

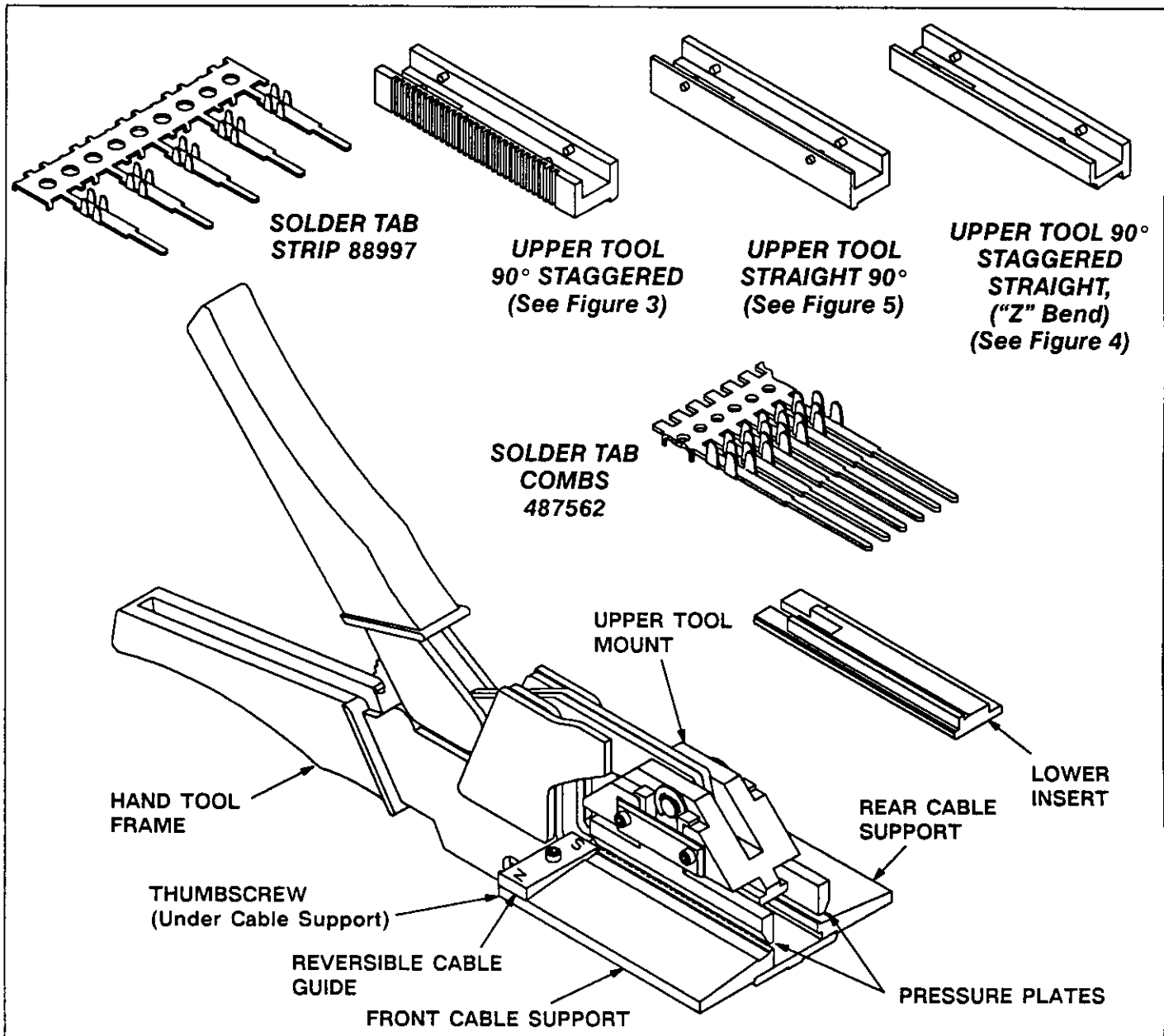
AMPAMP INCORPORATED
HARRISBURG, PA 17105AMP* HAND TOOL KIT 91292-1
FOR AMP
FFC CONTACT POSITIONING**IS 9719**CUSTOMER HOTLINE
1 800 722-1111RELEASED
7-29-91

Fig. 1

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1. INTRODUCTION

This Instruction Sheet covers the use of AMP Flexible Flat Cable (FFC) Contact Positioning Hand Tool Kit, Part Number 91292-1. The tool is designed to bend FFC solder tabs on .050 centerline cable or .100 centerline cable (refer to Application Specifications 114-16008 or 114-16015 respectively). This tool will bend either the Straight 90° (487851), the Staggered Straight ("Z" Bend, 487160), or the 90° Staggered (487153).

