

1. INTRODUCTION

This instruction sheet provides instructions on tool applications and a maintenance and inspection procedure for:

AMP ★ CERTI-LOK ★ INSERTION TOOL
Catalog No. 380392-8

The AMP CERTI-LOK insertion tool (Figure 1) is the basic tool of the AMP Pin and Contact Replacement Tool, Part No. 265871-□. As described in Instruction Sheet IS 2636, the pin and contact replacement tool includes one or more ACTION PIN★ contact replacement tips. This tool, with the selected contact replacement tip screwed into the plunger, is used to remove and replace ACTION PIN contacts in pc boards and panels.

BASIC INSERTION TOOL
NO. 380392-8 (PART OF
PIN AND CONTACT REPLACE-
MENT TOOL NO. 265871-□)

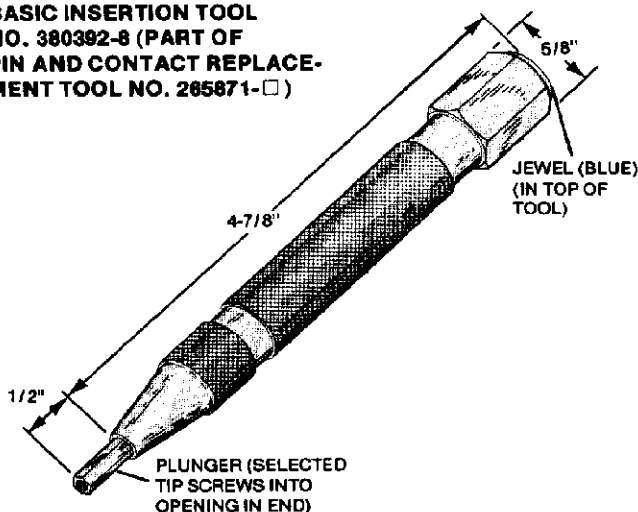


Figure 1

2. INSTRUCTIONS FOR USE OF TOOL

- (a) Obtain specified ACTION PIN contact replacement tip and screw it tightly into end of plunger (Figure 1).
- (b) Refer to IS 2636 for instructions in the use of this tool in the removal and replacement of ACTION PIN contacts.

NOTE: IS 2636 is included in Customer Manuals CM 2642 and CM 2740 which are supplied with ACTION PIN contact assembly kits.

3. MAINTENANCE/INSPECTION PROCEDURE

AMP recommends that a maintenance/inspection program be performed periodically to ensure dependable and uniform operation. Inspect the tool at least once a month. The frequency of inspection may be

adjusted to suit your requirements through experience, and is dependent upon:

- 1. The care, amount of use, and handling of the tool.
- 2. The degree of operator skill.
- 3. The presence of abnormal amounts of dust and dirt.
- 4. Your own established standards.

All tools are thoroughly inspected before shipping. Because of the possibility of damage in shipment, however, inspect your new tool in accordance with the following instructions when you receive it in your plant.

3.1 VISUAL INSPECTION

Do not allow deposits of dirt, grease, or other foreign matter to accumulate on the tool, especially on the plunger. These deposits may cause improper tool operation. Visually inspect the tool. All parts should be dry, clean, and free from nicks, burrs, and deformations. Clean, adjust, repair, and replace parts as necessary.

3.2 ADJUSTMENT OF TRIP FORCE

The trip force of this tool is adjustable and is factory adjusted for 16 to 18 lbs. Proper trip force is required to ensure proper insertion of the ACTION PIN contact into pc board or panel. To check the trip force accurately, obtain a gage that indicates trip force in pounds. Use a Chatillon Scale, No. 30D, with Van Dorn Drill Stand (bench type), No. 22145, Size 40, or their equivalents. See Figure 2. Check and, if necessary, adjust tool, as follows:

- (a) Place tool plunger under scale tip with top of tool on tool base on bench drill stand, as shown in Figure 2.
- (b) Pull down on bench drill handle until tool trips. The scale will indicate trip force in lbs. If trip force indication is not between 16 and 18 pounds, adjust trip force as instructed in steps (c) through (f) below.
- (c) Pry off the jewel (Figure 1).
- (d) Place shank cap (Figure 3) in vise and turn shank body counterclockwise one full turn.
 NOTE: Always pad surfaces of tool to prevent marring of the tool finish.
- (e) Turn tension adjusting screw (Figure 3) clockwise to increase or counterclockwise to decrease the trip force.
- (f) Retighten shank cap and trip the tool at least five times. Then repeat steps (a) and (b). If trip force is correct, replace jewel and tool is ready for operation. If trip force is incorrect, repeat steps (d) through (f) until correct trip force is achieved, and then replace jewel.

3.3 DISASSEMBLY AND REASSEMBLY

When it is necessary to disassemble the tool to replace damaged parts, proceed as follows:

- (a) Clamp shank body in vise. Use care not to deform shank body by closing vise too tightly.

