cap screws (included with the tooling assembly).

3. Slide upper tool onto the ram tool mount and tighten the setscrew to secure the upper tool.

4. To check the alignment of the upper and lower tool, position the backshell assembly with upper plastic cover into the tooling assembly, as shown in Figure 7.

5. Pull down on the tool handle, making sure that the recessed areas of the upper tool meet the raised areas of the upper plastic cover. Refer to Figure 7.

NOTE *If the upper tool does not meet the raised areas of the upper plastic cover, the base plate assembly must be re-aligned with the upper tool. Loosen the four socket head cap screws securing the spacer plate and base plate assembly; then re-align the base plate assembly with the upper tool. After the tooling is properly aligned, retighten the four screws.*

4. ASSEMBLY PROCEDURE

A. Tooling Assembly 543521-1

CAUTION *Secure applicator frame assembly to a workbench to ensure stability during operation.*

NOTE *Set the shut height — distance from the bottom surface of the ram FULLY BOTTOMED to the top of the machine base — to 38.1 [1.50]. Refer to Figure 3. For details on ram height adjustments, refer to 408-9817.*

1. Place backshell into Station 1 of the base plate assembly. Slide the backshell back until the mating face of the backshell is positioned against and under the head of the shoulder screws. See Figure 5.

2. Holding the backshell in place, pull the lever so that the seating slide seats the keys into the slots of the backshell. Refer to Figure 5.

3. Position the lower plastic cover into Station 2 of the base plate assembly. The cover must be positioned between the dowel pins, as shown in Figure 6.

4. Position backshell onto the lower plastic cover. See Figure 6.

5. Pull down on the tool handle (until the CERTI-CRIMP* ratchet releases) to seat the backshell into the plastic cover. Remove the backshell assembly from the tooling.