2. DESCRIPTION (Figure 1)

The Hand Tool consists of the following: a hand tool frame, three upper tools, one lower insert, and a bench clamp. The hand tool frame consists of the frame, two lower cable supports, two pressure plates, a cable guide, a reversible cable guide, and an upper tool mount. Each upper tool is used for one of the bending configurations. (Each tool is clearly marked.) The insert slides between the two cable supports and is used only for the "Z" bend. The bench clamp enables the

operator to use the hand tool mounted on an appropriate work bench.

3. BENCH CLAMP PROCEDURE

1. Choose a flat surface at the end of a two inch thick (maximum) work bench.
2. Place the bench stand at the end of the bench. (See Figure 2).
3. Position hand tool in the bench stand and align the mounting hole with the slot in the bench stand. Place the tool clamp through the bench stand and hand tool; then tighten clamp.

4. SETUP PROCEDURE

Determine type of cable (.050 centerline or .100 centerline) and type of bend (Straight 90°, Staggered Straight("Z" Bend), or 90° Staggered) for your application, and follow applicable procedure below:

A. .050 Centerline Cable, 90° Staggered (Figure 3)

1. Position reversible cable guide with "S" toward pressure plate, by removing thumbscrew and turning the guide to correct position, then replace thumbscrew and tighten.
2. Slide upper tool marked "staggered" onto the upper tool mount until it butts against the stabilizing bar.

NOTE

Ball plunger should snap into groove on upper tool which will retain it in position.

B. .050 Centerline Cable, "Z" Bend (Figure 4)

1. Remove reversible cable guide by loosening the thumbscrew.
2. Slide insert into lower tooling between the two cable supports until it butts against stabilizing bar.
3. Replace reversible cable guide with the "Z" toward pressure plate and tighten thumbscrew.

