

**AMP**AMP INCORPORATED  
HARRISBURG, PA 17105

CUSTOMER HOTLINE

1 800 722-1111

AMP\* ACCESSORY TOOLING  
FOR AMPMODU\* CONNECTOR  
TOOLING ASSEMBLY 91411-2

REDUCED FOR PACKAGING

**IS 9138**

RELEASED

6-12-89

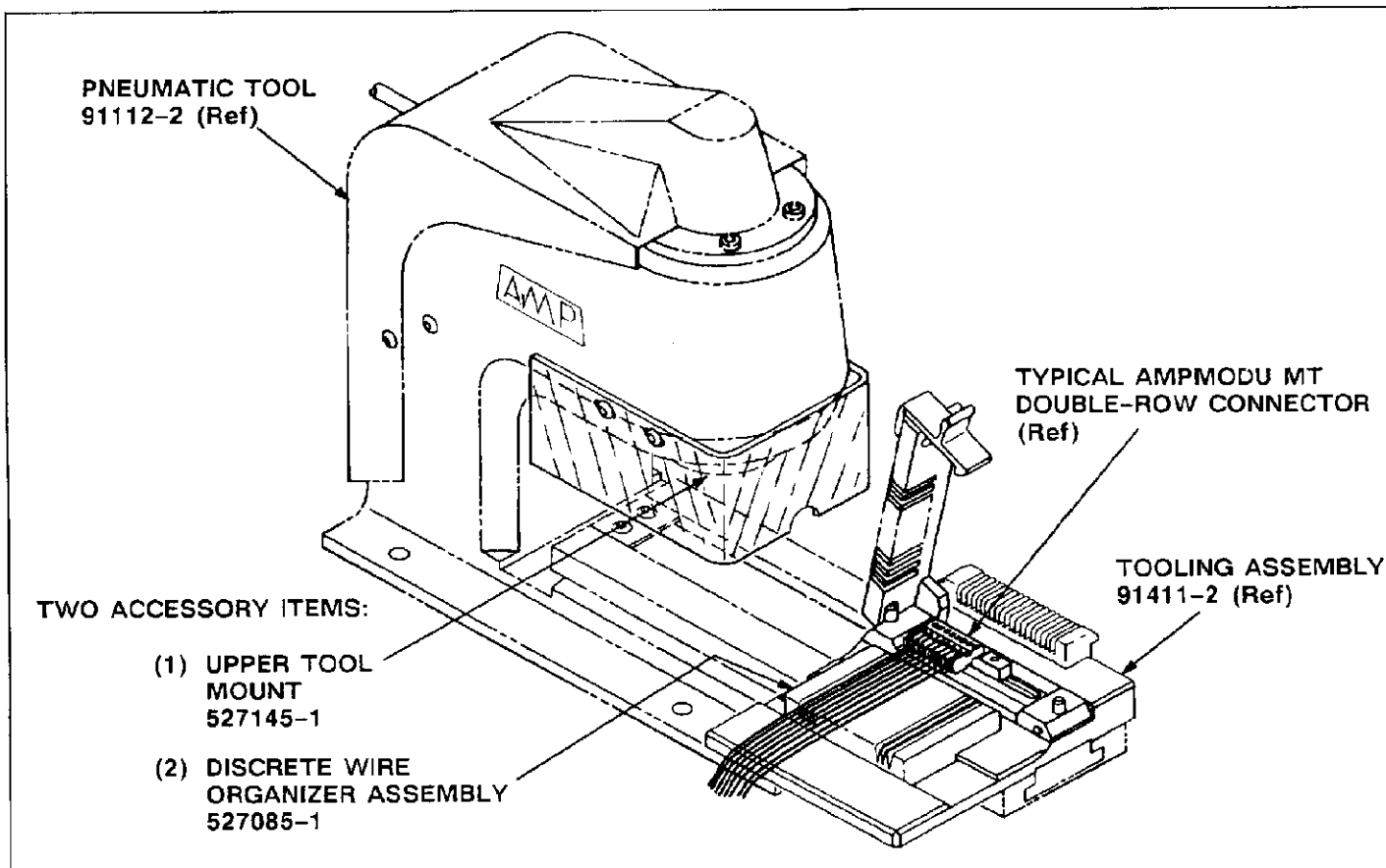


Fig. 1

**1. INTRODUCTION**

This instruction sheet (IS) covers the use of AMP accessory tooling for AMPMODU Connector Tooling Assembly 91411-2. Read these instructions and other references carefully before using the accessory tooling.

**NOTE**

*All dimensions on this sheet are in inches.*

**NOTE**

*Refer to AMP Instruction Sheet IS 9028 for specific information concerning the terminating of AMPMODU MT connectors to discrete wire, jacketed cable, and .050- or .100-in.-centerline ribbon cable.*

**2. DESCRIPTION (Figure 1)**

AMP accessory tooling consists of two items: Pneumatic Upper Tool Mount 527145-1 which replaces the standard mount in AMP Pneumatic Tool 91112-2 and Discrete Wire Organizer Assembly 527085-1 which is used when terminating discrete wire in the 91411-2 tooling assembly.

The discrete wire organizer can be used with either the pneumatic tool or AMP Manual Arbor Frame Assembly 91085-2. Refer to IS 7777 for instructions concerning the manual frame assembly, and to IS 7763 for the pneumatic frame assembly.

The discrete wire organizer (Figure 2) features a 25-position wire comb and a socket head cap screw. The upper tool mount (Figure 3) features a tool mount with an O-Ring.

