

Figure 1

1. INTRODUCTION

Cover Closing Kit 543518-1 is used to terminate AMPMODU 50/50 grid IDC connectors onto a variety of ribbon cable. The tooling must be installed in Manual Miniature Application Frame Assembly 91295-1 (refer to 408-9817 for operation instructions).

The connectors are available in various sizes and styles of receptacles ranging from 10 to 100 positions in increments of 10 positions. Refer to Application Specification 114-7010 for detailed description of the connectors and cable.

NOTE



All dimensions on this document are in metric units [with U. S. customary units in brackets].

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

The cover closing kit consists of an upper tool and a lower tooling assembly. Two termination covers assist in locating the wire over the insulation displacement contacts of the connector.

3. SET UP

Refer to 408-9817 and set the shut height of frame assembly to 47.63 mm [1.875 in.]. Then, proceed with following.

1. Push the upper tool into the ram tooling adapter of the frame assembly. See Figure 2.
2. Locate the lower tool assembly by inserting its locating pins into the holes in the machined base of the frame assembly. Make sure the inscription "CENTER CONNECTOR" is facing the front of the frame assembly. See Figure 3.
3. Assemble the termination covers onto the connector, and close them partially by hand. Then install the cable.

NOTE



If using round-to-flat cable or flat ribbon cable, insert the cable between the covers and contacts and pre-close the covers by hand, clamping the cable in place.

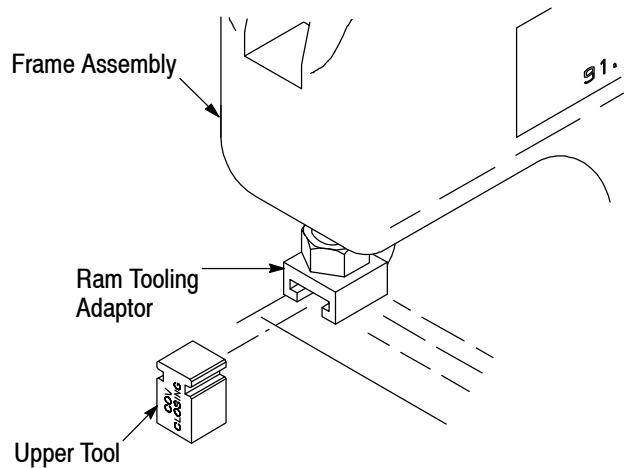


Figure 2

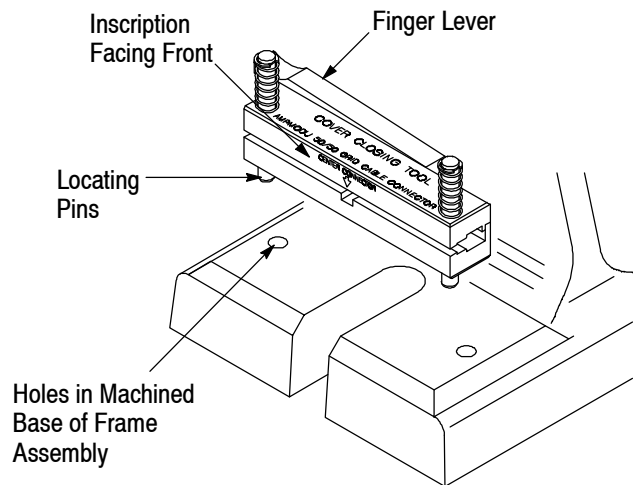
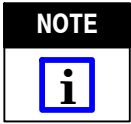


Figure 3

4. Depress the finger lever and insert the connector (centered) into the lower tool assembly between the upper and lower bars. See Figure 4. The connector is properly located if the upper and lower termination covers rest on the "A" and "B" surfaces, the front of the connector is against the "C" surface of the inside of the lower tool assembly, and the connector metal latch or polarization feature is facing down.



In order to ensure proper termination, the connector must remain horizontal.



It might be required to support the cable extending beyond the cover closing tool.

