AMP INCORPORATED
HARRISBURG, PA. U.S.A.

ADJUSTMENT & REPAIR OF A-MP★ CERTI-LOK★ TAPER PIN INSERTION TOOLS

IS 7162	
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1. INTRODUCTION

A-MP CERTI-LOK Insertion Tools have been adjusted prior to shipment to give optimum service. It is recommended that when Tools need adjustment or repair, they be returned to AMP for this service. (See applicable AMP Customer Drawing.) If you wish to adjust or repair the Tools, the following procedures are recommended. AMP is not responsible for damages arising out of defective repair by the customer. Read these instructions carefully before attempting to adjust or repair Tools.

NOTE These instructions apply only to CERTI-LOK Tools WITHOUT THE PULL-TEST FEATURE. To adjust Tools with the Pull-Test feature, see AMP Instruction Sheet No. 7163.

2. TRIP FORCE ADJUSTMENT

Proper Taper Pin retention is assured only when the Trip Force is properly adjusted. To check the Trip Force accurately, you will need a Gage that indicates the Trip Force in pounds. Use a Chatillon Scale #30 D with Van Dorn Drill Stand (bench type) #22145, Size 40 or their equivalents. See Figure 1. Test the Insertion Tool as follows:

1. Place Tool Tip under Scale Tip with the Tool Base on Bench Drill Stand. See Figure 1.
2. Pull down on Bench Drill Handle until Tool trips.
3. The Scale will indicate Trip Force in pounds. If Trip Force does not fall within the range shown in Figure 3, the Tool must be adjusted.

Adjust the Tool as follows:

1. Pry off the Jewel.
2. Place Shank Cap in vise and turn Shank Body counterclockwise one full turn.

NOTE Always pad surfaces of Tool to prevent marring the finish.

3. Turn Tension Adjusting Screw clockwise to increase Trip Force or counterclockwise to reduce Trip Force.
4. Tighten Shank Cap. Trip Tool at least five times. Repeat above test. If the Trip Force is correct, the Jewel may be replaced and the Tool is ready for operation. If the Trip Force is incorrect, further adjustment must be made according to the preceding operations.

