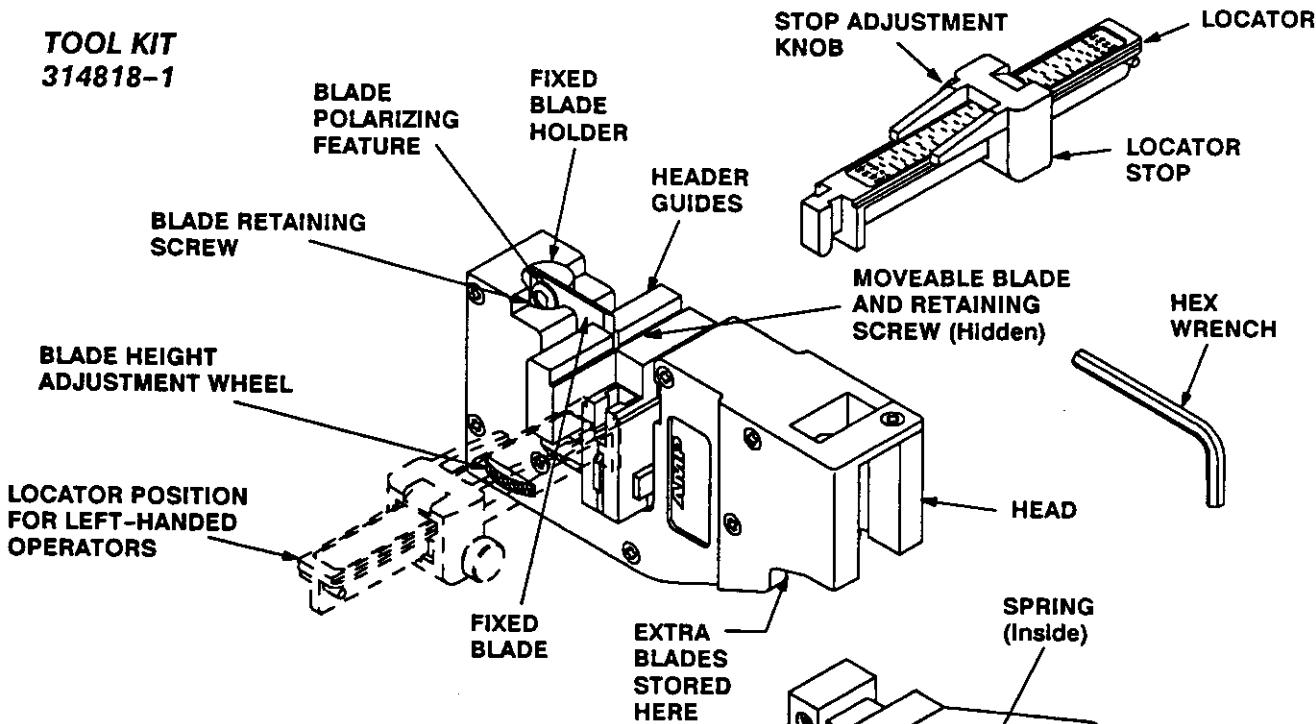


CUSTOMER HOTLINE  
1 800 722-1111**TOOL KIT  
314818-1****AMPMODU MOD II BREAKAWAY HEADERS**

SINGLE ROW VERTICAL HEADERS		SINGLE ROW RIGHT-ANGLE HEADERS		DOUBLE ROW VERTICAL HEADERS		DOUBLE ROW RIGHT-ANGLE HEADERS	
U.S.	HOLLAND	U.S.	U.S.	HOLLAND	U.S.	U.S.	U.S.
103747	215201	103765	103783	215447	103801		
103741	215267	103759	103777	216072	103795		
103239	215403	103148	103240	216900	103149		
103185	215662	103325	103186	216901	103326		
103327	216898	103329	103328	216950	103330		
102976	216899	102978	102977	—	102979		
102972	216921	102974	102973	—	102975		
103321	—	103323	103322	—	103324		

Fig. 1

cad

**1. INTRODUCTION**

The AMP Tool Kit 314818-1 is designed to cut AMPMODU Mod II Breakaway Headers with base part numbers shown in Figure 1. These headers have .64mm [.025 in.] square posts on 2.54mm [.100 in.] centers. The variety of post platings available accounts for the many numbers under each heading.

This tool kit is also sold by AMP Holland as part no. 734180-1 for use with the corresponding header part numbers listed. All of the products listed in Figure 1 are cut by the tool in a similar manner; for the sake of simplicity these instructions show double row right-angle headers throughout.

