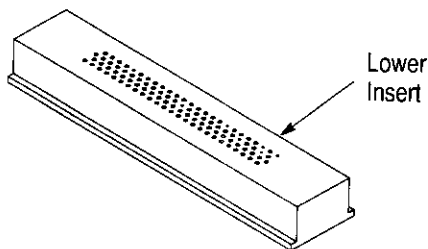


Connector-Specific Kit 679073-1



Typical Application Tooling

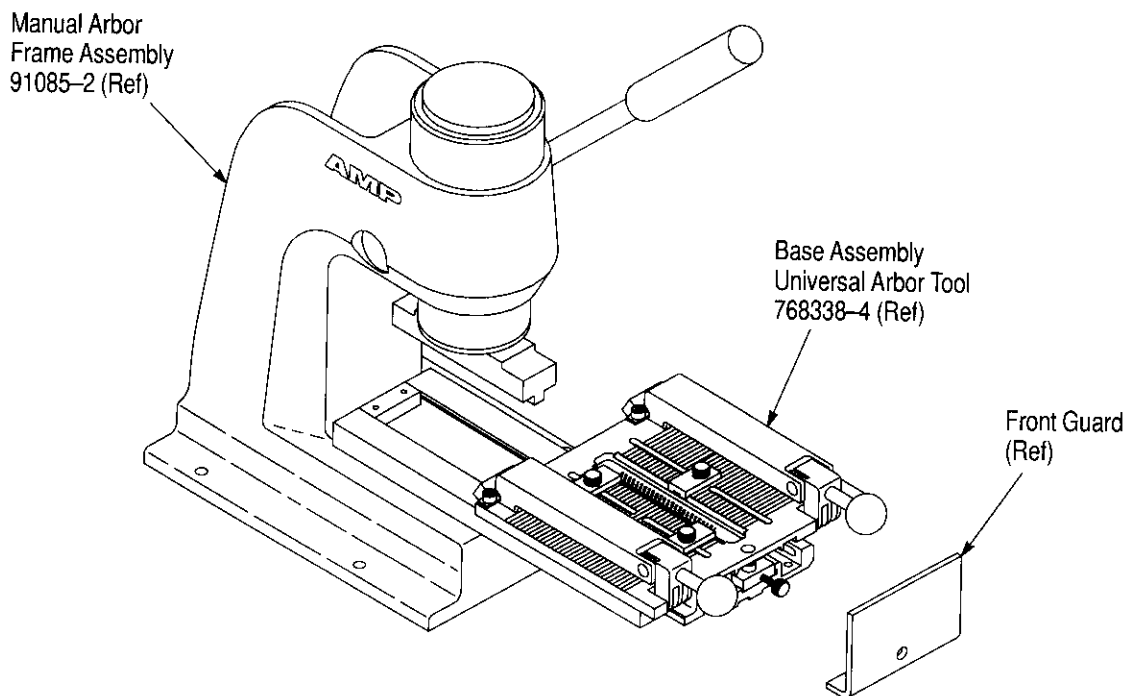


Figure 1

1. INTRODUCTION

This instruction sheet covers the installation and setup procedures for AMP* Connector-Specific Kit 679073-1. The connector-specific kit is used in conjunction with Base Assembly Universal Arbor Tool 768338-4 and AMP Manual Arbor Frame Assembly 91085-2 (see Figure 1), or AMP Pneumatic Auto-Cycle Unit 91112-3 to terminate AMP-LATCH System 50 Paddleboard Connectors to 0.64 [.025] centerline ribbon cable with solid 30 AWG or stranded 32 AWG cable conductors.

NOTE

Dimensions on this sheet are in metric units [with U.S. customary units in brackets].

Refer to instruction sheets 408-7777 (supplied with Manual Arbor Frame Assembly) and 408-6732

(supplied with Pneumatic Auto-Cycle Unit) for tooling information. Installation and termination procedures for the Base Assembly Universal Arbor Tool are available in 408-4201. For the selection of AMP-LATCH connectors, refer to AMP Catalog 82012.

NOTE

Cable assemblies manufactured by AMP Incorporated contain ribbon cable meeting the requirements of AMP Engineering Drawings 57013 (30 AWG solid conductors) and 57038 (32 AWG stranded conductors). AMP-LATCH System 50 Paddleboard Connectors are available in various sizes from 20 to 100 positions. If you wish to assemble your own cable assemblies using these connectors, use a cable of equal or superior quality.

2. DESCRIPTION (Figure 1)

The connector-specific kit consists of a lower insert. The lower insert is designed with alignment holes which properly align the connector for termination. The lower insert is identified with the AMP part number and .025 Paddleboard.

3. INSTALLATION AND SETUP OF CONNECTOR-SPECIFIC KIT

3.1. Installation

These procedures are typical for the Manual Arbor Frame Assembly and the Pneumatic Auto-Cycle Unit. Before installing the connector-specific kit, install the Base Assembly Universal Arbor Tool onto the frame assembly, as described in 408-4201.

