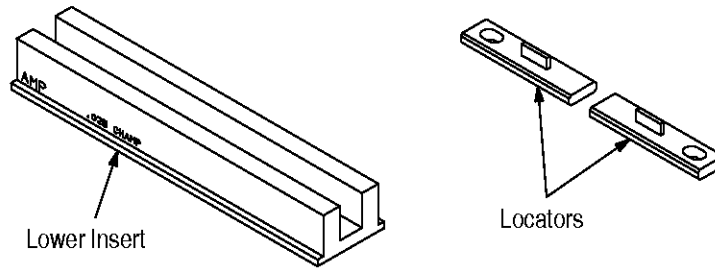


Connector-Specific Kit 679177-2



Typical Application Tooling

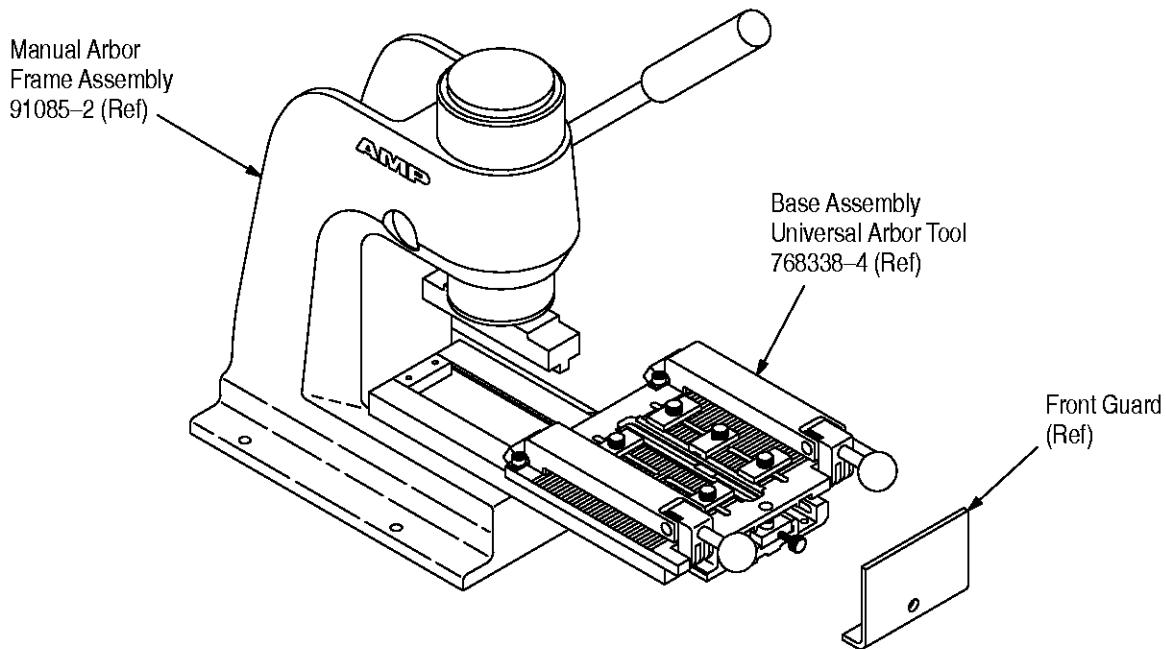


Figure 1

1. INTRODUCTION

This instruction sheet covers the installation and setup procedures for AMP* Connector-Specific Kit 679177-2. 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 CHAMP .050 Series I Receptacle Connectors to 0.64 mm [.025 in.] centerline flat ribbon cable.

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.

NOTE

Dimensions on this sheet are in millimeters [followed by inches in brackets]. Figures are not drawn to scale.

Reasons for reissue are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The connector-specific kit features a lower insert and two locators. The lower insert and locators properly align the connector for termination.