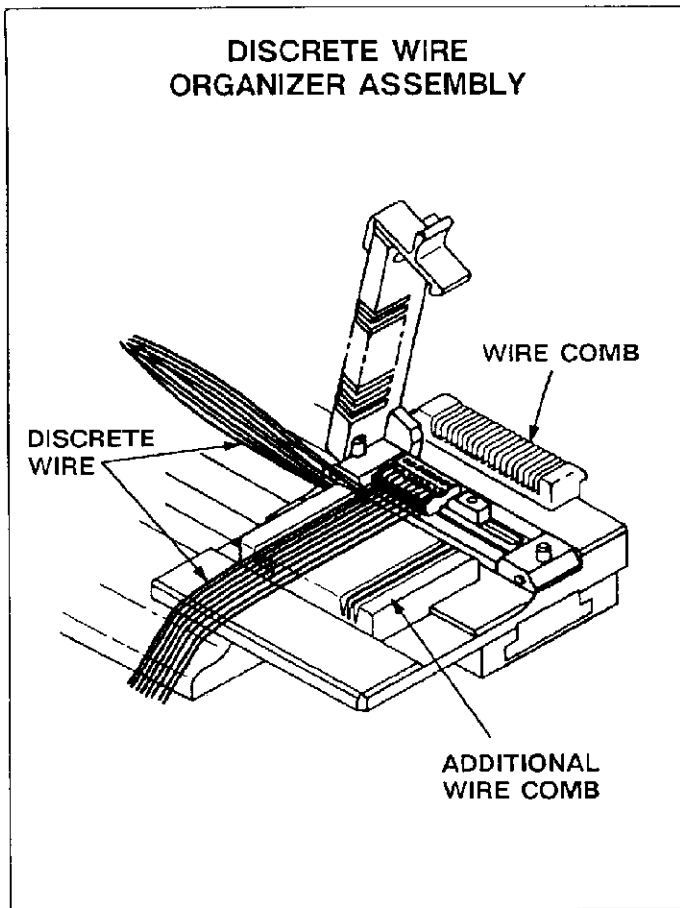


Fig. 2

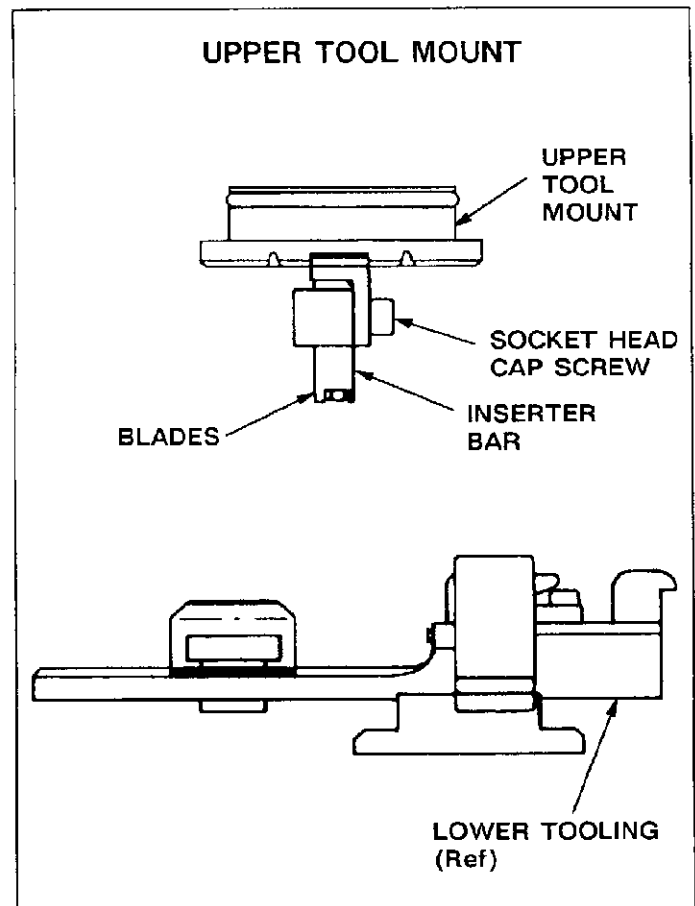


Fig. 3

### 3. ASSEMBLY PROCEDURES

#### A. Discrete Wire Organizer Assembly (Figure 2)

Discrete wires are terminated to the connectors by replacing the existing cable clamp with an additional wire comb. Proceed as follows:

1. Remove the existing cable clamp by removing the thumbscrew.
2. Insert the wire comb by tightening the socket head cap screw to the slide nut.

#### NOTE

Refer to IS 9028 for specific terminating procedures for discrete wire.

#### B. Upper Tool Mount (Figure 3)

When terminating AMPMODU MT connectors using the pneumatic tooling assembly, proceed as follows:

#### DANGER

Disconnect air supply from tooling before working on tool mount.

1. Remove the four screws of the existing upper tool mount on the pneumatic frame assembly and set the tool mount aside.
2. Remove the inserter tooling assembly from the manual tool mount supplied with the 91411-2 tooling assembly.
3. Mount the inserter tooling assembly to the pneumatic upper tool mount as shown in Figure 3.
4. Mount the upper tool mount to the pneumatic frame assembly using the four screws that were removed in Step 1. Make sure the heads of the inserter bar screws are facing the direction shown in Figure 3.
5. Manually cycle the applicator (air disconnected) to ensure proper alignment. Re-alignment of the lower tooling may be required. Refer to setup procedures in IS 9028.

4. TOOLING INSPECTION AND REPAIRS

AMP accessory tooling shown in Figures 1 and 4 was inspected prior to shipment. AMP recommends that the tooling be inspected immediately upon its arrival at your facility, and at regularly scheduled intervals, to ensure that it has not been damaged during handling and use.

When repair is necessary, contact your local AMP representative or return the tooling with a written description of the problem to:

AMP Incorporated  
Customer Repair  
1523 North 4th Street  
Harrisburg, PA 17102-1604

Additional accessory tooling can be ordered from:

AMP Incorporated  
P.O. Box 3608  
Harrisburg, PA 17105-3608

or a wholly-owned subsidiary of AMP Incorporated.