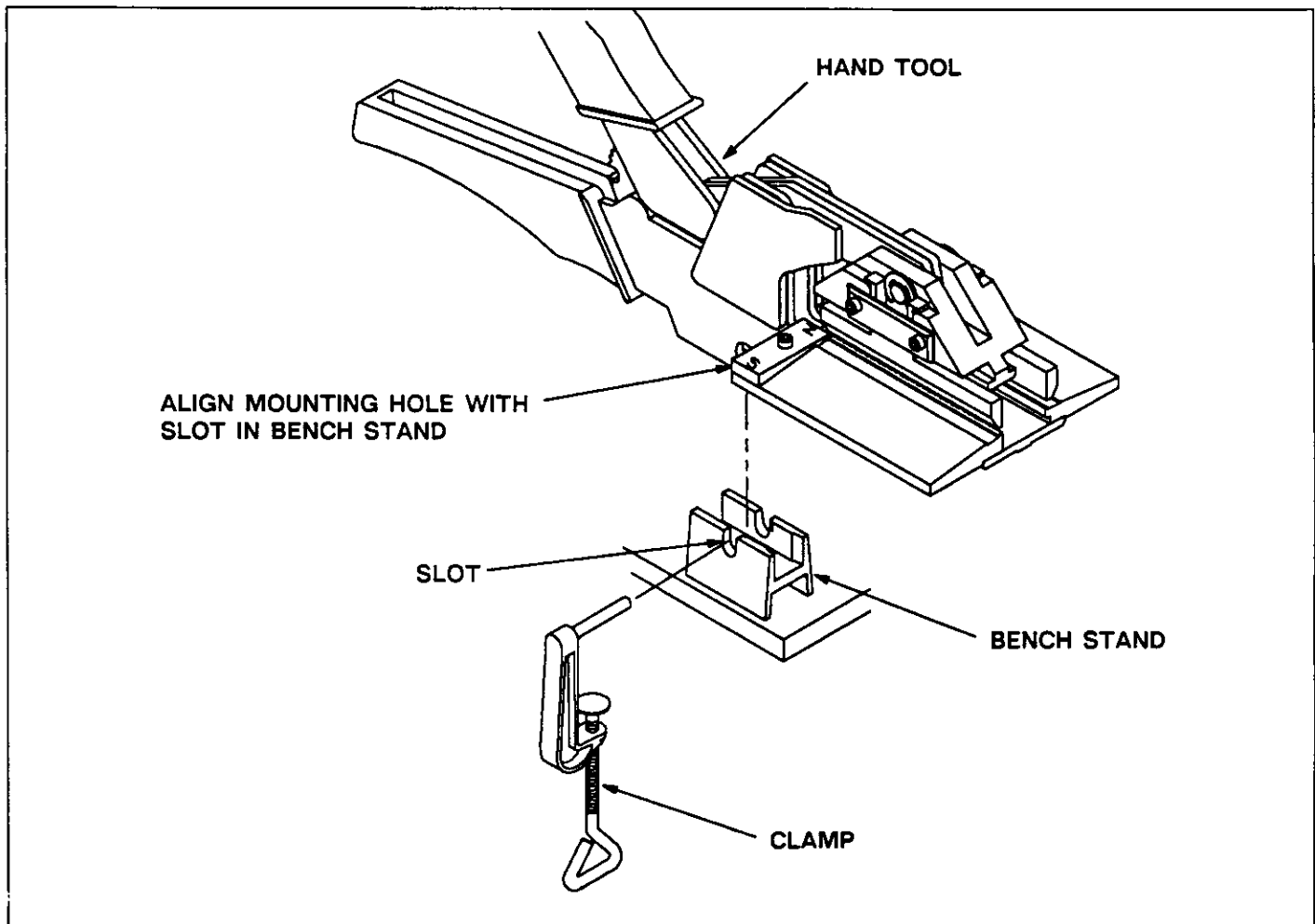


Fig. 2

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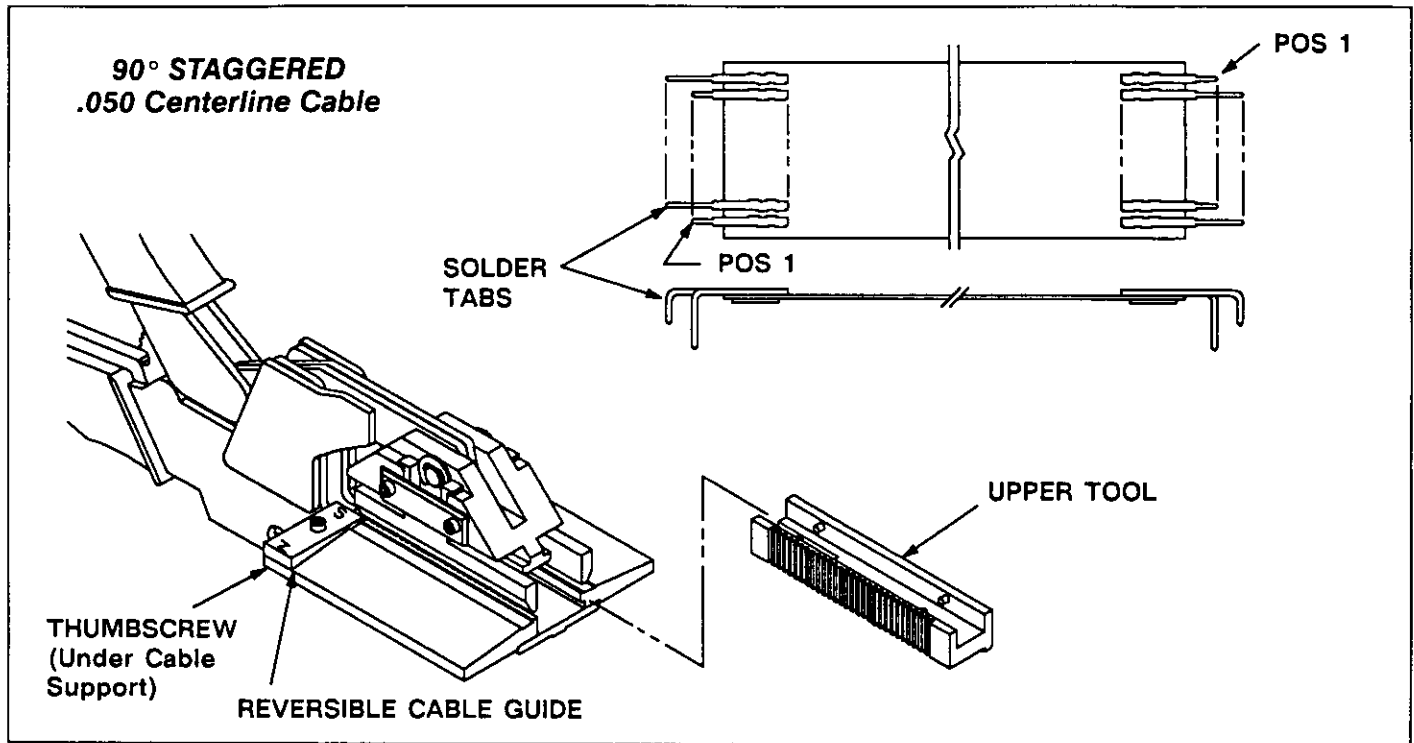


