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AMPAMP INCORPORATED
HARRISBURG, PA 17105AMP* CLINCHING TOOL 91117-5
FOR AMP TWO ROW AMP-HDI***IS 9178**CUSTOMER HOTLINE
1 800 722-1111

HIGH DENSITY INTERCONNECTION CONNECTORS

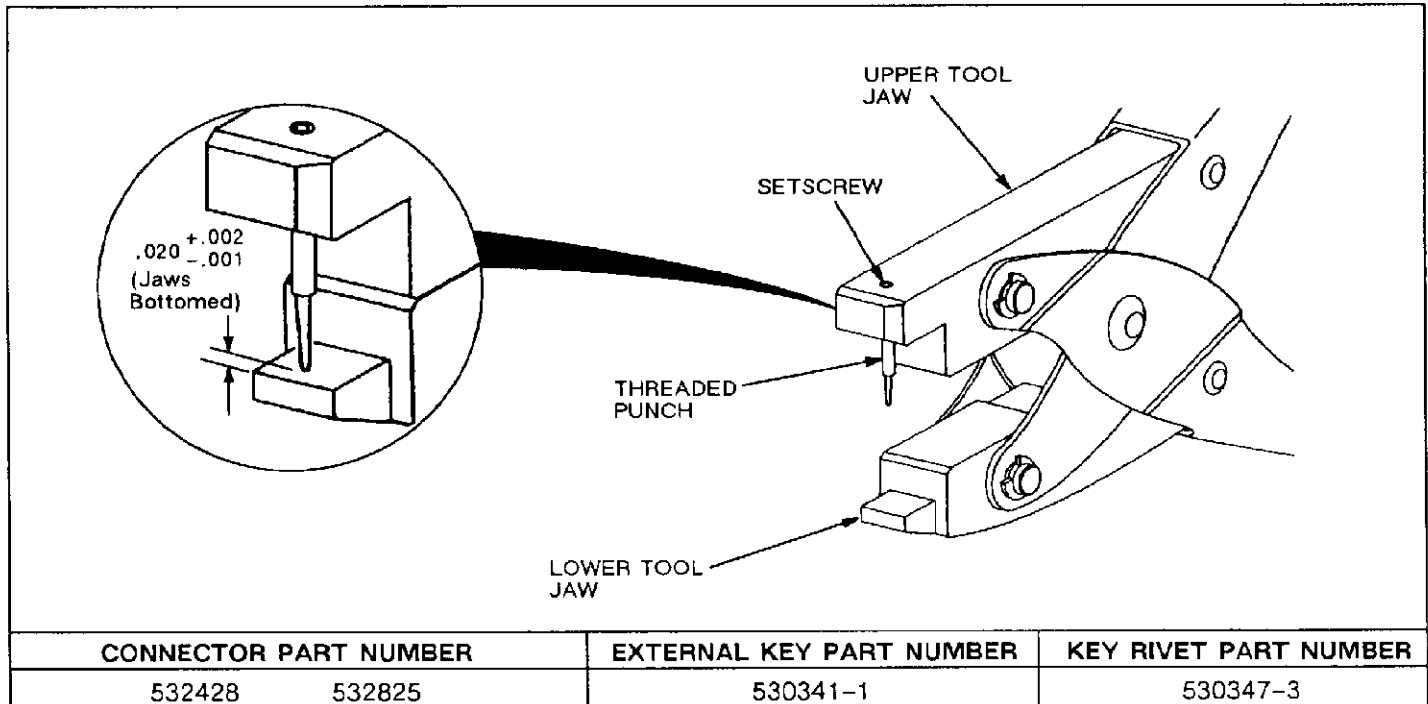
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Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Clinching tool 91117-5, which is designed to install external keys into the AMP-HDI two row connectors listed in Figure 1, to provide polarization of mating connectors. Read these instructions thoroughly before installing any keys.

NOTE

All dimensions on this sheet are in inches.

2. DESCRIPTION (See Figure 1)

The clinching tool features an upper and lower tool jaw. The upper tool jaw contains a setscrew and a replaceable threaded punch which clinches the rivet through the connector and key. The lower tool jaw supports the rivet when the tool handles are closed.

3. CLINCHING PROCEDURE

Before starting, make certain the connector, external key, and key rivet are compatible. (See Figure 1).