**NOTE**

Read this entire instruction sheet before using the tool.

## 2. DESCRIPTION

The tool kit comes in carrying case 314814-1 (not shown); in the case are:

- pistol grip ratchet handle 314813-1 to actuate the tool,
- locator 314817-1 for positioning headers in the tool,
- cutting head 314815-1 (includes blades installed, and a stored set of 2 extra blades), and
- a hex wrench for changing blades.

Additionally, the following are available as customer-replaceable items:

- blade replacement set 314816-1 (includes 6 blades and 6 screws), and
- handle replacement spring 314819-1.

## 3. HOW TO USE THE TOOL

### NOTE

*Instructions are based on operator being right-handed. If operator is left-handed, use tool same way, except reverse hands.*

### A. Assemble The Tool

1. Remove handle and head from case. Hold handle in right hand as you would to operate it; but hold around grip only, and not around trigger (See Figure 2).
2. Hold head firmly in left hand, with thumb exerting pressure downward against flat top surface at rear of head.

### DANGER

*Keep thumb clear of slot in head where handle attaches. Also, DO NOT hold head so that fingers are in cutting area.*

3. Slide handle onto head. Make sure top surfaces of parts are flush.

### B. Adjust For Header Width (Figure 2)

1. Hold header in right hand. Hold tool in left hand with thumb and middle finger positioned to operate release buttons on guide. Support rear of handle firmly against chest or abdomen.
2. Press both release buttons in and at the same time slide guide forward against sides of header body. Proper adjustment should allow header to slide freely along guide ledges, but should not allow slop between header and guides.
3. When satisfied with the adjustment, relax pressure on release buttons. Hold header in place with right thumb.

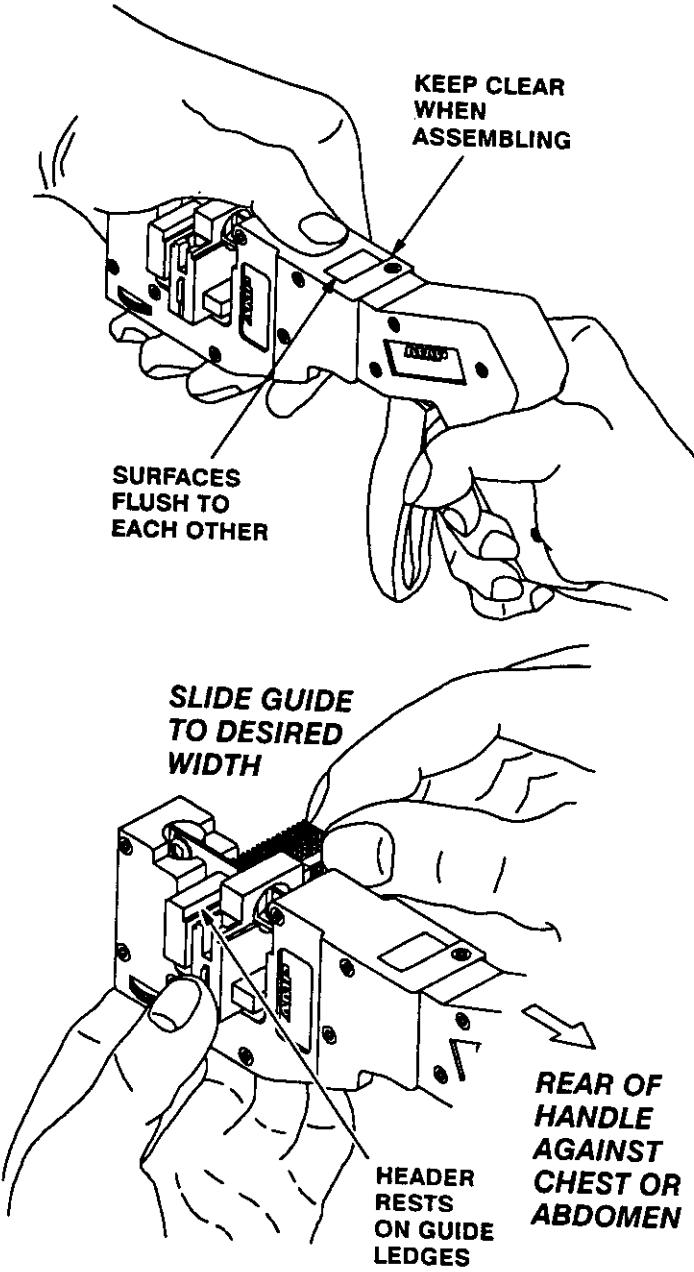


Fig. 2

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## C. Adjust Fixed Blade Height (Figure 3)