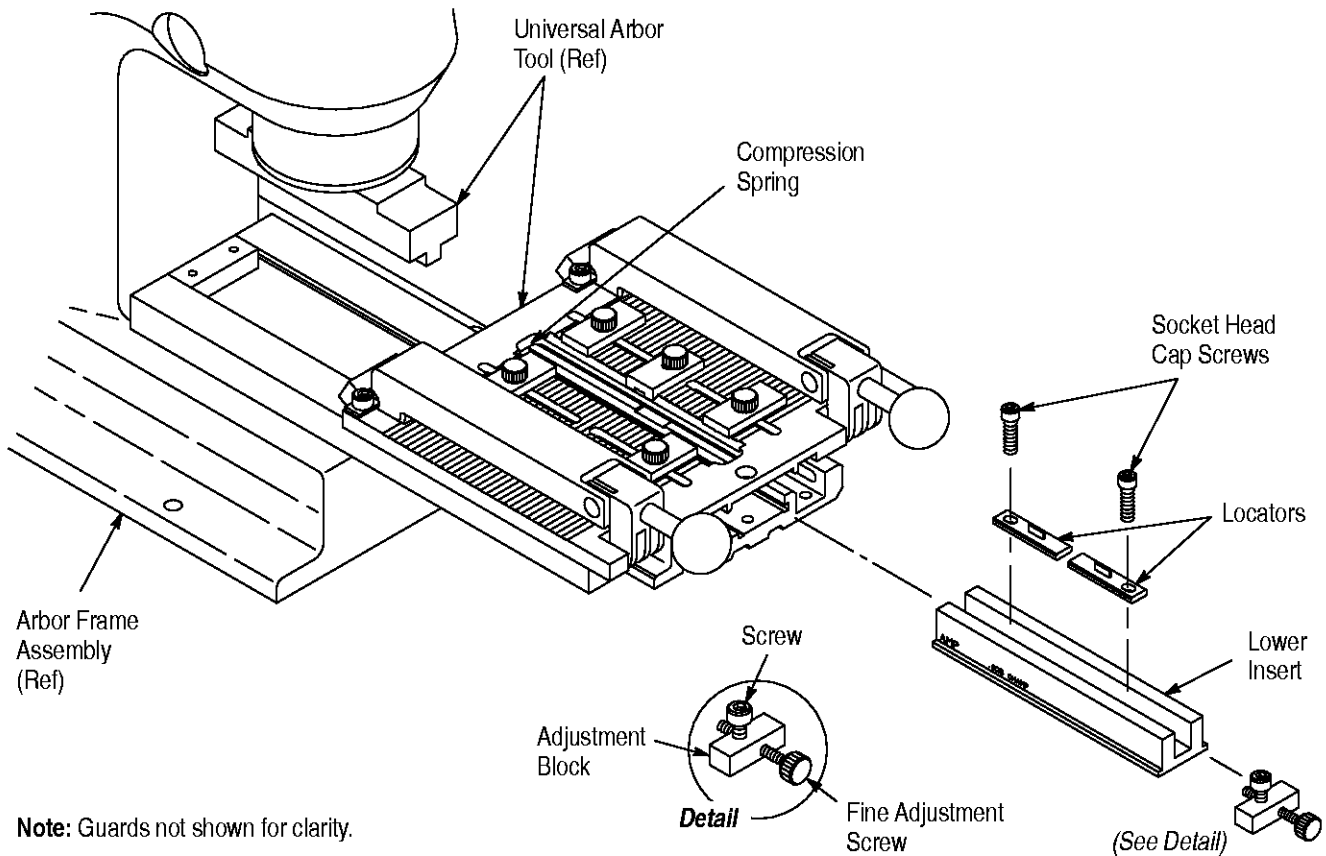


Figure 2

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. Secure the locators onto the lower insert using the socket head cap screws. Tighten the screws just enough to hold the locators in place. Refer to Figure 2.
2. Place the connector onto the locators and between the socket head cap screws. Slide the locators apart until the blades butt against the inside edges of the connector. Secure the locators by fully tightening the screws. The connector must fit securely over the blades. See Figure 3.
3. When the locators are secure, remove the connector from the lower insert.