NOTE

Close tool handles and measure distance between punch tip and lower jaw. If necessary, adjust threaded punch and setscrew to obtain clearance of $.020 +.0021-.001$ (See Figure 1). To adjust punch, loosen set screw, adjust threaded punch up or down as required, and tighten set screw.

Refer to Figure 2 and proceed as follows:

1. Determine keying position required on connector. Key cavities are letter coded on one connector end and number coded on the other end.
2. Place key into cavity at desired position. Insert rivet into back of cavity with flat surface against connector. The rivet flat edge should face either end of the connector. (See View "A-A", Figure 2).

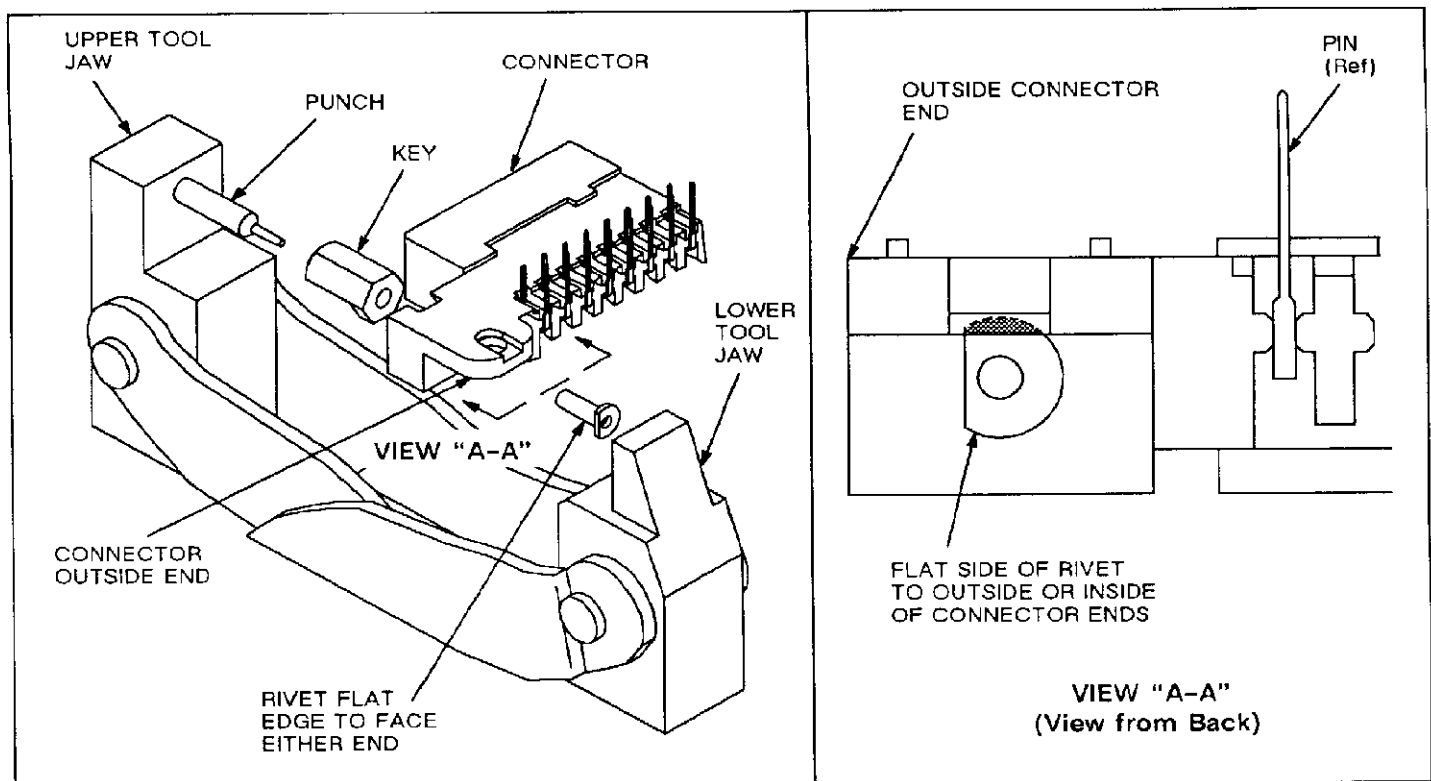


Fig. 2

3. Open tool handles and position tool perpendicular to connector.
4. Place lower tool jaw on rivet and close tool slowly, ensuring that the punch tip enters through key and into rivet.
5. Squeeze tool handles together until key presses into cavity and jaws are bottomed. Remove tool and, if required, repeat these procedures on other end of connector, making certain that key is properly oriented.