## NOTE

*This adjustment applies only to right-angle headers. It allows the header to slide unobstructed across guide ledges.*

1. Hold tool with thumb and forefinger of left hand positioned to turn adjustment wheel at lower front of head.
2. Using right thumb, slide header end against blade. Make sure header is in firm contact with guide ledges.
3. Looking down on top of tool, turn adjustment wheel counterclockwise to lower blade (clockwise if it needs to be raised) until the top edge of the blade is below lowest header post, but is still above plastic header body.

## D. Install And Adjust Locator (Figure 4)

1. Remove header from tool. Slide locator into slot in guide until it clicks in place. Make sure top surfaces of guide and locator are flush to each other.
2. Loosen locator stop and move it as far away from guide as possible. Replace header onto guide ledges.
3. Slide header along ledges until the correct number of post positions are to the right of blades for the size header you wish to cut. Blades must line up on cutting notch in header body. Hold header in place with left thumb.

## NOTE

*Header may be measured at blades so that 1 position up to 25 positions are to the right, leaving 15 positions or more to the left. To cut headers larger than 25 positions, measure to the left of blades.*

## DANGER

*Before continuing, make sure all parts of your hands are clear of blades.*

4. Carefully advance ratchet with right hand until header is firmly held by blades in cutting notch, but is not yet cut. Slide locator stop against right end of header and secure in place.

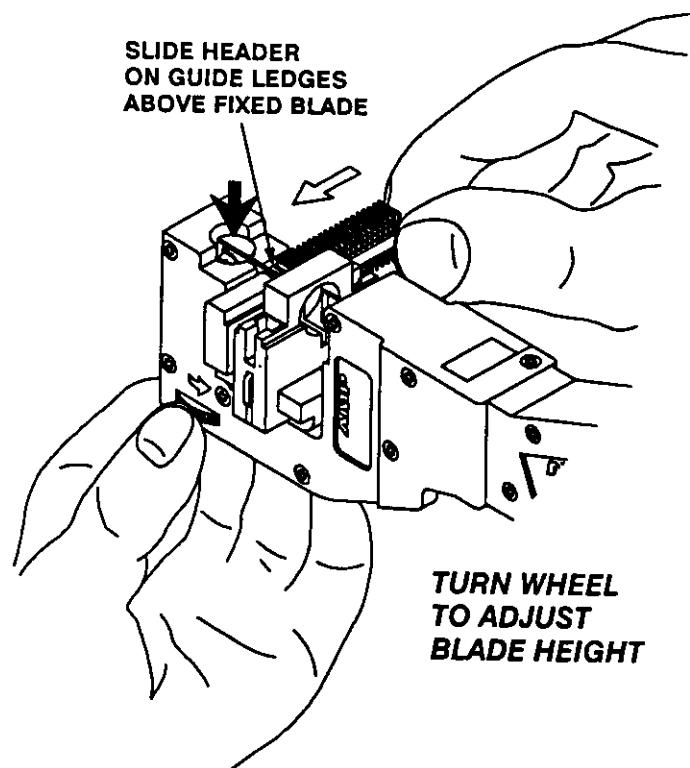


Fig. 3

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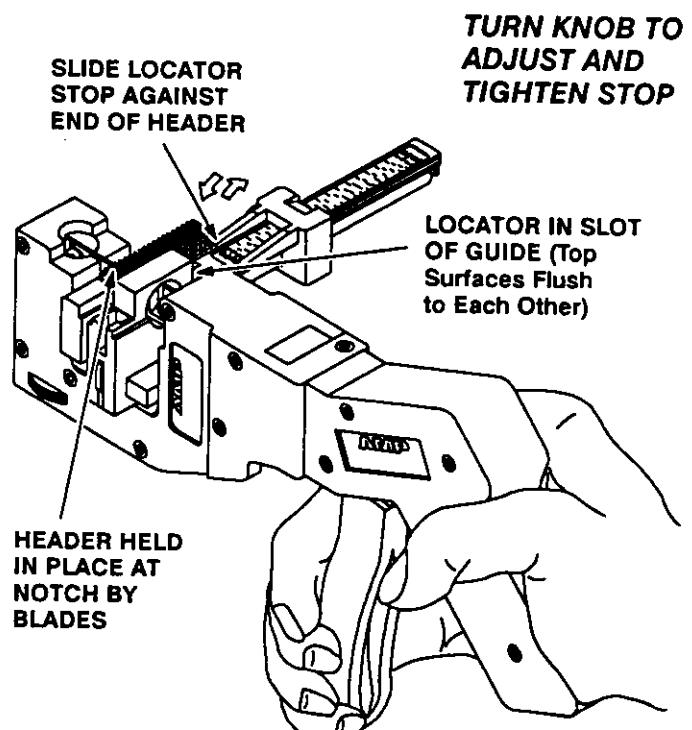