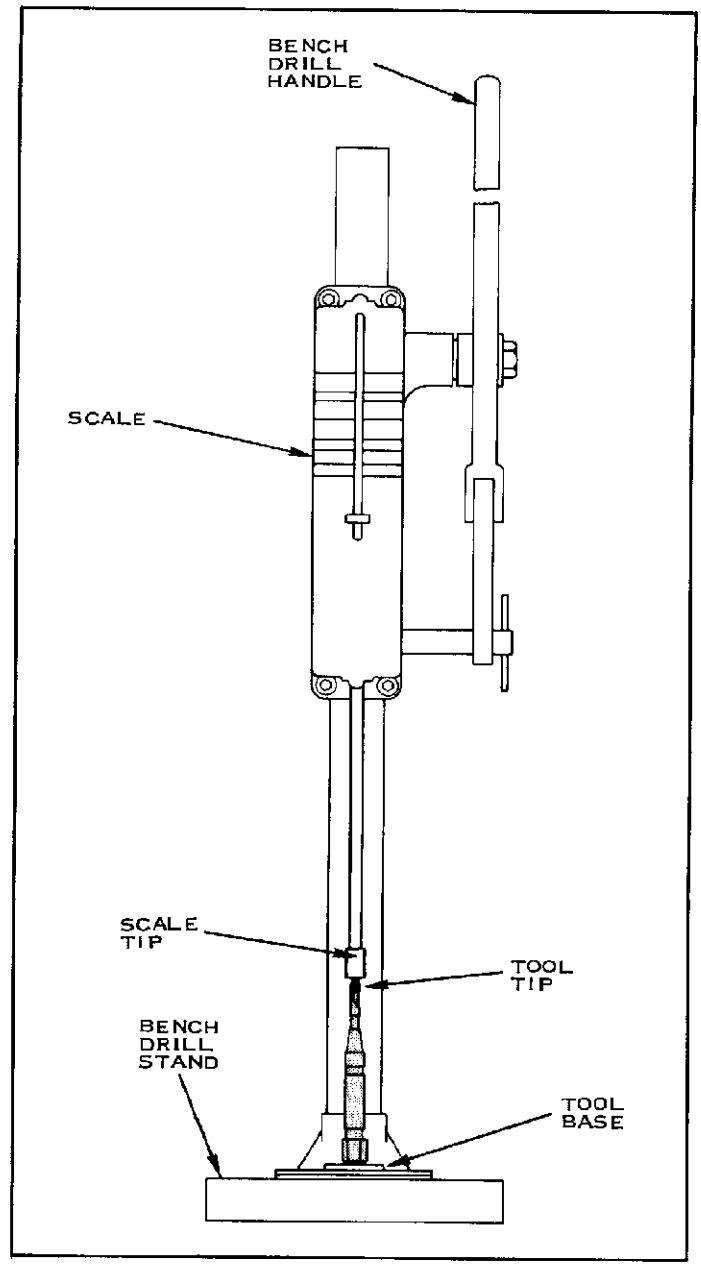

FIGURE 1

★ TRADEMARK OF AMP INCORPORATED

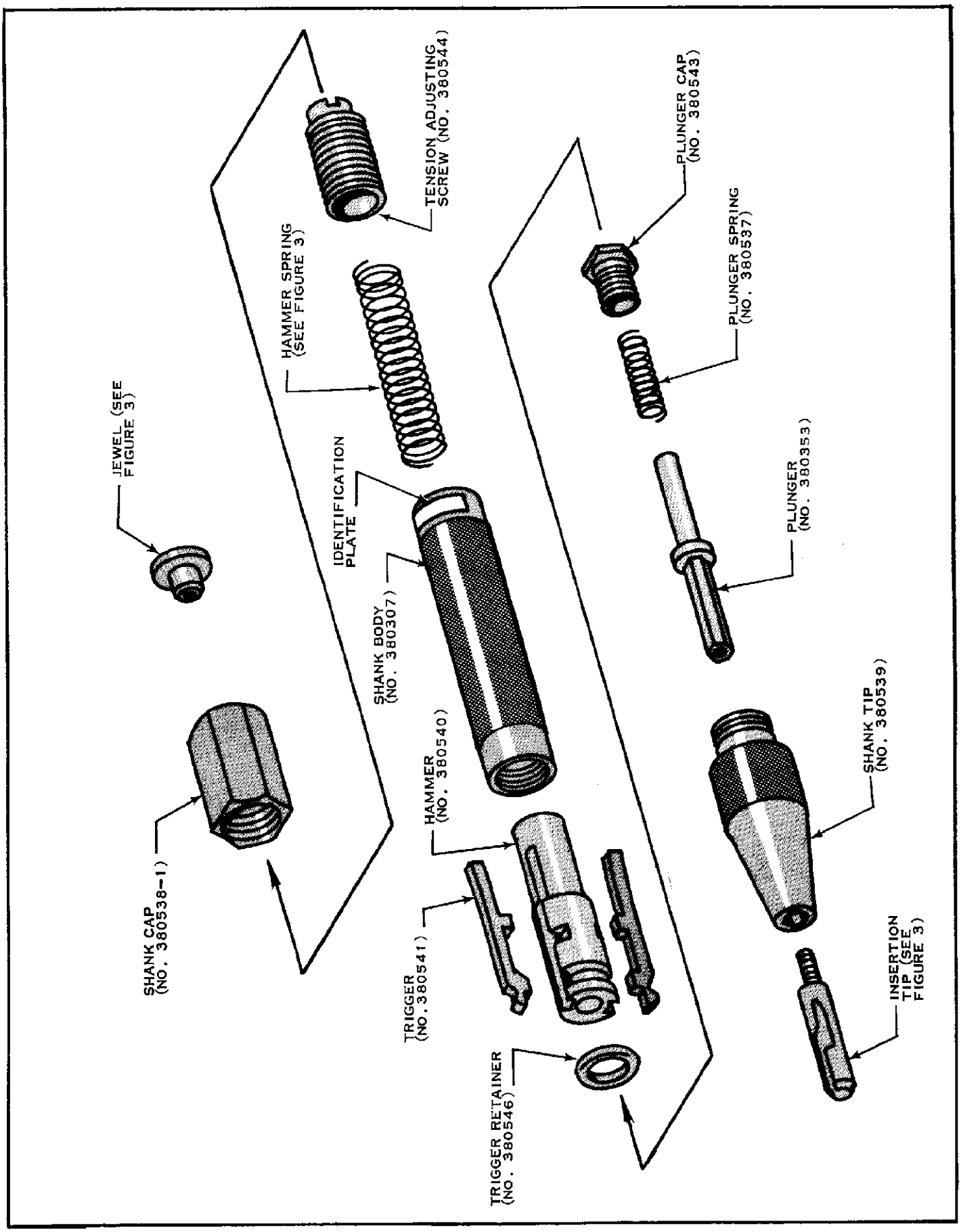
TENSION ADJUSTING SCREW (NO. 380544)
HAMMER SPRING (SEE FIGURE 3)
JEWEL (SEE FIGURE 3)
IDENTIFICATION PLATE
SHANK BODY (NO. 380307)
HAMMER (NO. 380540)
SHANK CAP (NO. 380538-1)
TRIGGER (NO. 380541)
TRIGGER RETAINER (NO. 380546)
PLUNGER CAP (NO. 380543)
PLUNGER SPRING (NO. 380537)
PLUNGER (NO. 380353)
SHANK TIP (NO. 380539)
INSERTION TIP (SEE FIGURE 3)