All illustrations and information contained in this instruction sheet are based on the latest product information available at the time of publication.

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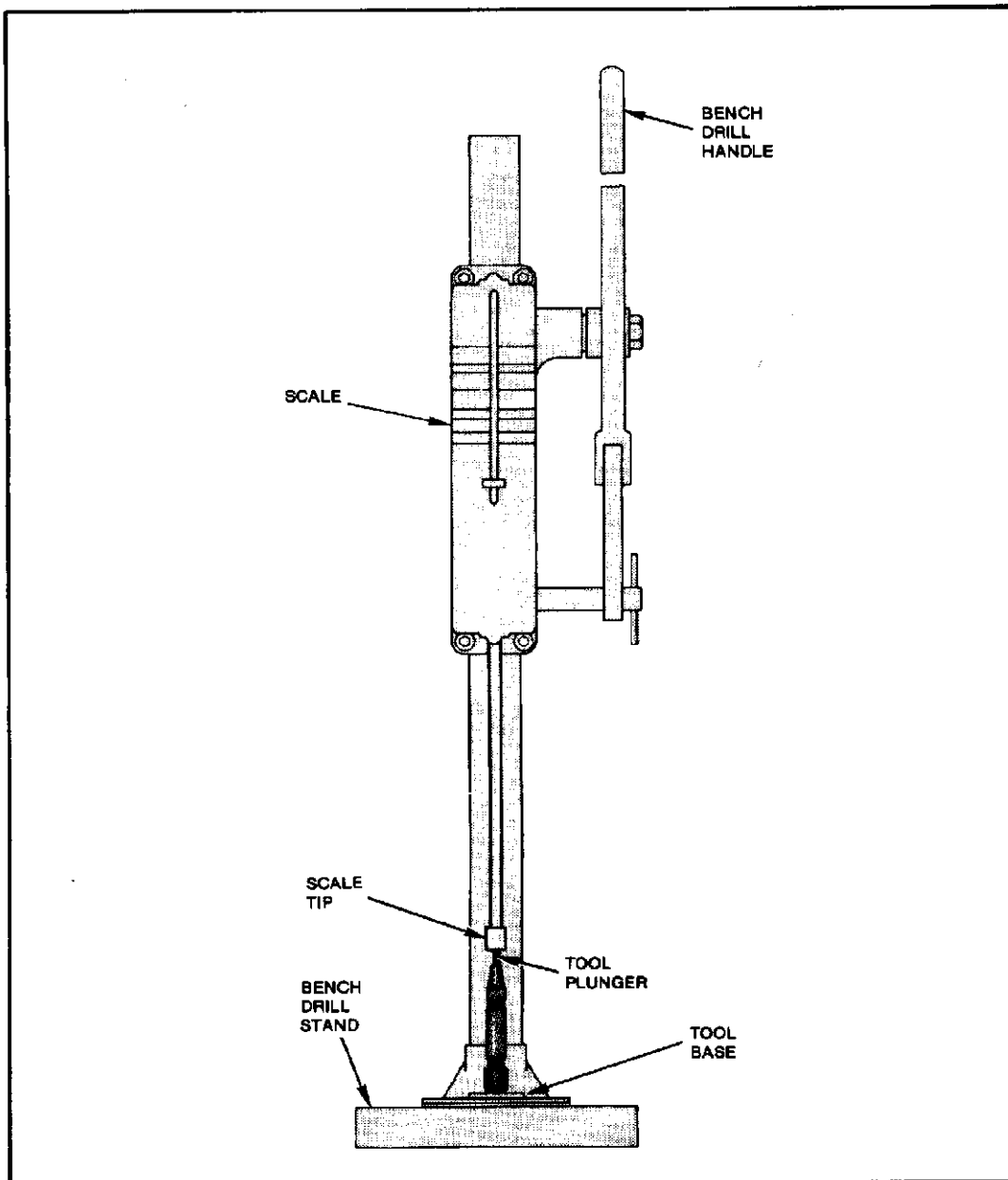


Figure 2

- (b) Remove shank cap, tension adjusting screw, and hammer spring from shank body.
- (c) Remove shank tip from shank body.
- (d) Remove plunger cap, plunger spring, and plunger from shank tip.
- (e) Take shank body out of vise and remove hammer assembly from shank body.
- (f) If necessary, remove triggers from hammer by prying up on free ends of triggers.
- (g) Inspect trigger retainer for cuts or nicks. If it is necessary to replace trigger retainer, use care not to cut or nick retainer on edges of retainer groove on hammer.
- (h) Before reassembling hammer assembly into shank body, apply a film of Texaco Regal ARO 10W Rust

Resistant Oil, or equivalent, to hammer and triggers.
NOTE: Oil must be light viscosity, non-gumming, and compatible with neoprene trigger retainer.

