

AMPAMP INCORPORATED
HARRISBURG, PA 17105CUSTOMER HOTLINE
1 800 722-1111AMP* ASSEMBLY TOOL
CATALOG NO. 91016-[]
FOR AMP TURNABLE JACKSCREWS

REDUCED FOR PACKAGING

IS 7126RELEASED
1-7-65

CONNECTOR PRODUCTS DIVISION

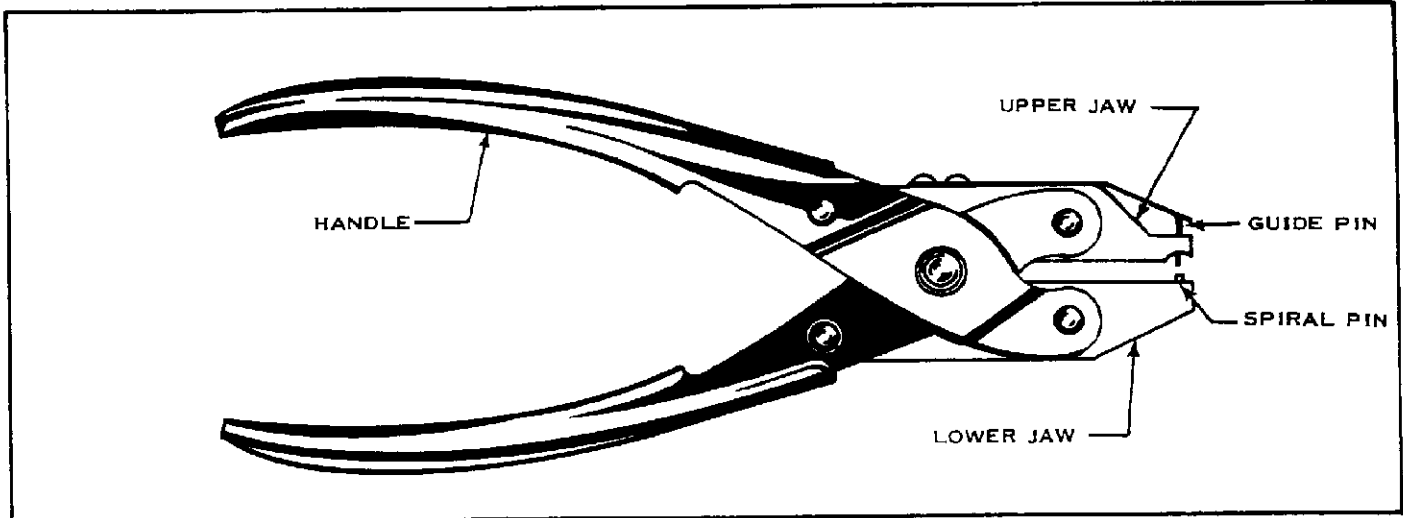


Fig. 1

1. This Tool (see Figure 1) is used to assemble Spiral Pins into A-MP Turnable Jackscrews for Series "M", Miniature DUALATCH* and COAXICON* Connectors. The Spiral Pin holds the Jackscrew Tip in the Jackscrew Body. There are two Methods of Assembly. Method I is used in all cases in which Method II does not apply. Method II is used only to assemble Jackscrews which will be used to attach Strain Relief Clamps to Connector Blocks.

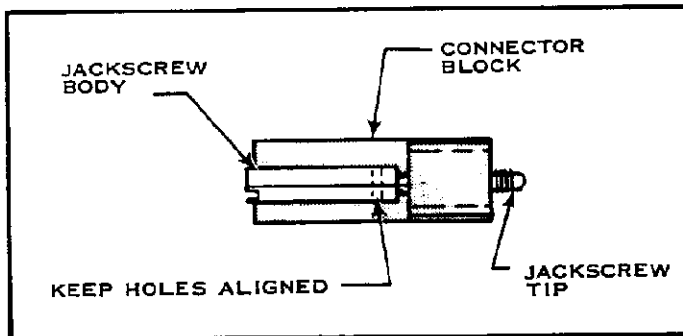


Fig. 2

II METHOD I**1. PREPARATION**

- Place Spiral Pin into hole in Lower Jaw of Tool. See Figure 1.
- Insert Jackscrew Tip thru Connector Block and into Jackscrew Body. See Figure 2.
- Align hole in Tip with hole in Body. See Figure 2.