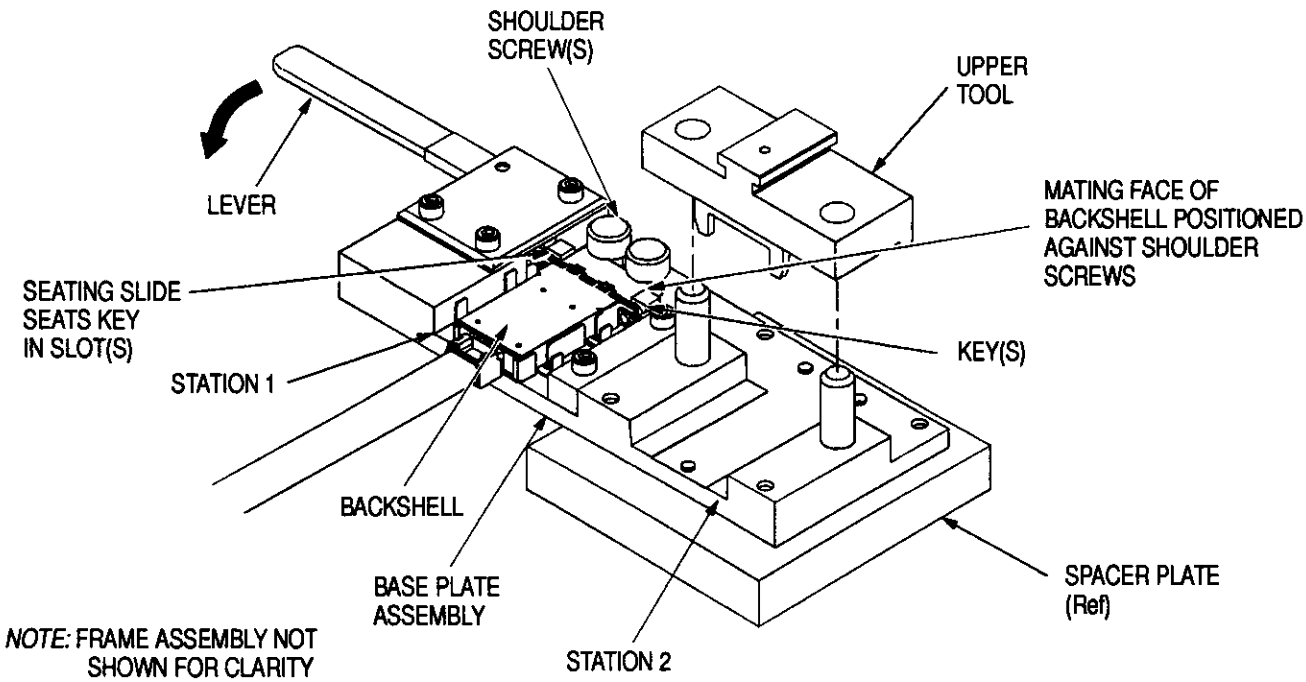

Figure 5

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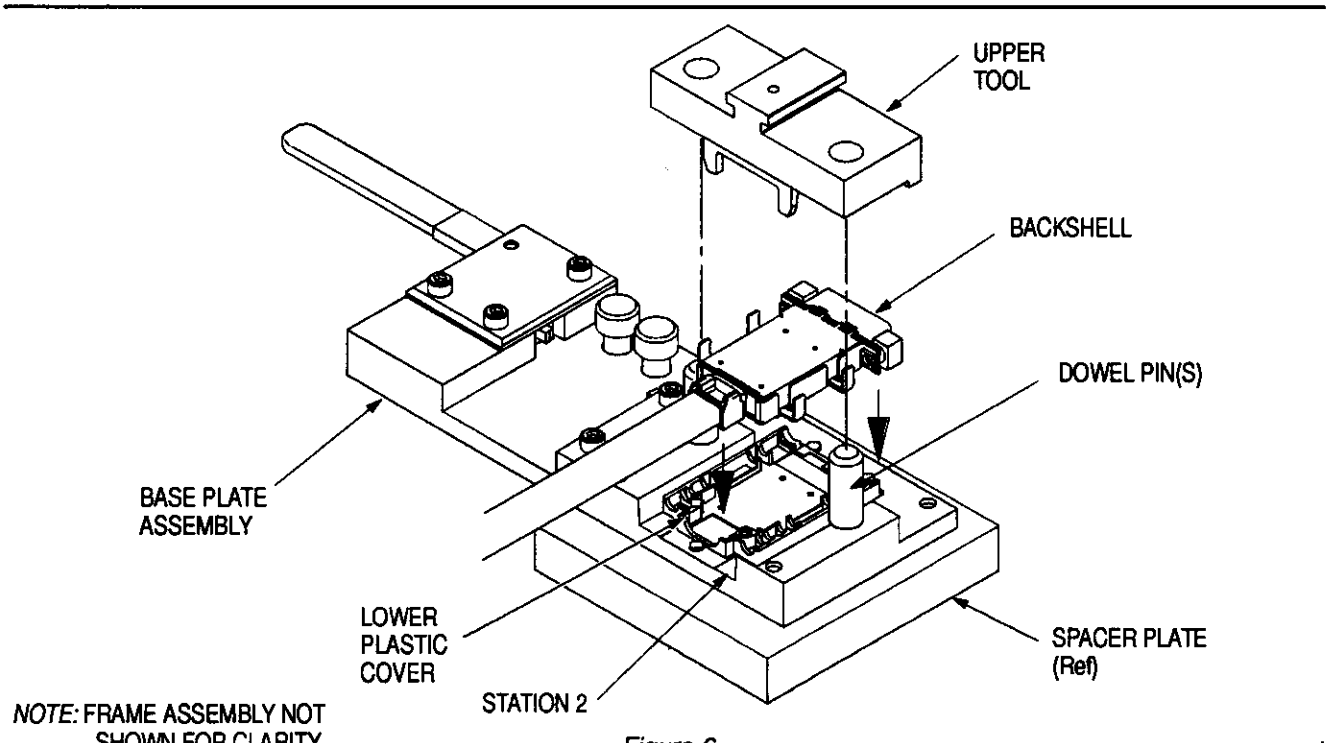

