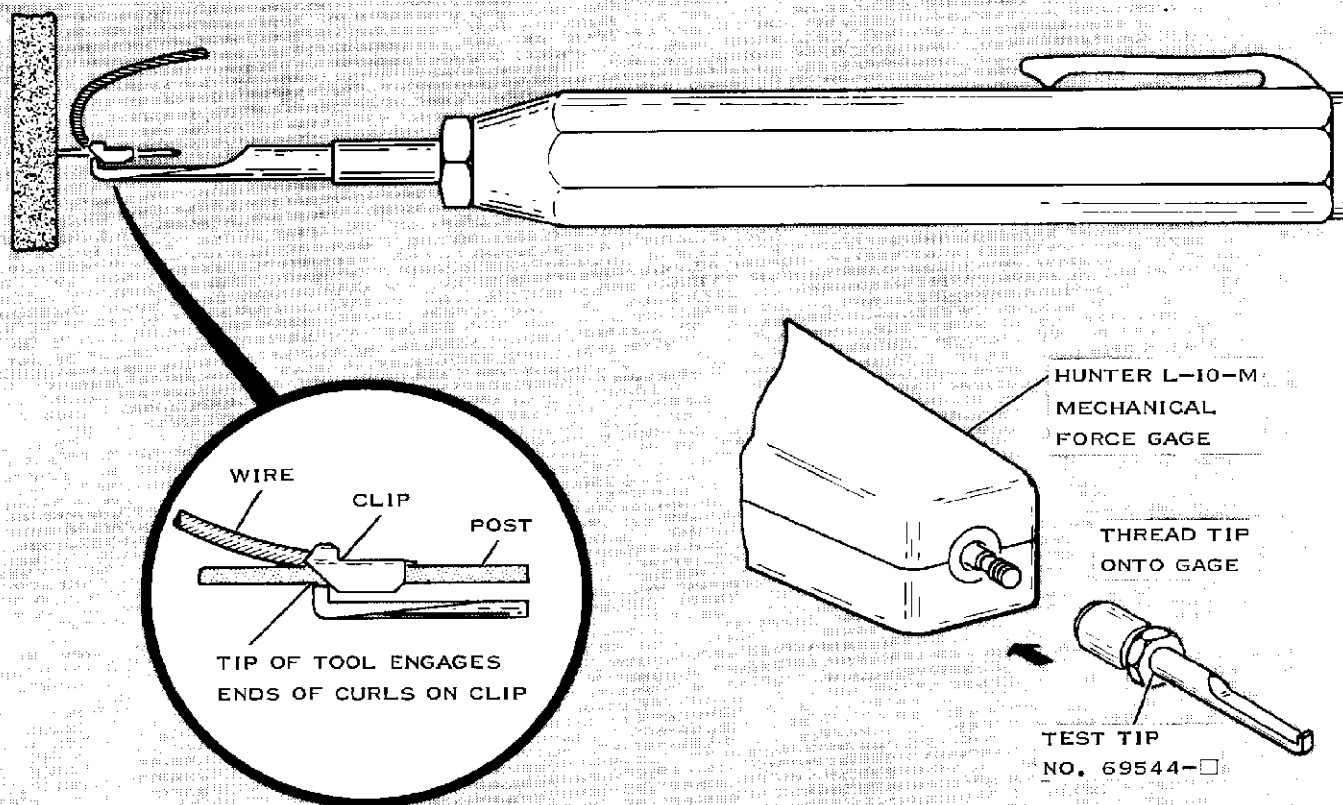




AMP* TERMI-POINT*
PULL TEST TOOL
CATALOG No. 69358-□
AND TEST TIP
CATALOG No. 69544-□

IS 1933	
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CLIP NUMBER	POST SIZE	PULL TEST TOOL			TEST TIP NUMBER†
		NUMBER	TEST FORCE IN POUNDS	INDICATOR RING COLOR	
□-330495-□	.031" X .062"	69358-2	2.25	YELLOW	69544-1
□-330854-□	.031" X .093"	69358-5	2.25	YELLOW	69544-2
□-67042-□	.022" X .036"	69358-6	0.50	GREEN	69544

† USE WITH HUNTER MECHANICAL FORCE GAGE MODEL L-10-M.

FIG. 1

1. INTRODUCTION

The Pull Test Tools, Catalog No. 69358-□ and Test Tips, Catalog No. 69544-□ (for use with Hunter Mechanical Force Gauge, Model L-10-M) are used to make non-destructive tests of the mechanical quality of a termination.

2. TESTING PROCEDURE

2.1 PULL TEST TOOL No. 69358-□

- Hook Tool squarely against end of Clip, with Tip engaging Ends of Curls on Clip. See Figure 1.
- Maintain alignment of Tool with Post, and pull slowly until the Indicator Ring is in line with front of Tool. See Figure 1.

(c) Clip may slide, no more than 1/2 the Clip Length, before the Indicator Ring is visible. See Figure 2-A.

(d) Lateral Clip movement during test, see Figure 2-B, does not affect the quality of termination.

NOTE: Clips that move more than 1/2 the Clip Length should be rejected and a new Clip applied and test repeated.

2.2 TEST TIP No. 69544-□

- Thread Tip onto Hunter Mechanical Force Gauge, Model L-10-M.
- Hook Tip squarely against end of Clip, with Tip engaging End of Curls on Clip. See Figure 1.