Fig. 3

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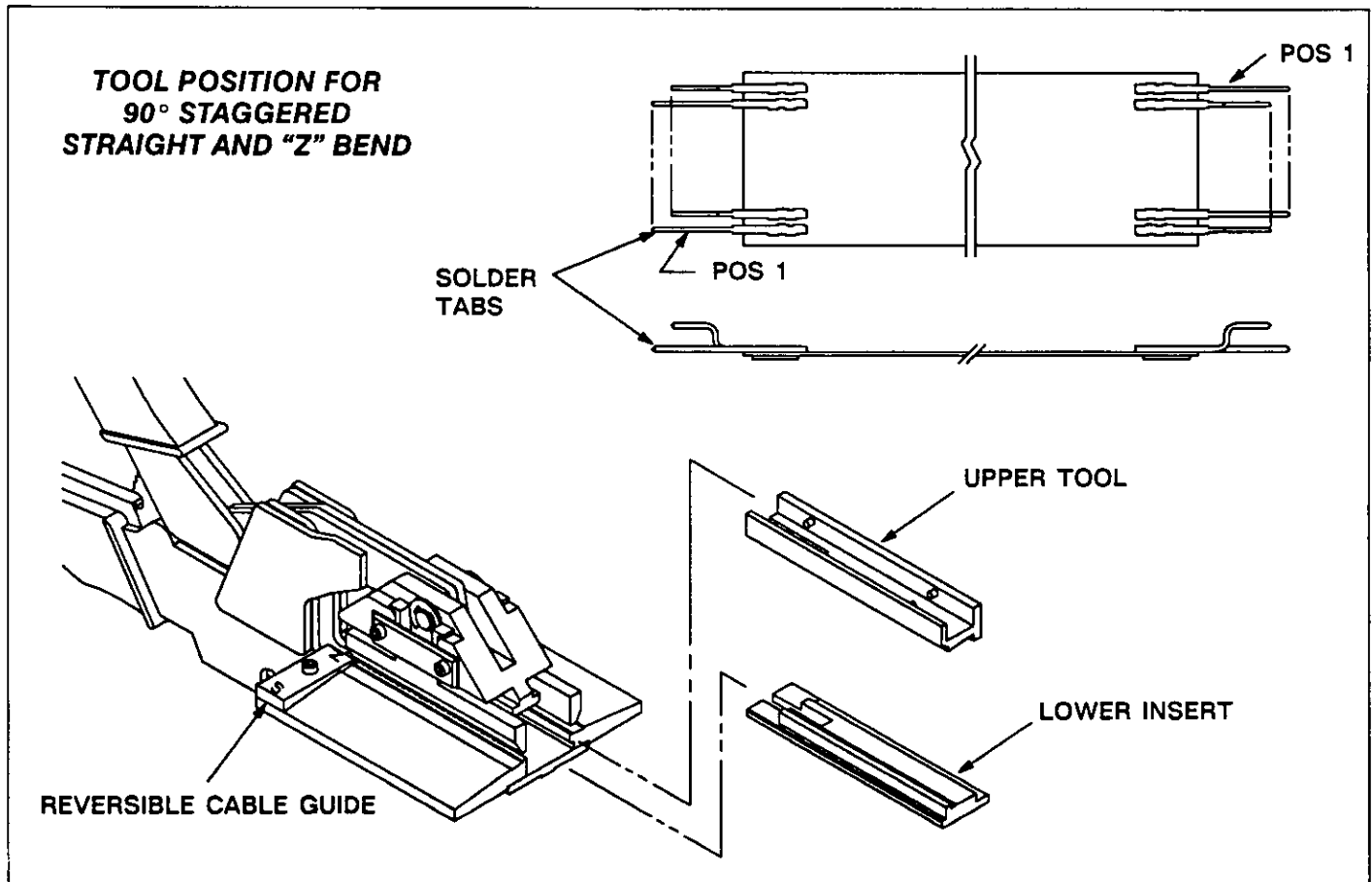