Fig. 4

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### E. Cut Headers (Figure 5)

Hold header with left hand and advance ratchet with right hand until ratchet cuts through header and releases to its original position.

You are now ready to cut any quantity of headers to the size you preset with the locator stop. To cut headers to another size, repeat steps 2 through 4, above.

### 4. DISASSEMBLING THE TOOL

#### A. Remove The Locator

##### CAUTION

*Always remove locator first when disassembling tool. Always remove locator and store it in carrying case when not in use.*

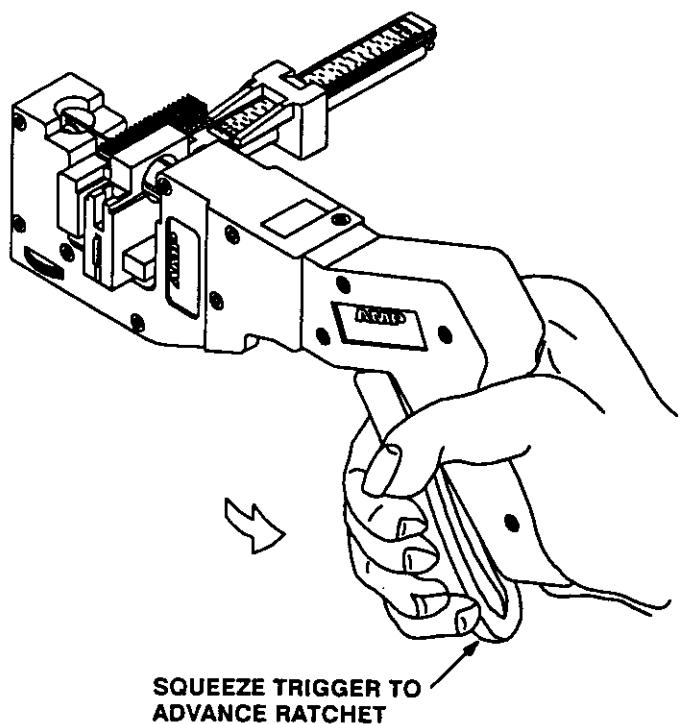


Fig. 5

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1. Hold tool head in left hand with left forefinger positioned to press right release button. Grasp locator firmly with right thumb and forefinger next to guide.
2. Press release button and lift straight up on locator to remove it.

#### B. Remove Handle From Head

##### NOTE

*Handle cannot be removed unless ratchet is fully released.*

1. Maintain a firm grip on head in left hand and handle in right hand as shown in Figure 6.
2. Remove handle with a quick, sweeping motion to the right, with right arm finishing fully extended.

##### DANGER

*Keep left hand clear of slot in head where handle attaches. Be sure area to your front and right is clear.*