4. INSPECTION/MAINTENANCE

It is recommended that the tool be inspected immediately upon arrival at your facility, and at regularly scheduled intervals, to ensure that the tool has not been damaged during handling.

A. Daily Maintenance

It is recommended that each operator of the tool be made aware of — and responsible for — the following two steps of daily maintenance:

1. Remove dust, moisture, and other contaminants using a clean brush, or a soft lint-free cloth. Do NOT use objects that could damage the tool.
2. Make certain all pins, pivot points, and bearing surfaces are protected with a thin coat of SAE No 20 motor oil. Do NOT oil excessively.

B. Repair

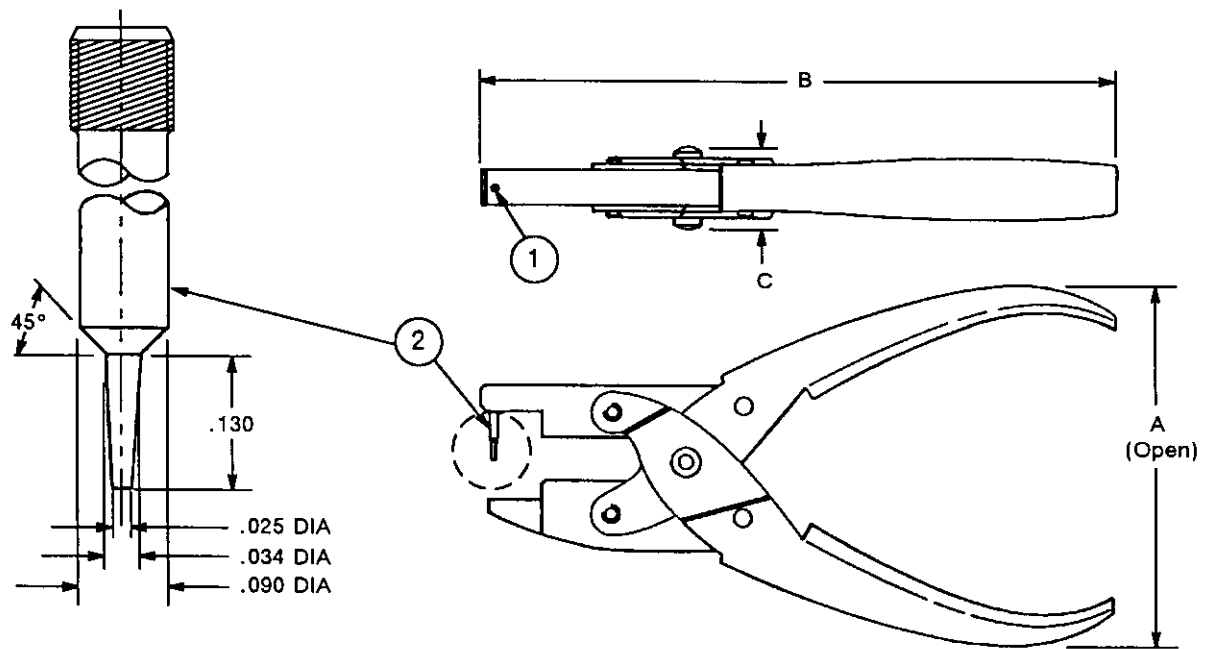
When repair is necessary, to ensure the quality and reliability of the tool, return the tool with a written description of the problem to:

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

Customer-replaceable parts, those specified in Figure 3, can be ordered from:

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

or a wholly owned subsidiary of AMP Incorporated.



TOOL SPECIFICATIONS		REPLACEMENT PARTS		
DIMENSION	WEIGHT	ITEM	PART NUMBER	DESCRIPTION
A	5.00	1	2-21006-7	SETSCREW, Skt Hd, No. 6-32
B	5.60			
C	.80			
	7.5 oz	2	314312-1	PUNCH, Threaded

Fig. 3