Figure 6

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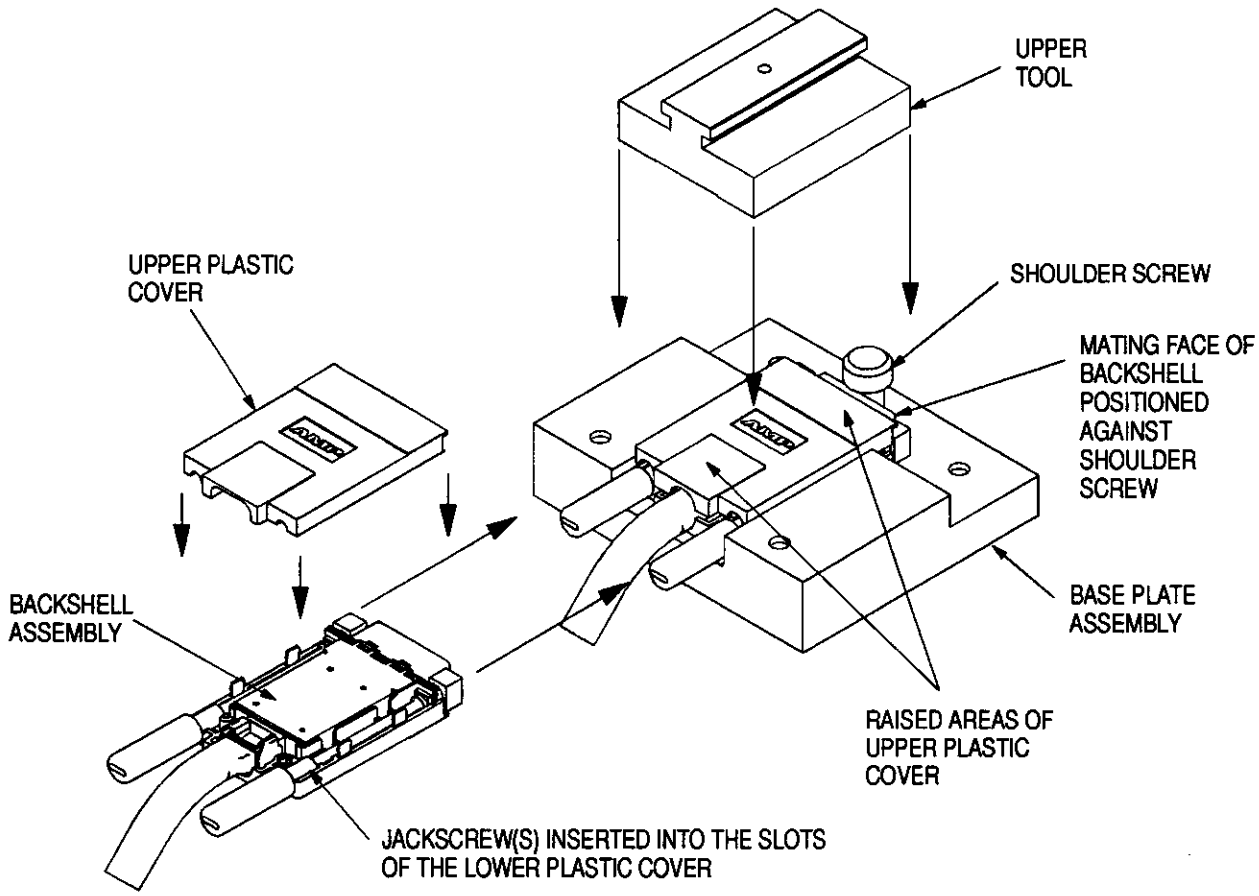


Figure 7 cad

B. Tooling Assembly 543522-1

CAUTION *Secure applicator frame assembly to a workbench to ensure stability during operation.*

NOTE *Set the shut height — distance from the bottom surface of the ram FULLY BOTTOMED to the top of the machine base — to 40.6 [1.60]. Refer to Figure 3. For details on ram height adjustments, refer to 408-9817.*

1. Insert the jackscrews into the slots of the lower plastic cover; then position the upper plastic cover onto the backshell assembly. See Figure 7.

2. Position backshell assembly with upper plastic cover into the base plate assembly, as shown in Figure 7. The mating face of the backshell assembly must be positioned against, and under the head of, the shoulder screw. See Figure 7.

3. Pull down on the tool handle (until the CERTI-CRIMP ratchet releases) to seat the upper plastic cover onto the backshell assembly. See Figure 8 for a properly assembled AMPLIMITE .050 Series Slimline Connector.