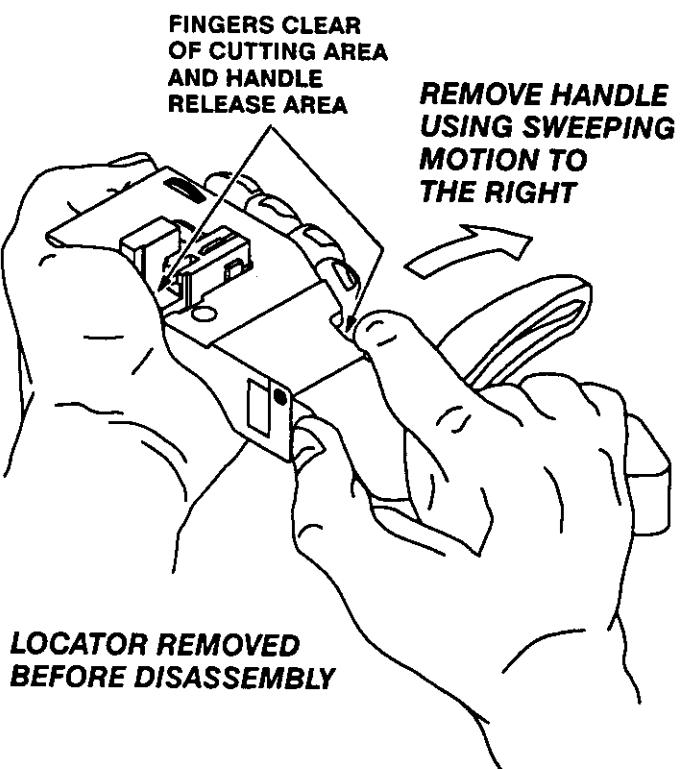


Fig. 6

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## 5. MAINTAINING THE TOOL (Figure 7)

Inspect the tool kit when you receive it and before each use. At the end of each shift the tool operator should clean the tool with a clean, soft, lint-free cloth. Change blades when necessary as follows:

1. Looking down on top of tool, turn adjustment wheel clockwise until fixed blade holder is at its top height limit and can be removed. Using small-nose pliers, grasp blade next to blade holder and remove by pulling straight up.
2. Remove and replace screw and blade using hex wrench in kit. Set aside; do not replace blade holder in head.
3. Handle must be assembled to head to remove the moveable blade. Press both release buttons and slide guide as far front as possible. Advance ratchet until screw clears head and remove screw (See Figure 7).
4. Press release buttons and slide guide as far toward handle as possible. Using small-nose pliers, turn blade to the side far enough to release it. Pull blade through slot in guide and remove it.
5. Release ratchet. Hold tool sideways with view hole facing up and head tilted upward slightly. Using small-nose pliers, pick up replacement blade from top with holes the same direction as polarizing features visible through view hole.
6. Insert blade through slot in guide until seated on polarizing features. Replace screw through view hole.
7. Place fixed blade holder in head. Make sure blade is directly above its seating slot. Push blade holder down with right thumb until seated; continue to push down while turning adjustment wheel counterclockwise until top of blade and holder are flush with top of head.

## 6. REPAIR

Stock an inventory of spare parts to prevent delays. Refer to Section 2 for correct part numbers and order from:

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

When necessary, the entire tool may be returned for evaluation and repair, with a written description of the problem, to:

CUSTOMER REPAIR (01-12)  
 AMP INCORPORATED  
 1523 NORTH 4TH STREET  
 HARRISBURG PA 17102-1604

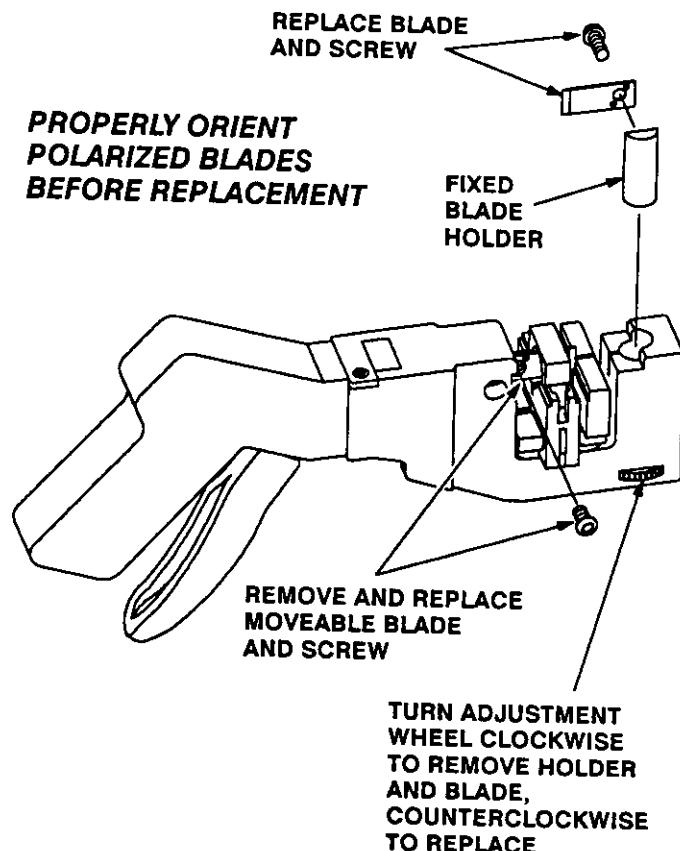


Fig. 7

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# Mouser Electronics

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[314818-1](#)