Fig. 4

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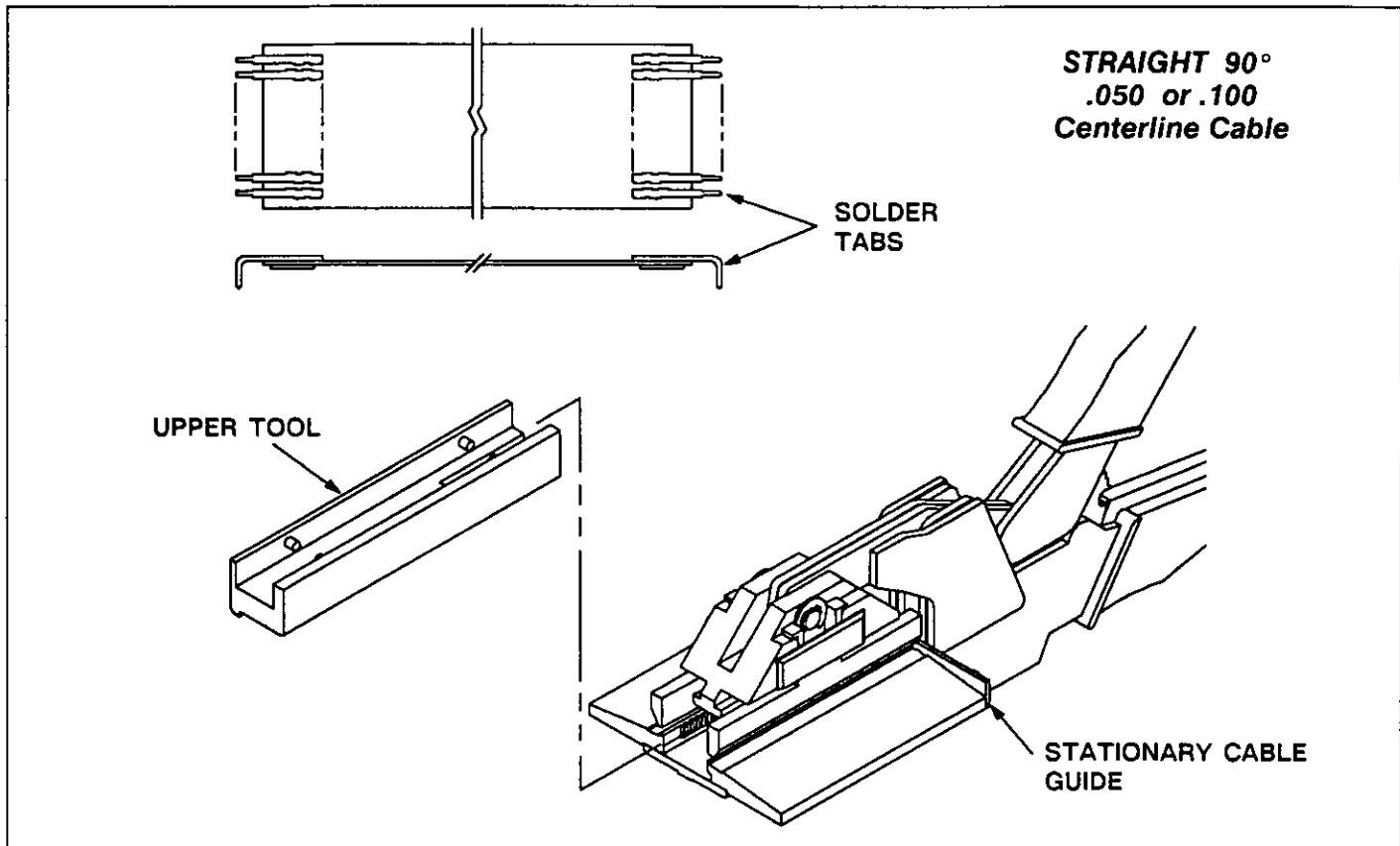


Fig. 5

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4. Slide upper tool marked with "Z" onto the upper tool mount until it butts against the stabilizing bar.

C. .050 and .100 Centerline Cable Straight 90° (Figure 5)

1. Remove any existing upper tool and insert.
2. Slide upper tool marked "straight" onto the upper mount until it butts against the stabilizing bar.

5. BENDING PROCEDURE

NOTE

Mount hand tool onto a flat surface whenever possible before beginning this procedure (refer to Paragraph 3, BENCH CLAMP PROCEDURE).

Determine type of bend and cable to be used, and follow applicable procedure below. Before beginning, be sure tool has been set up per Paragraph 4, SET UP PROCEDURE.

A. .050 Centerline Cable, 90° Staggered Straight and "Z" Bend (Figure 6)

1. Slide cable with contacts under pressure plate on the cable support with the reversible cable guide. Cable should be placed against cable guide.

NOTE

For the 90° Staggered, the crimps should face down. For the "Z" Bend, the crimps should face up.

2. Slide cable against cable guide until end of cable butts against step on cable guide.
3. Hold cable firmly in place with hand and cycle hand tool.
4. Remove cable with contacts bent per application.

NOTE

When removing cable, push cable in toward the center of the tool and then slide out.