DANGER To avoid personal injury, always **DISCONNECT** air supply from main air valve before installing tooling onto the Pneumatic Auto-Cycle Unit.

1. Remove the screw that secures the adjustment block to the universal arbor tool, then remove the adjustment block. Slide the lower insert onto the base assembly until it is against the compression spring. See Figure 2.
2. Re-assemble the adjustment block. *Make sure* to orient the block so that the fine adjustment

screw is closest to the right side and bottom side of the block. See detail in Figure 2.

CAUTION To avoid improper terminations, the adjustment block must be re-assembled properly.

3. Loosen the fine adjustment screw so that it is not touching the lower insert.

3.2. Setup

1. Open cable clamp assembly.
2. Slide cable through the connector; then insert connector (cover up) into the lower insert, making sure that the first contact is aligned with the Position 1 locating hole in the lower insert. See Figure 3.

NOTE The Position 1 locating hole in the lower insert is used to align the connector in the lower insert. **ALWAYS** locate the first contact with the Position 1 locating hole. The rest of the contacts will align with the clearance holes (these holes are larger in diameter than the locating hole). Refer to Figure 4.

3. Position the cable into the universal arbor tool and follow termination procedures according to the instructions packaged with the arbor tool.

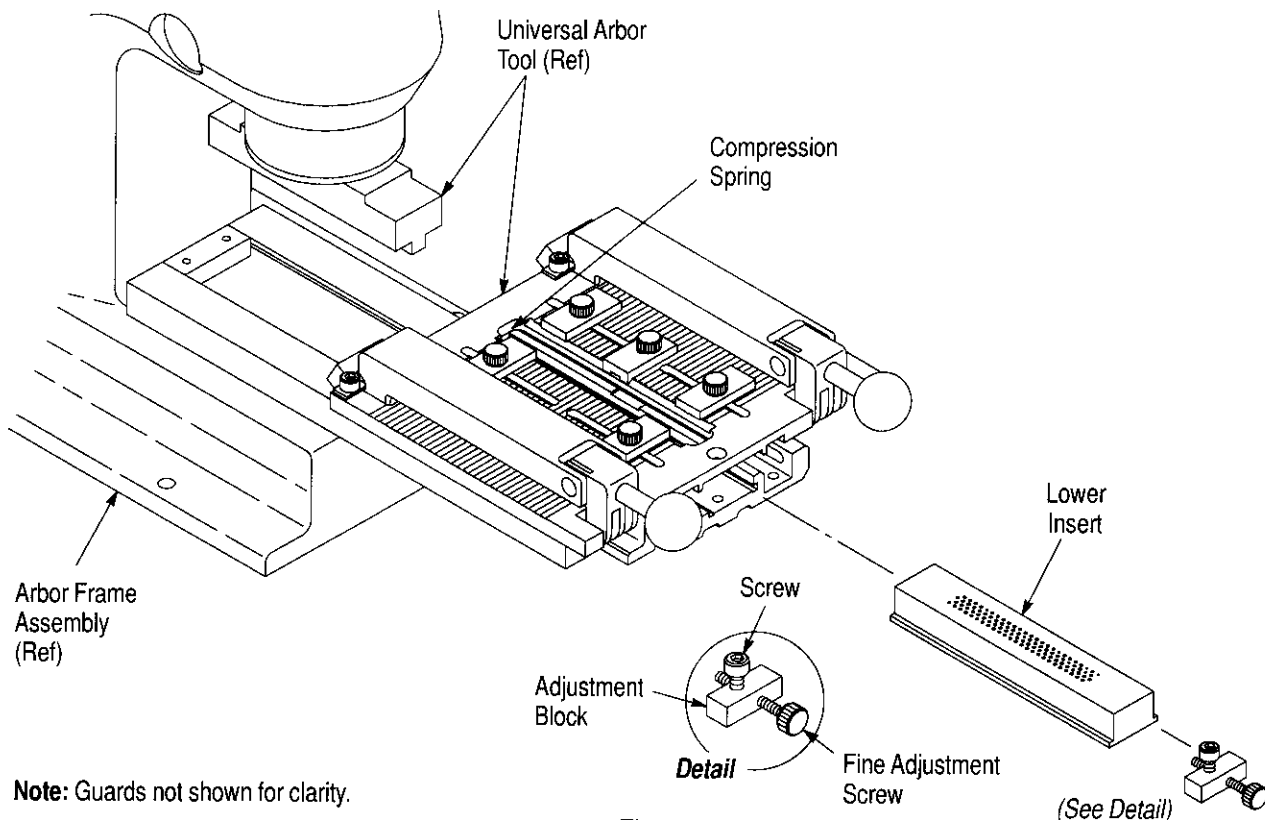


Figure 2