- (c) Maintain alignment of Gage with Post, and pull slowly until the Gage reaches its maximum reading.
NOTE: Gage must be set in "LOCK" Position to record maximum reading.
- (d) Clip may slide no more than 1/2 the Clip Length, before reading is obtained. See Figure 2-A.
- (e) Lateral Clip movement during test, see Figure 2-B, does not affect the quality of termination.
NOTE: Clips that move more than 1/2 the Clip Length should be rejected and a new Clip applied and test repeated.

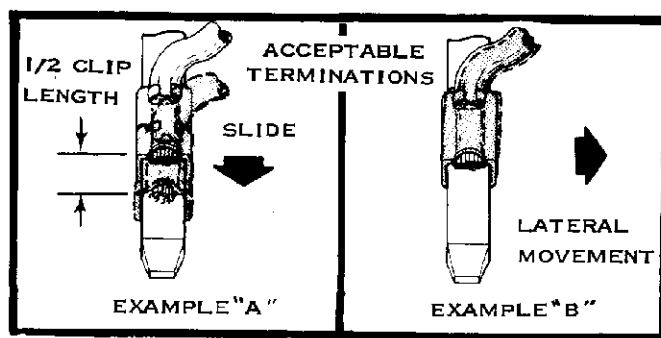
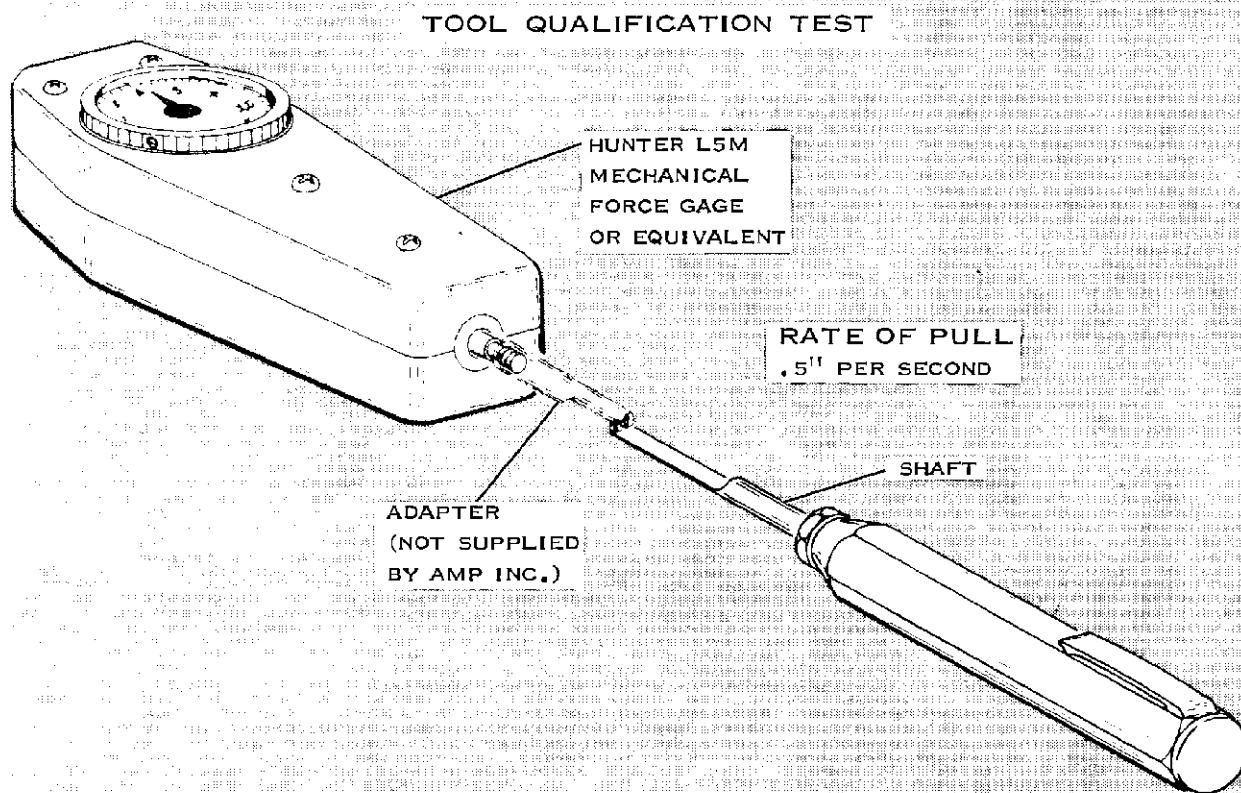


FIG. 2



TOOL NUMBER	INDICATOR RING COLOR	CALIBRATION FORCE IN POUNDS
69358-2	YELLOW	2.25 ± .10
69358-5	YELLOW	2.25 ± .10
69358-6	GREEN	0.50 ± .10

FIG. 3

3. TOOL QUALIFICATION TEST

A periodic Tool Qualification Test should be made to make certain that Tool No. 69358-□ is maintaining the proper calibration. Use the following procedure to check Tool Calibration:

- (a) Connect TERMI-POINT Test Tool to an accurate Mechanical Force Gage. A typical set-up using a Hunter L5M Force Gage and Adapter is shown in Figure 3.
NOTE: Gage must be set in "LOCK" Position to record maximum reading.

- (b) Force Gage and Test Tool must be held in a horizontal plane and be aligned when making the test. Care must be taken to prevent binding between shaft and end of Test Tool. See Figure 3.
- (c) Pull Tool, using a pull rate of .5 inches per second.
- (d) Gradually decrease pull rate until Indicator Ring is in line with front of Tool. Check Gage Reading.
- (e) If Gage Reading is not satisfactory, Test Tool should be returned to AMP Incorporated.