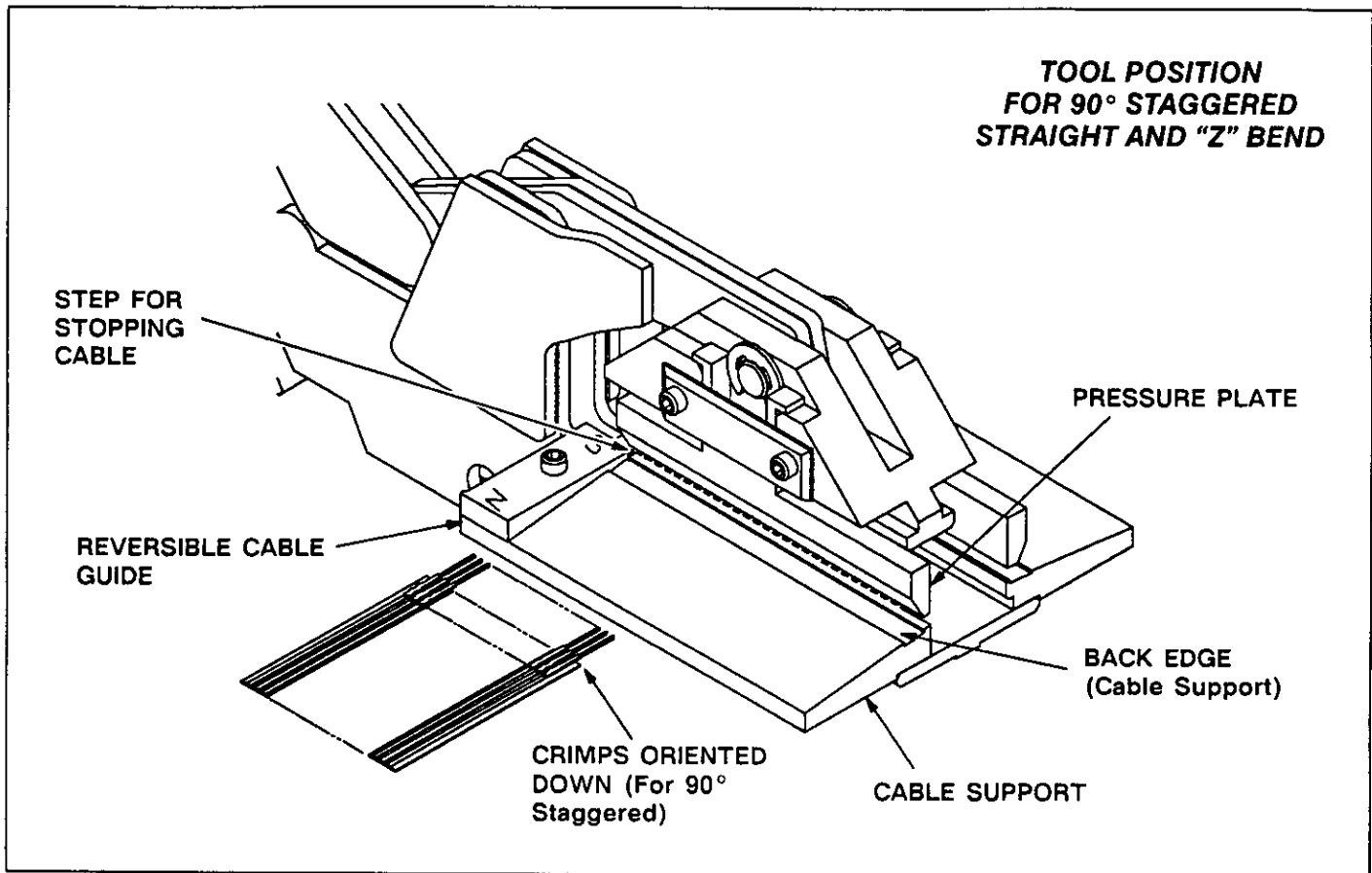


Fig. 6

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B. .050 Centerline Cable, Straight 90° (Figure 7)

C. .100 Centerline Cable, Straight 90° (Figure 7)

NOTE

This bend is done by using the opposite side of the tool, and the operator may choose to loosen the bench clamp and rotate the tool 180° on the work bench.

NOTE

This type of bend uses the same side of the tool as the .050 Centerline Cable, Straight 90° bend.

1. Position cable on cable support opposite the one with the reversible cable guide and approximately in the center of the tool (crimps oriented down).
2. Slide cable with contacts under pressure plate until crimped area of contacts passes the recessed area on the cable support.
3. With light pressure on the cable, slide the cable back out until the crimps catch on the back edge of the recessed area of the cable support. (This should force the cable perpendicular to the bending edge).
4. Hold cable firmly in place and cycle hand tool.
5. Remove cable from hand tool by sliding it out the front of the tool.

1. Place cable on cable support against cable guide and slide forward under pressure plate (crimps oriented down).
2. Continue sliding cable until end of cable butts against stop on cable guide. Be sure it butts against the step on cable guide and is not catching on the recessed area of the cable support.
3. Hold cable firmly in place and cycle hand tool.
4. Remove cable from hand tool by sliding it out the front of the tool.