4. 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.
5. 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.

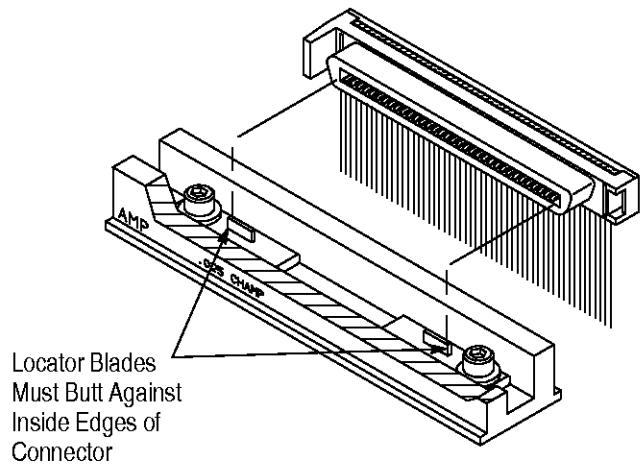


Figure 3

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

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

3.2. Setup

- Remove the cover from the connector and place the connector into the lower insert as described in Paragraph 3.1.
- Position the cable into the universal arbor tool and follow termination procedures according to the instructions packaged with the arbor tool.

3.3. Connector Inspection

- 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 to ensure that the cable conductors are properly aligned with the contacts. Refer to applicable AMP application specification (114-series) for termination height dimensions.
- 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 handling.

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

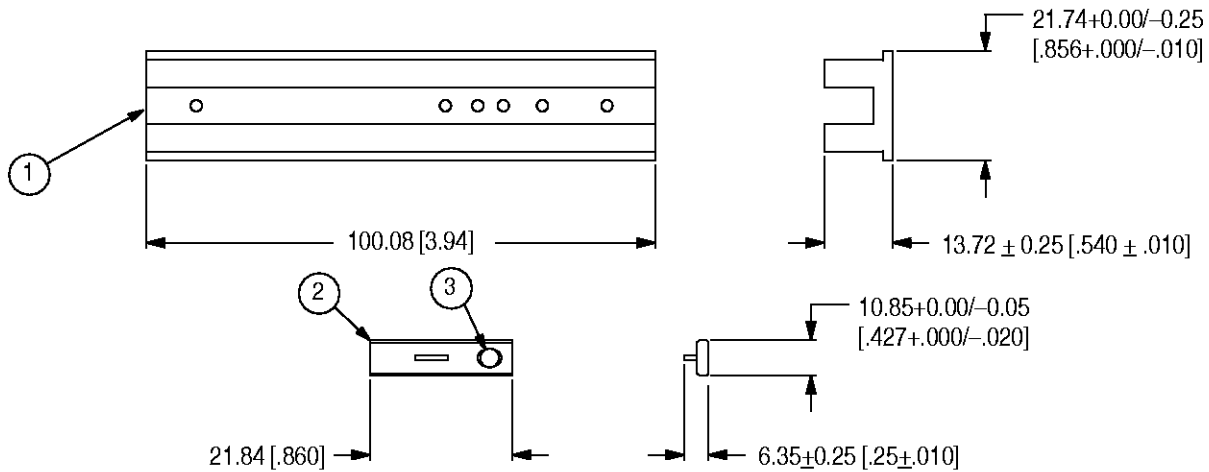
CUSTOMER SERVICE (38-35)
AMP INCORPORATED
PO BOX 3608
HARRISBURG, PA 17105-3608

5. REVISION SUMMARY

Since the previous release of this document, the following changes were made:

Per EC 0990-1053-98

- Removed reference to plug connectors from title and introduction



REPLACEABLE PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER KIT
1	679102-1	LOWER INSERT	1
2	679101-1	LOCATOR	2
3	7-21000-9	SCREW, Socket Head Cap, 4-40 x .38 in. L	2

Figure 4