

Figure 1

## 1. INTRODUCTION

This instruction sheet describes the installation and setup of Termination Tooling Kit 1424082-1 for the Paddleboard Style Terminator. The tooling kit is used with the Base Assembly Universal Arbor Tool 768338-2 and the Manual Arbor Frame Assembly 91085-2 to terminate AMP-LATCH\* Paddleboard Terminators onto .64 mm [.025-in.] centerline ribbon cable.

For information on the setup and operation of Universal Arbor Tool 768338-2, refer to Instruction Sheet 408-9875. For information on the setup and operation of Manual Arbor Frame Assembly 91085-2, refer to Instruction Sheet 408-7777.

Read these instructions (and other referenced documents) thoroughly before terminating any connectors.

### NOTE



*Dimensions are in metric units [followed by inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.*

## 2. DESCRIPTION (Figure 1)

Termination Tooling Kit 1424082-1 consists of a spacer plate, a retention block, and two locators. The

spacer plate supports the paddleboard terminator at the same height as the flutes on the arbor tool to allow ease of cable insertion into the terminator. The retention block on the spacer plate prevents the paddleboard terminator from moving away from the fluted surface. The retention block also allows two resting positions for the paddleboard terminator. The two locators align the paddleboard terminator with the flutes on the base tooling of the arbor tool.

## 3. TERMINATION TOOLING KIT INSTALLATION

1. Remove the spacer and the fluted plate from the arbor tool assembly by removing the two socket head cap screws. See Figure 2, Detail A.

2. Install the termination tooling kit onto the arbor tool assembly, as shown in Figure 2, Detail B. Reassemble the fluted plate onto the arbor tool. Hold the locator kit and fluted plate in place with the socket head cap screws. **DO NOT** tighten the socket head cap screws.

3. Position the paddleboard terminator on the tooling kit between the locators and the retention block with the connector cover facing up. See Figure 1.

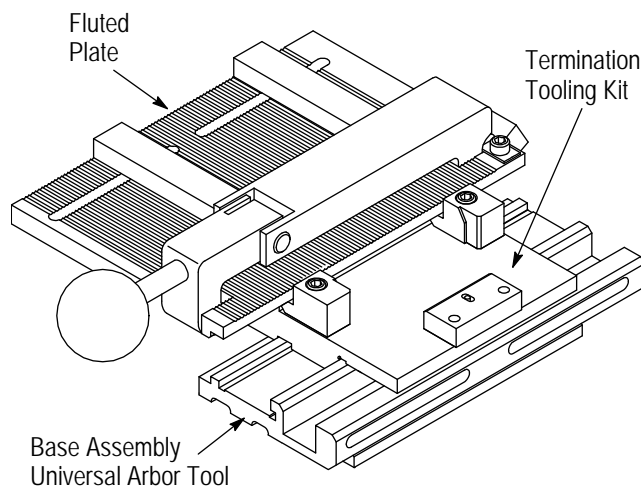
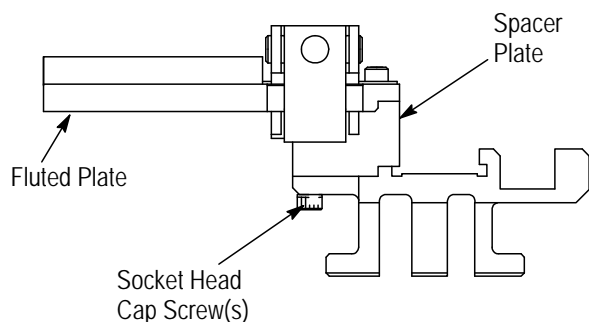


Figure 2

**NOTE**


The locators are positioned on the spacer plate at assembly and should not require further adjustment. Any tooling alignment should be done by moving the entire locator kit and the fluted plate.

4. Insert the cable into the paddleboard terminator; then place the cable onto the fluted plate between the cable guides. Align the termination tooling kit so that the centers of the contacts are in line with the flutes on the tool plate. When the cable conductors are directly over the insulation slots of the contacts, the tooling is properly aligned. Secure the tooling by tightening the two socket head cap screws. See Figure 2, Detail A.

**NOTE**


During setup, make sure the cable conductors are positioned down into the flutes of the tool plate and are perpendicular to the paddleboard terminator. The cable guides must be positioned against the cable. If an adjustment is necessary, loosen the thumbscrews, move the cable guide(s) against the cable, and re-tighten the thumbscrews.

5. When the cable is properly positioned, close the cable clamp.

**CAUTION**


Re-check the position of the cable to ensure that the spacer plate did not move during setup. If the cable conductors are not directly over the insulation slots of the contacts, re-adjust the spacer plate.

6. Perform a test termination. Remove the paddleboard terminator from the tooling; then remove the terminator cover from the connector. Inspect the termination to ensure that each contact has pierced through the cable, straddling each conductor.

#### 4. REVISION SUMMARY

- New logo

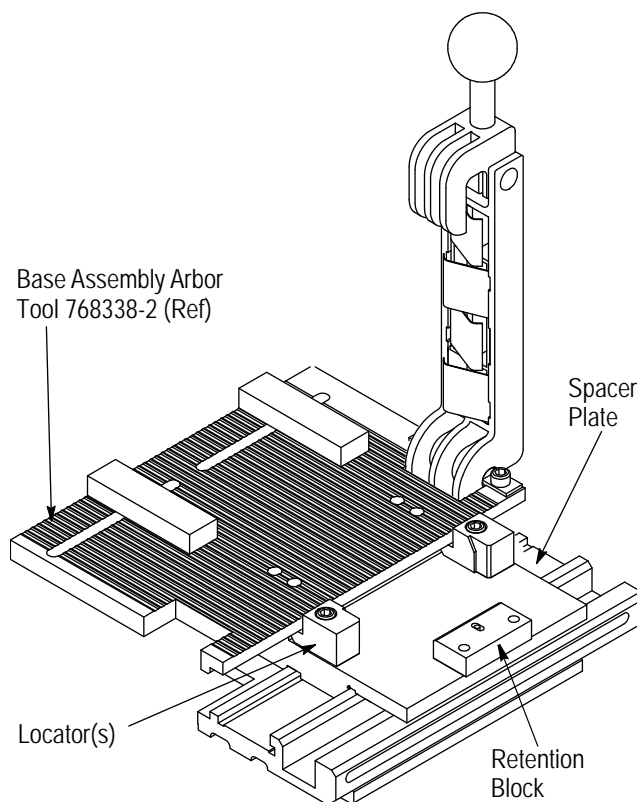


Figure 3