6. DAILY MAINTENANCE

It is recommended that each user of the tool be made aware of, and responsible for, the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean brush or soft, lint-free cloth.

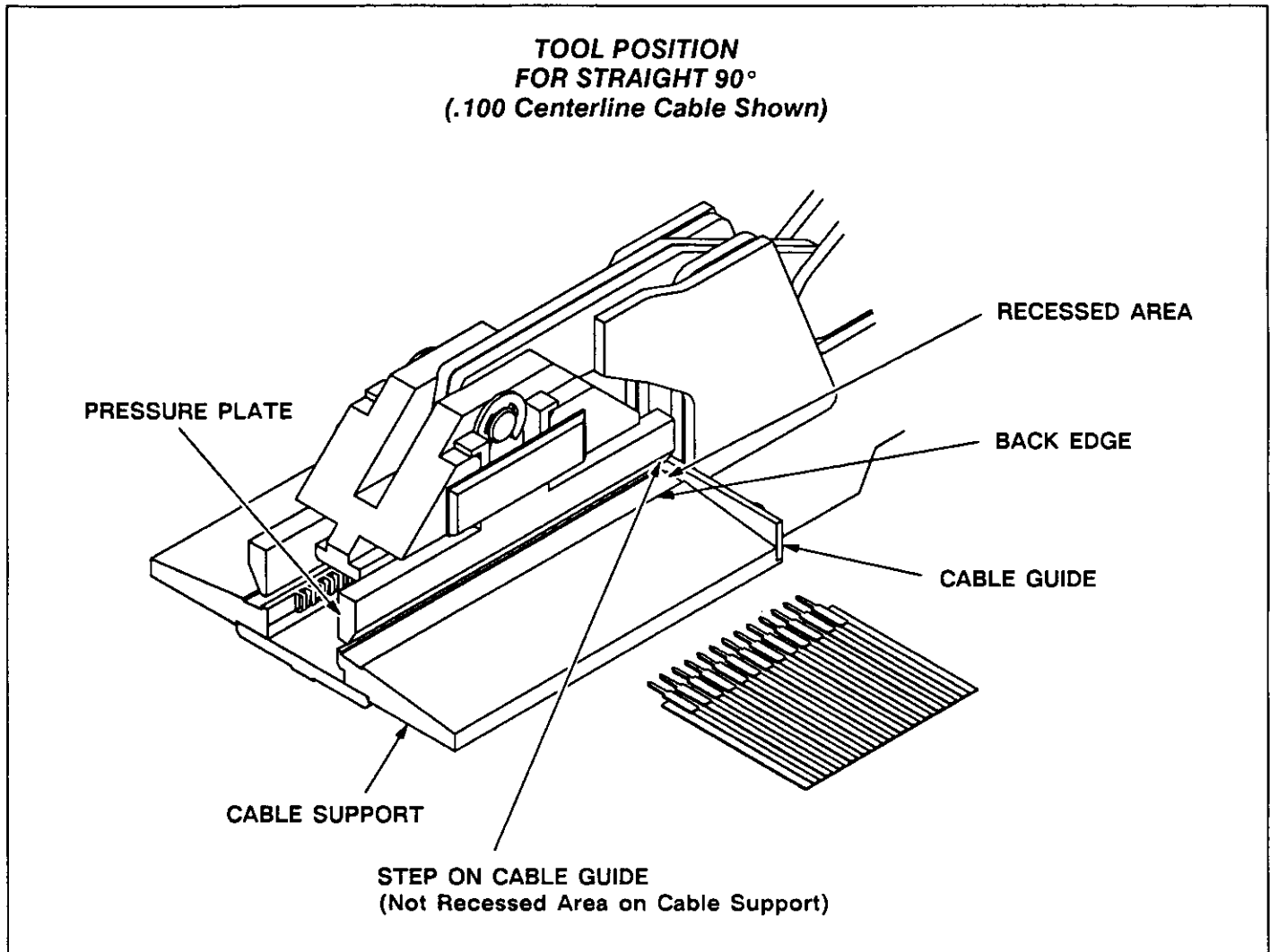


Fig. 7

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2. Lubricate pivot points with a light oil or grease. Do NOT oil excessively.