5. Grasp the frame assembly handle and pull it down with a steady firm pressure—the upper tool will touch the upper bar of the lower tool assembly with added firm pressure. The downward

movement of the handle is completed when the upper tool bottoms completely.

4. REPLACEMENT

Order additional cover closing kits through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
 TYCO ELECTRONICS CORPORATION
 PO BOX 3608
 HARRISBURG PA 17105-3608

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Modified Section 1
- Modified Step 3 of Section 3

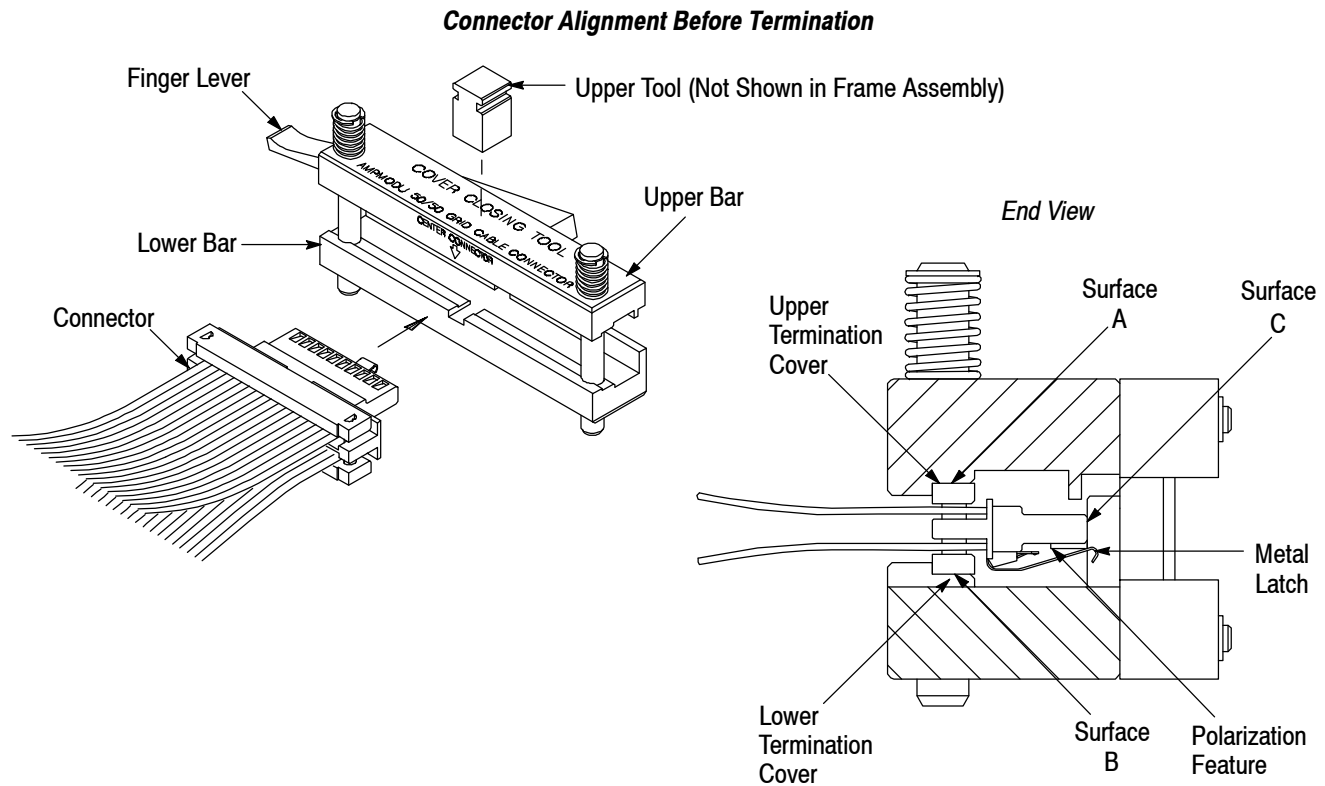


Figure 4