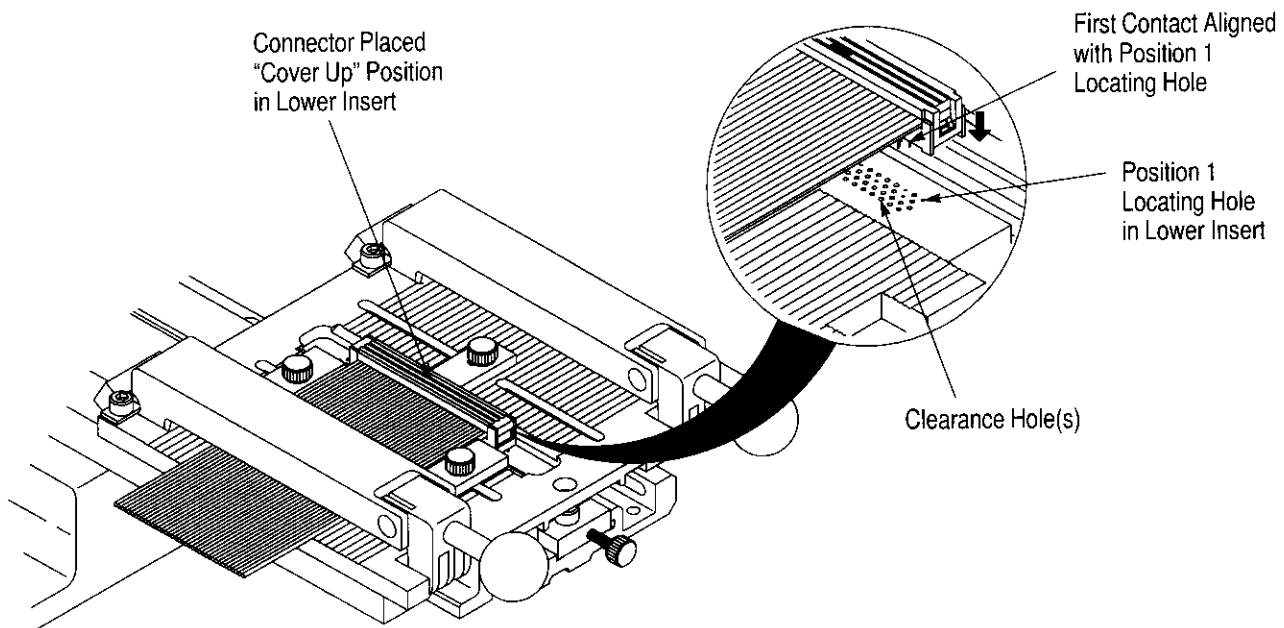


Figure 3

3.3. Connector Inspection

1. Perform a test termination and inspect the connector to ensure that the cable conductors are aligned with the contacts. If available, use a tester to inspect the termination, or remove the connector cover and inspect the termination with a microscope. Refer to the applicable AMP application specification (114-series) for termination height dimensions.
2. If the cable conductors are not aligned with the contacts, a re-alignment of the connector is necessary. Determine the direction the connector must be moved to align the cable conductors with the contacts. Loosen the two locking setscrews on the universal arbor tool (which secure the lower insert) and re-align the lower insert.

NOTE

For additional information on connector and cable alignment, refer to the instructions packaged with the universal arbor tool.

4. CONNECTOR-SPECIFIC KIT INSPECTION

The connector-specific kit has been inspected and should be verified with the information provided in Figure 4. AMP recommends that the kit be inspected immediately upon its arrival at your facility (and at regularly scheduled intervals) to ensure that the kit components have not been damaged during transit.

For additional information concerning connector-specific kits, or to purchase additional kits, contact your local AMP representative or:

CUSTOMER SERVICE (38-35)
AMP INCORPORATED
PO BOX 3608
HARRISBURG PA 17105-3608

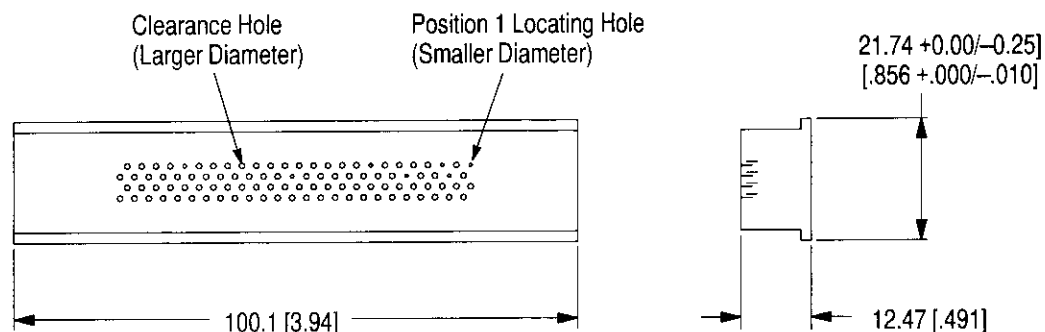


Figure 4