3. When tool is not in use, store in a clean, dry area.

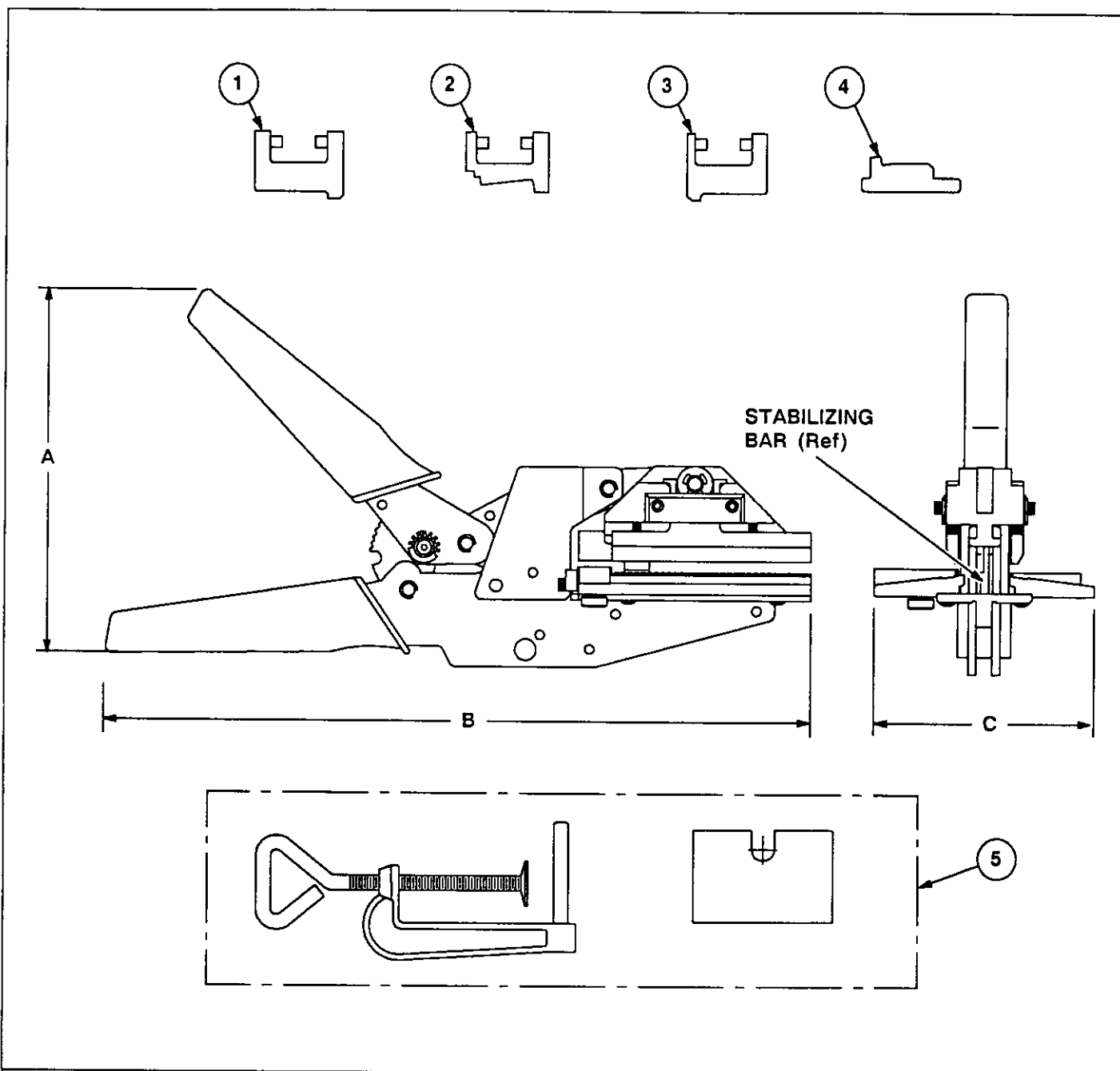
and at regularly scheduled intervals, to ensure that the tool has not been damaged during handling and use.

A complete inventory of the customer-replaceable parts listed in Figure 8 should be stocked for immediate replacement. Replacement parts can be ordered from:

7. TOOL INSPECTION AND REPAIR

AMP FFC Hand Tool Kit 91292-1 has been inspected before shipment. AMP recommends that the tool be inspected immediately upon its arrival at your facility,

CUSTOMER SERVICE (038-035)
AMP INCORPORATED
P. O. BOX 3608
HARRISBURG, PA 17105-3608



REPLACEMENT PARTS				TOOL SPECIFICATION		
ITEM	PART NUMBER	DESCRIPTION	QTY	DIMENSIONS		WEIGHT
1	543470-1	UPPER TOOL, Staggered	1	A	5.70	3 lbs, 8 oz
2	543471-1	UPPER TOOL, "Z" Bend	1	B	10.60	
3	543479-1	UPPER TOOL, Straight, Rt. Angle	1	C	3.32	
4	543472-1	LOWER INSERT	1			
5	543264-1	KIT, Bench Clamp	1			

Fig. 8

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