FIGURE 2

TOOL NUMBER	TRIP FORCE (POUNDS)	JEWEL		TIP		HAMMER SPRING NO.
		COLOR	NUMBER	NUMBER	SYMBOL	
380306-1	20-22	YELLOW	380309-4	395005	F	380308-3
380306-2	12-13	RED	380309-2	395005	F	380308-2
380306-3	12-13	RED	380309-2	395042	G	380308-2
380306-4	20-22	YELLOW	380309-4	395042	G	380308-3
380306-5	9-10	GREEN	380309-5	395005	F	380308-1
380306-6	9-10	GREEN	380309-5	395142	K	380308-1
380306-7	20-22	YELLOW	380309-4	380301-1	A1	380308-3
380306-8	16-18	BLUE	380309-6	380301-1	A1	380308-4
380306-9	12-13	RED	380309-2	380366-1	C1	380308-2
1-380306-0	9-10	GREEN	380309-5	380339-1	B1	380308-1
380392-1	20-22	YELLOW	380309-4	———	———	380308-3
380392-2	12-13	RED	380309-2	———	———	380308-2
380392-5	9-10	GREEN	380309-5	———	———	380308-1
380430-1	20-22	YELLOW	380309-4	380429-1	E1	380308-3
380430-2	12-13	RED	380309-2	380429-1	E1	380308-2
380430-3	12-13	RED	380309-2	811013-1	L1	380308-2
380430-4	20-22	YELLOW	380309-4	811013-1	L1	380308-3
465250-1	16-18	BLUE	380309-6	810980-1	R1	380308-4
802895-1	12-13	RED	380309-2	802893-1	P1	380308-2
802895-2	12-13	RED	380309-2	802893-2	P2	380308-2
802896-1	16-18	BLUE	380309-6	802894-1	N1	380308-4
811034-1	12-13	RED	380309-2	811033-1	M1	380308-2
811034-2	12-13	RED	380309-2	811033-2	M2	380308-2
811034-3	12-13	RED	380309-2	811033-3	M3	380308-2
811034-4	12-13	RED	380309-2	811033-4	M4	380308-2
811071-1	6-7	BROWN	380309-1	395042	G	380308-3
811170-1	12-13	RED	380309-2	395005-1	F1	380308-2

FIGURE 3

3. TOOL DIS-ASSEMBLY (SEE FIGURE 2)

If it is necessary to dis-assemble Tool to replace defective parts, follow the procedure below. Replacement parts may be ordered from AMP using the part numbers shown in Figures 2 and 3.

NOTE The Tip Symbol referred to in Figure 3 is stamped on the Insertion Tip and on the Identification Plate on the Shank Body along with the Tip Number. See Figure 2.

1. Clamp Shank Body in vise.
2. Remove Shank Cap, Tension Adjusting Screw and Hammer Spring from Shank Body.
3. Remove Insertion Tip and Shank Tip from Shank Body.
4. Remove Plunger Cap, Plunger Spring and Plunger from Shank Tip.
5. Take Shank Body out of vise and remove Hammer Assembly from Shank Body.
6. To remove Triggers from Hammer pry up on free end of Trigger.
7. Inspect Trigger Retainer for cuts or nicks. If it is necessary to replace Retainer, be careful not to cut or nick Retainer on edges of Retainer Groove on Hammer.
8. Before reassembling Hammer Assembly, apply a film of Texaco Regal ARO 10W Rust Resistant Oil or equivalent to Hammer and Triggers.

4. TOOL ASSEMBLY (SEE FIGURE 2)

1. Assemble Trigger Retainer and Triggers on Hammer.
2. Replace Plunger, Plunger Spring and Plunger Cap in Shank Tip.
3. Insert Hammer Assembly into Shank Body.
4. Place Shank Body in vise and assemble Shank Tip to Shank Body.

When clamping any part of Tool in vise, be careful not to close vise enough to deform part.

NOTE All threaded connections on Tool must be tightened sufficiently to prevent removal by hand.

5. Assemble Insertion Tip to Shank Tip. Using a Torque Wrench, tighten Insertion Tip with a torque of 7 inch-pounds.
6. Replace Hammer Spring and Tension Adjusting Screw in Shank Body.
7. Remove Shank Body from vise.
8. Adjust Trip Force according to Paragraph 2.
9. Tool is now ready for operation.