



AMP ★ LANCELOK ★
INSERTION TOOL
Catalog No. 69421

IS 1902	
RELEASED	12-3-63
REVISED	2-28-78

1. INTRODUCTION

Tool No. 69421 is used to insert AMP LANCELOK terminals into contact springs in the rear board frame and spring assemblies of programming systems. The tool may also be used to insert or extract AMP Multiple Contact Patchcords used in AMP Patchcord Programming Systems. See page 2 for insertion and extraction procedures.

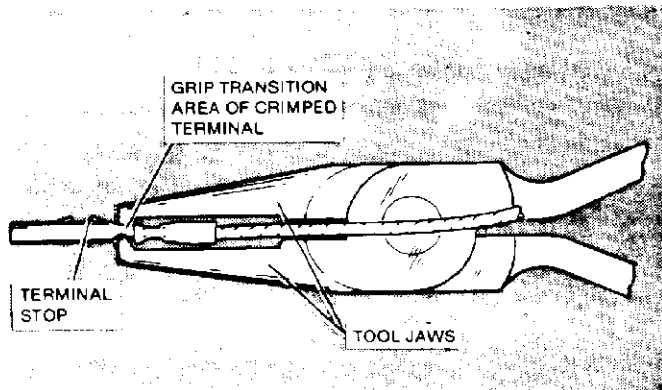


Figure 1

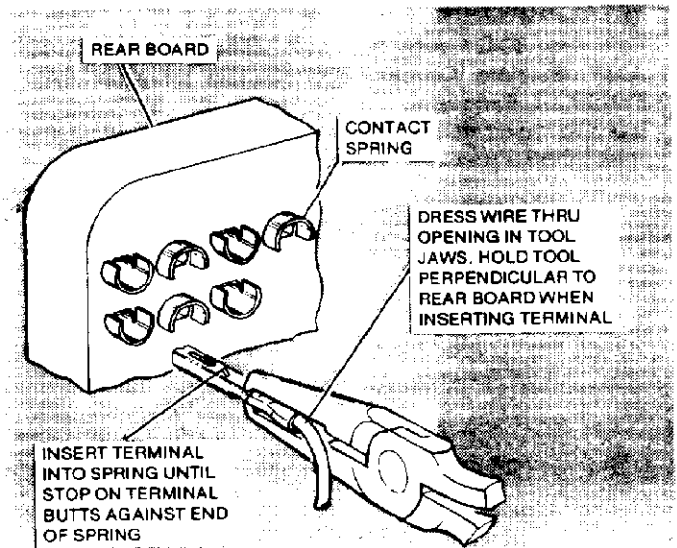


Figure 2

2. INSERTION PROCEDURE

- (a) PIDG ★ LANCELOK terminals must first be crimped onto wire according to instruction sheets No. 1830 or 1877. Uninsulated LANCELOK terminals are crimped according to instruction sheets No. 1842 or 1901.
- (b) Grip transition area of crimped terminal with insertion tool as shown in Figure 1.
- (c) Dress wire thru opening in tool jaws. See Figure 2. Do not grip wire.
- (d) Hold tool perpendicular to rear board and insert terminal into contact spring. See Figure 2.

NOTE: Make sure that terminal is properly aligned with hole in contact spring. Flat portion of terminal must be placed against flat portion of inside of spring.

- (e) Terminal stop butts against end of spring when terminal is properly inserted to maximum depth. See Figure 3.
- (f) Remove insertion tool from terminal.

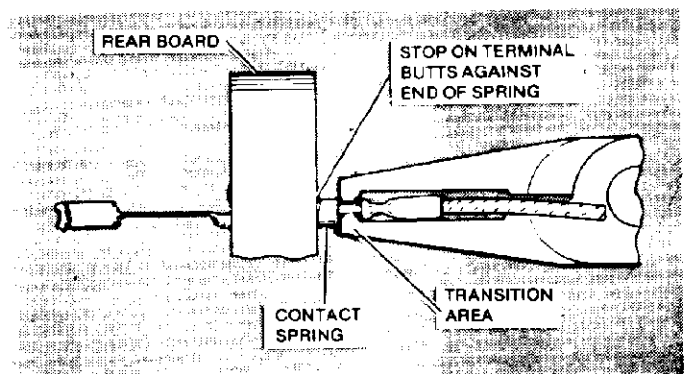


Figure 3

Copyright 1963, 1965, 1978
 by AMP Incorporated,
 Harrisburg, Pa. All International Rights Reserved. AMP Incorporated
 products covered by U.S. and Foreign Patents and/or Patents Pending.