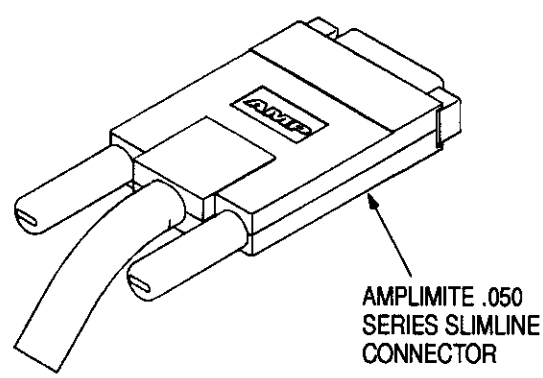


Figure 8 cad

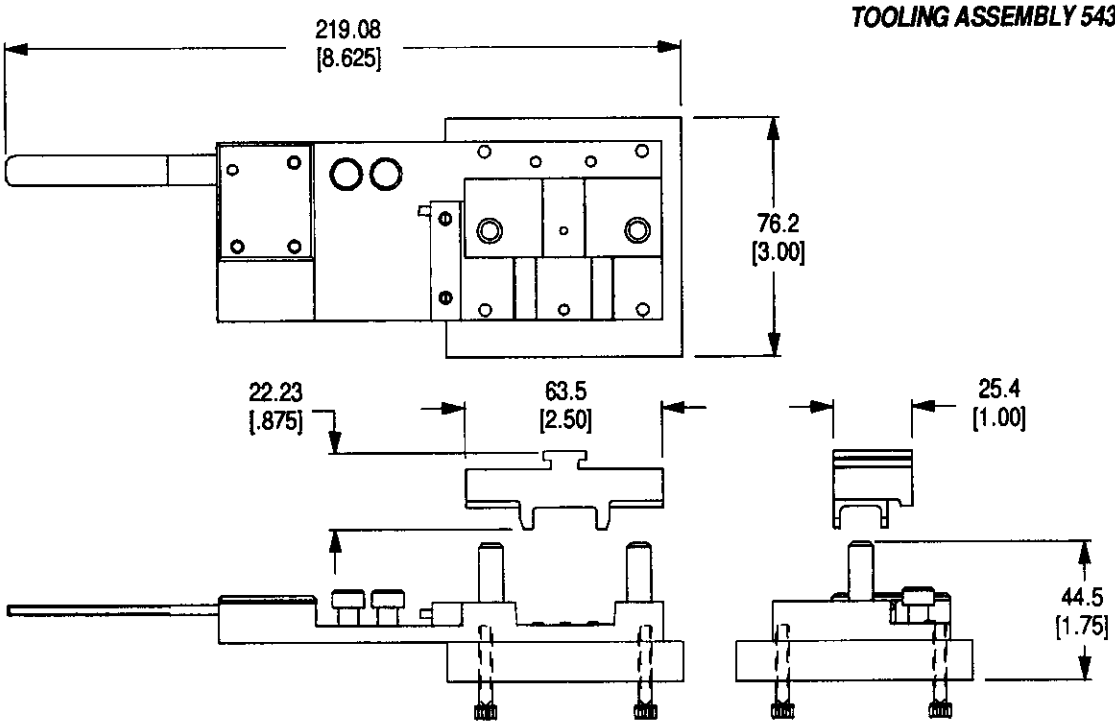
5. TOOL ASSEMBLY REPLACEMENT

AMP Tooling Assemblies 543521-1 and 543522-1 are inspected prior to shipment. AMP recommends that each tool be inspected immediately upon its arrival at your facility to ensure that the tooling has not been damaged during shipment and that the tooling conforms to the dimensions provided in Figure 9.

Additional tooling assemblies may be purchased by calling 1-800-526-5142 or send a facsimile of your purchase order to 1-717-986-7605 or by contacting:

CUSTOMER SERVICE (38-35)
AMP INCORPORATED
P.O. BOX 3608
HARRISBURG, PA 17105-3608

TOOLING ASSEMBLY 543521-1



TOOLING ASSEMBLY 543522-1

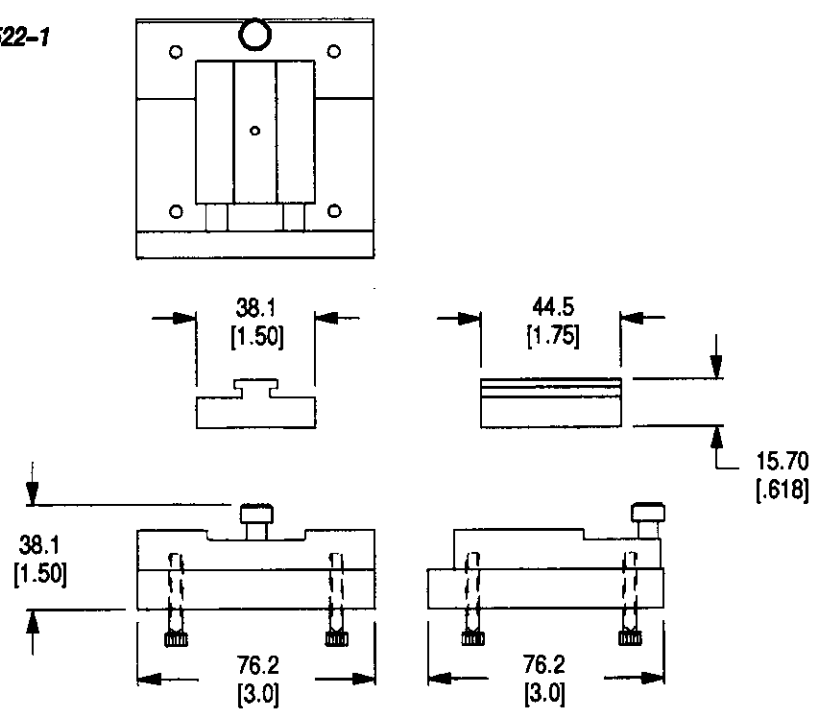


Figure 9

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