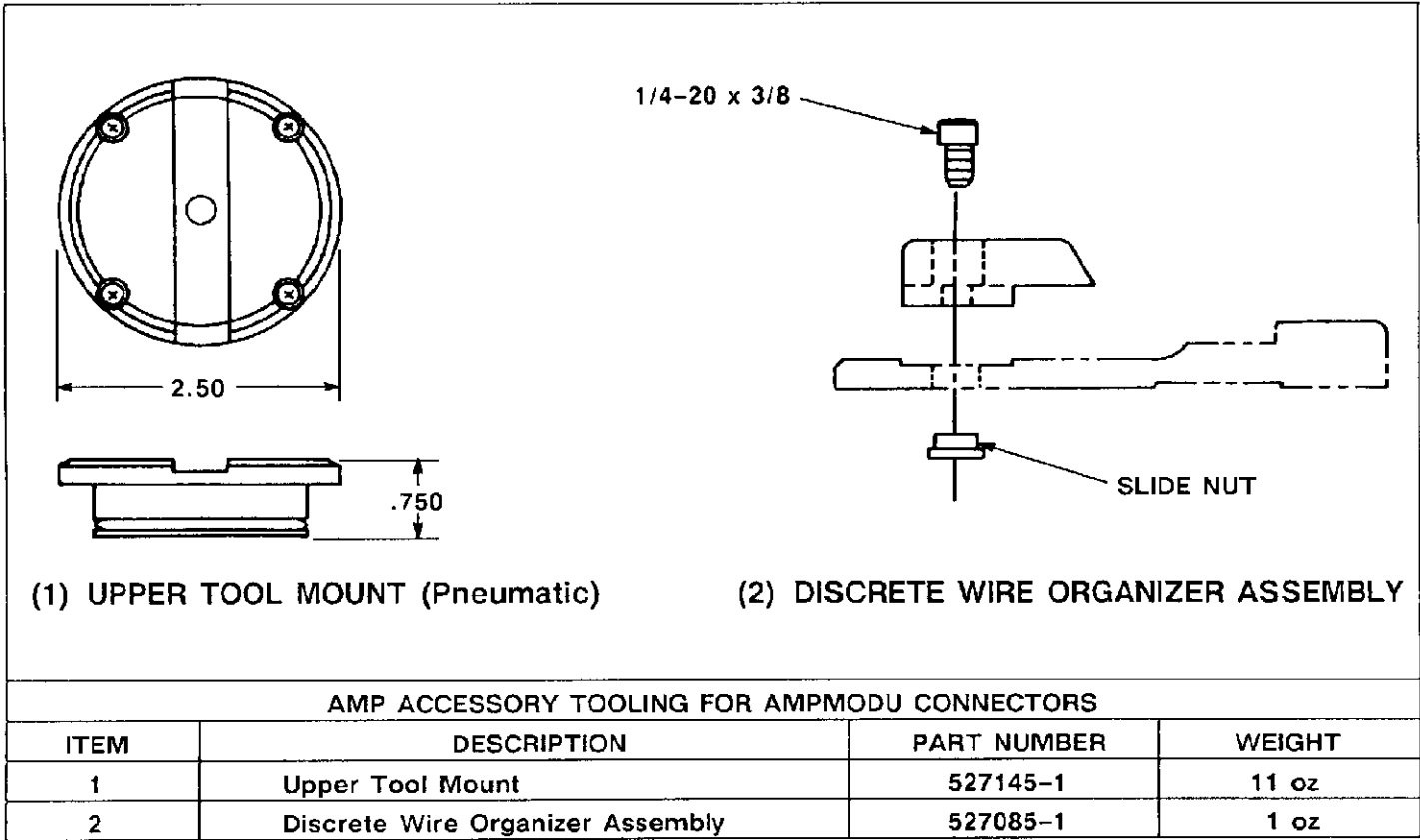


Fig. 4

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