**PATCHCORD INSERTION &
EXTRACTION PROCEDURE**
Using Tool No. 69421

1. INTRODUCTION

Tool No. 69421 may be used to insert and extract AMP Multiple Contact Patchcords, used in AMP Patchcord Programming Systems. This tool may be used to insert or extract only those patchcords having a notched shroud as shown in Figure 1.

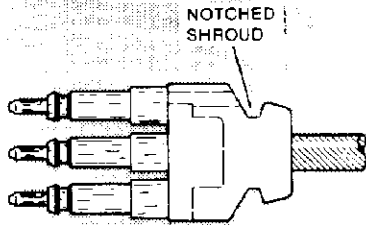


Figure 1

2. INSERTION PROCEDURE

- (a) Grip notched shroud of patchcord. See Figure 2.

NOTE: Do not squeeze shroud too hard. Use only sufficient force to maintain a firm grip to insert patchcord in panel.

- (b) Insert patchcord contacts into desired position in programming system and carefully push patchcord into panel.

3. EXTRACTION PROCEDURE

- (a) Grip notched shroud of patchcord. See Figure 2.

NOTE: Do not squeeze shroud too hard. Use only sufficient force to maintain a firm grip to extract patchcord from panel.

- (b) Carefully pull patchcord from panel.

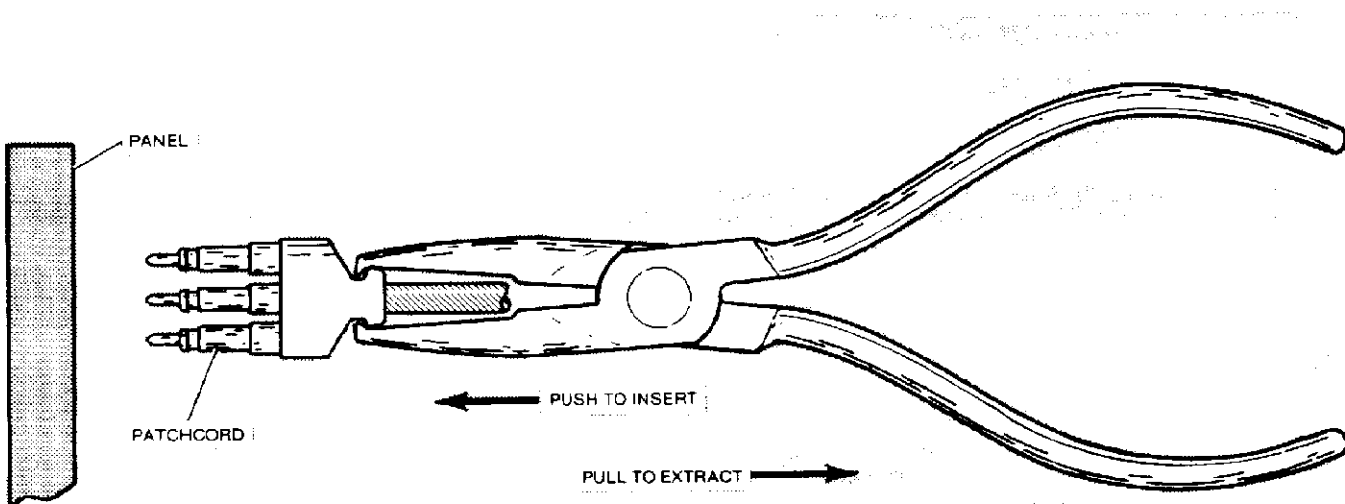


Figure 2