- (i) Reassemble trigger retainer and triggers on hammer and insert hammer assembly into shank body.
- (j) Reassemble plunger, plunger spring, and plunger cap into shank tip.
- (k) Place shank body in vise using care not to close vise too tightly, and assemble shank tip to shank body.
- (l) Reassemble hammer spring, tension adjusting screw, and shank cap to shank body.
- (m) Remove shank body from vise.
- (n) Check and adjust trip force, as described in paragraph 3.2. With trip force adjusted for 16 to 18 pounds, the tool is ready for operation.

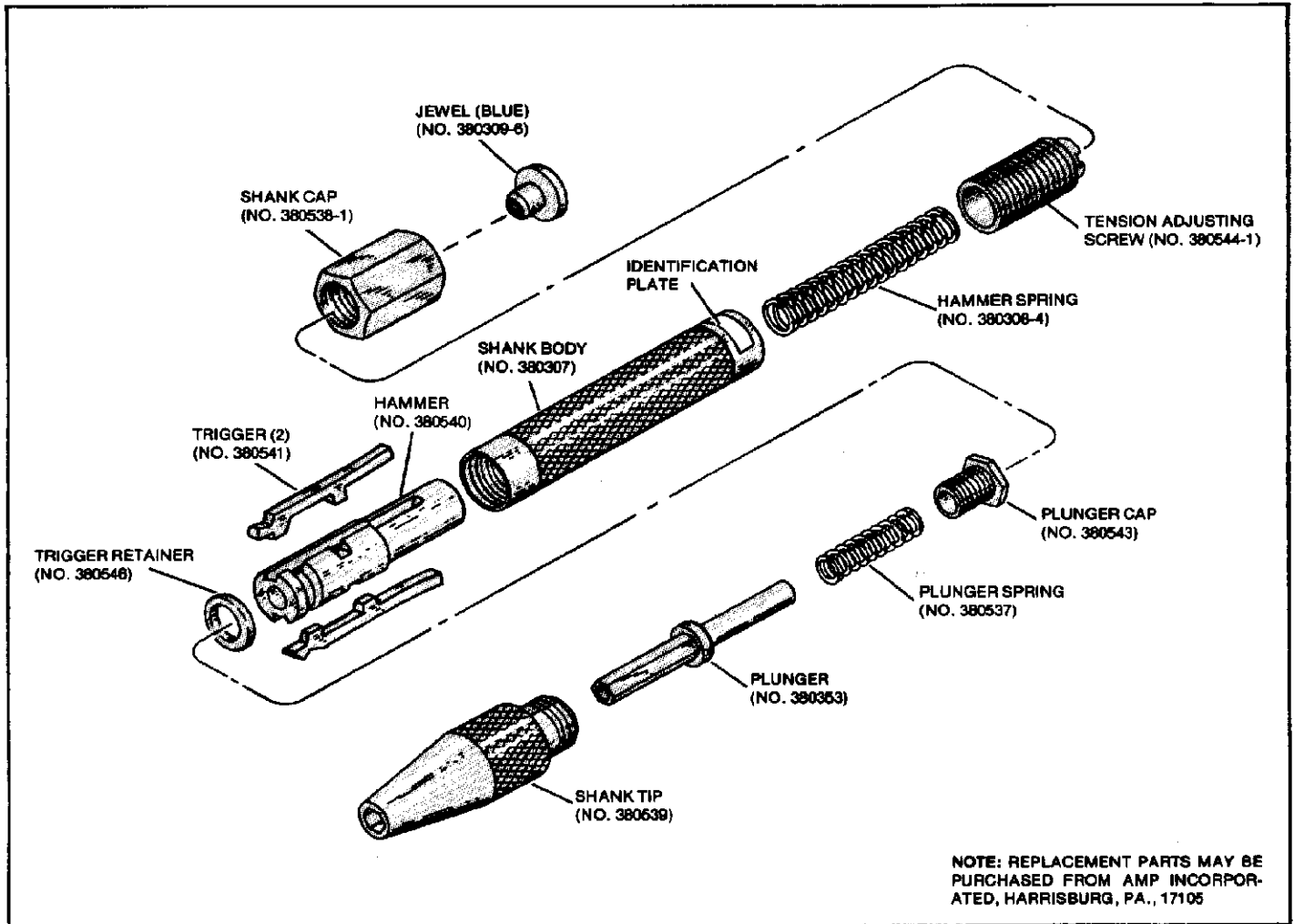


Figure 3

3.4 REPLACEMENT PARTS

When field maintenance of this tool is anticipated, it will be advantageous to stock certain replaceable parts. Figure 3 illustrates and identifies replaceable

parts that can be purchased from AMP Incorporated, Harrisburg, Pa., 17105, or a wholly owned subsidiary of AMP Incorporated.

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2-17-78		ENG. <i>James Collier</i>	PUB. <i>Paul Felty</i>