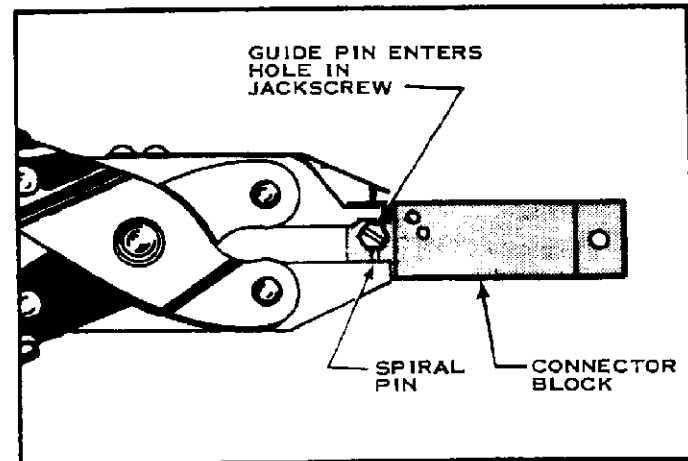


Fig. 3

2. SPIRAL PIN ASSEMBLY

- Grasp Jackscrew with Tool so that Guide Pin in Upper Jaw of Tool fits into hole in Jackscrew. See Figure 3.
NOTE: Guide Pin must pass thru Jackscrew Body into Jackscrew Tip.
- Squeeze Handles. As Jaws close, Spiral Pin will pass thru Body into Tip.
- Open Handles and remove Tool from Jackscrew.
- Using flat part of Tool Jaws, complete insertion of Spiral Pin into Jackscrew.

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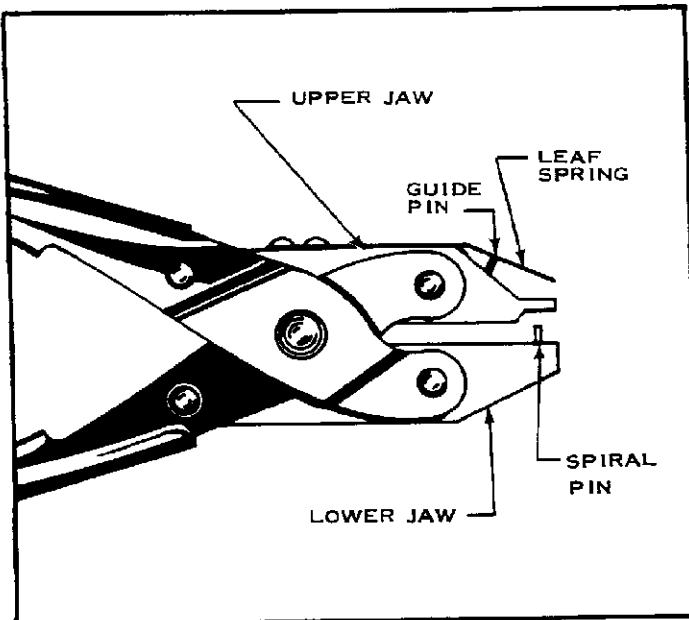


Fig. 4

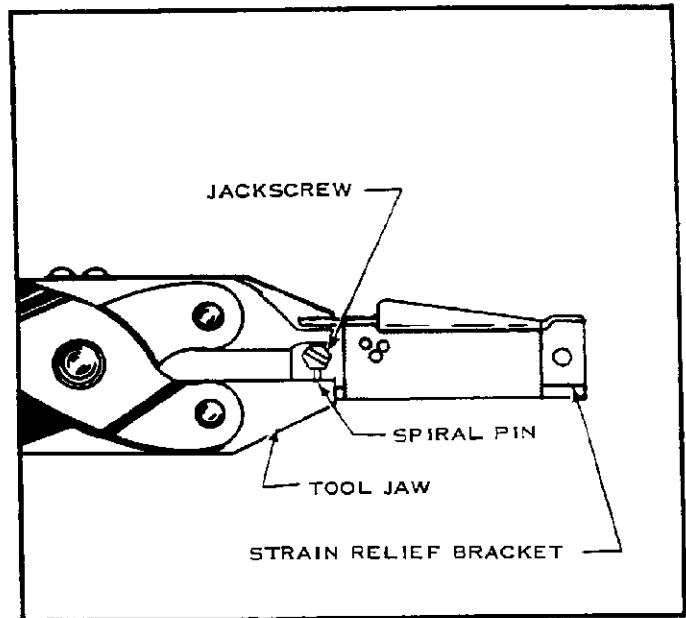


Fig. 5

III METHOD II

1. PREPARATION

- (a) Lift Leaf Spring on Upper Jaw of Tool and place Guide Pin in Receptacle in Upper Jaw as shown in Figure 4.
- (b) Place Spiral Pin into Lower Tool Jaw as shown in Figure 4.
- (c) Place Strain Relief Clamp Bracket against Connector Block. See Figure 5.
- (d) Continue Preparation as in Para. II-1 (b & c).

2. SPIRAL PIN ASSEMBLY

- (a) Keeping holes in Jackscrew Tip and Body aligned, grasp Jackscrew with Tool so that Spiral Pin fits into hole in Body. See Figure 5.
- (b) Continue Spiral Pin Assembly as in Para. II-2 (b, c & d).