

Fig. 1

1. INTRODUCTION

This instruction sheet covers the use of the AMP Insertion Tool 91042-1 which is designed to insert Type XI, Size 20 Pin and Socket Contacts (203874 and 203875) into AMP High Density Rectangular (HDR) Connectors. Read these instructions carefully before using the tool.

NOTE

All dimensions presented on this instruction sheet are in inches, unless otherwise stated.

2. DESCRIPTION (Figure 1)

This tweezer-shaped tool features two serrated insertion tips for grasping the wire connected to the con-

tact, and two tool handles which assist in applying even pressure to the insertion tips.

3. INSERTION PROCEDURES (Figure 1)

Insert the contact as follows:

1. Place the insertion tool over the wire, with the tool insertion tips behind the contact insulation barrel.
2. Insert the contact into the connector cavity until the locking lance on the contact is fully seated.
3. Remove the insertion tool tip from the connector cavity. Pull back lightly on the wire to make sure the contact is locked in place.

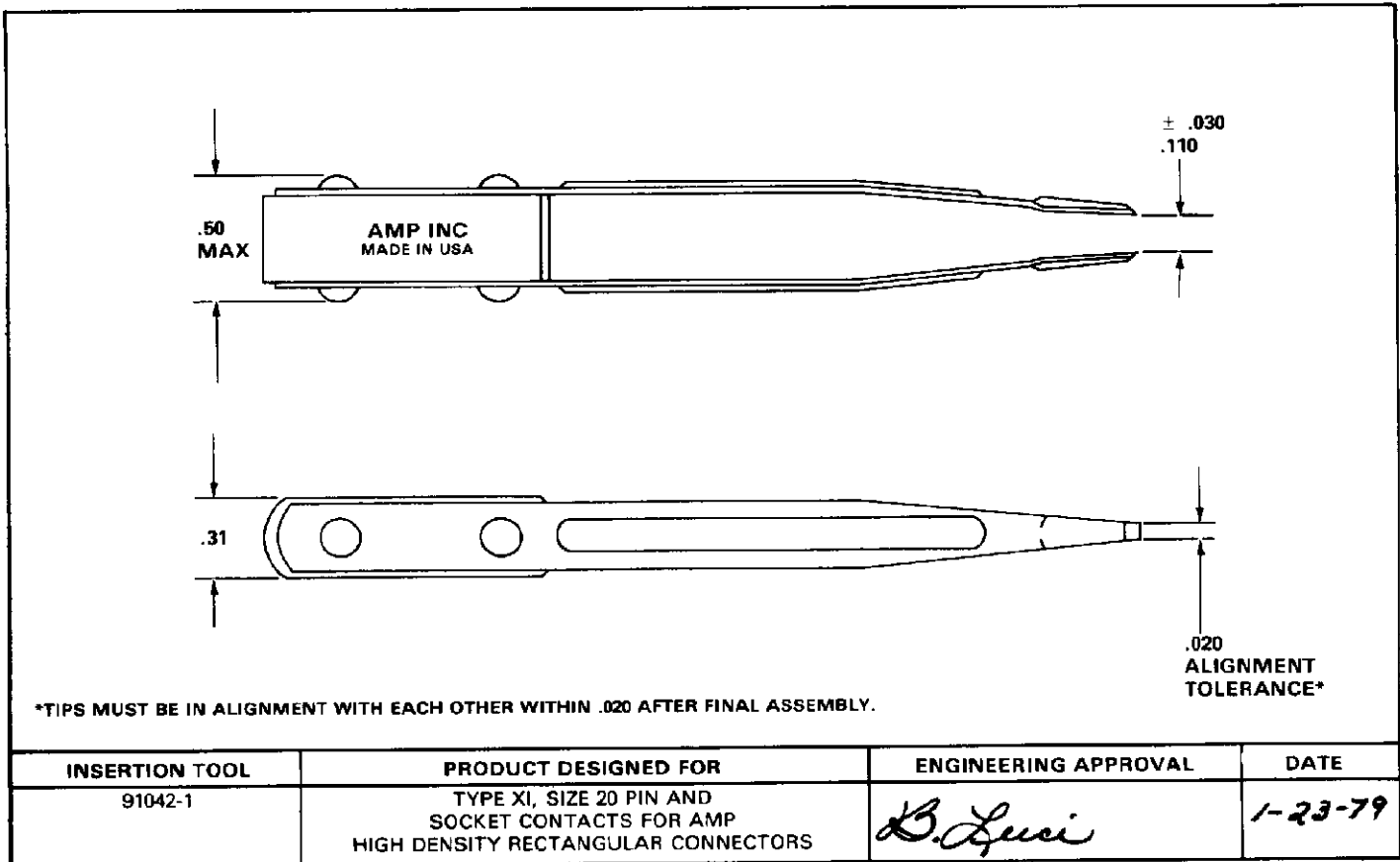


Fig. 2

4. TOOL CERTIFICATION

The tool listed in this instruction sheet should be certified with the information provided in Figure 2.

We recommend that you inspect the tool immediately upon arrival in your factory, and at regularly sched-

uled intervals, to ensure that the tool has not been damaged during handling.

Additional tools can be purchased from:

AMP Incorporated
 Eisenhower Boulevard
 Harrisburg, Pennsylvania 17105