

Fig. 1

**1. INTRODUCTION**

This instruction sheet (IS) covers the use of the AMP Insertion Tool 274448-1 which inserts AMP loose-piece Quadra-Mate 100 Series Terminals listed in Figure 1 into pc boards. The tool is also used to insert tin-plated copper wire into the already inserted terminal. Read these instructions carefully before inserting any terminals into the pc boards.

**NOTE**

All dimensions presented on this instruction sheet are in inches.

**2. DESCRIPTION**

The insertion tool features a grooved handle and a steel-lined insertion tip. The insertion tip is notched to

accept and to retain the terminal (inset) for insertion into the pc board. The tip is also grooved to push the wire into the terminal using the *insulation displacement* termination technique.

**3. INSERTION PROCEDURE**

Arrange a hole pattern for pc board according to layout in Figure 2, then insert terminal as follows (Figure 1):

1. Place relieved plate or rubber mat (1/16 in. thick) under pc board.
2. Place terminal into insertion tip of tool.
3. Insert terminal firmly into hole of pc board as shown and withdraw tool.

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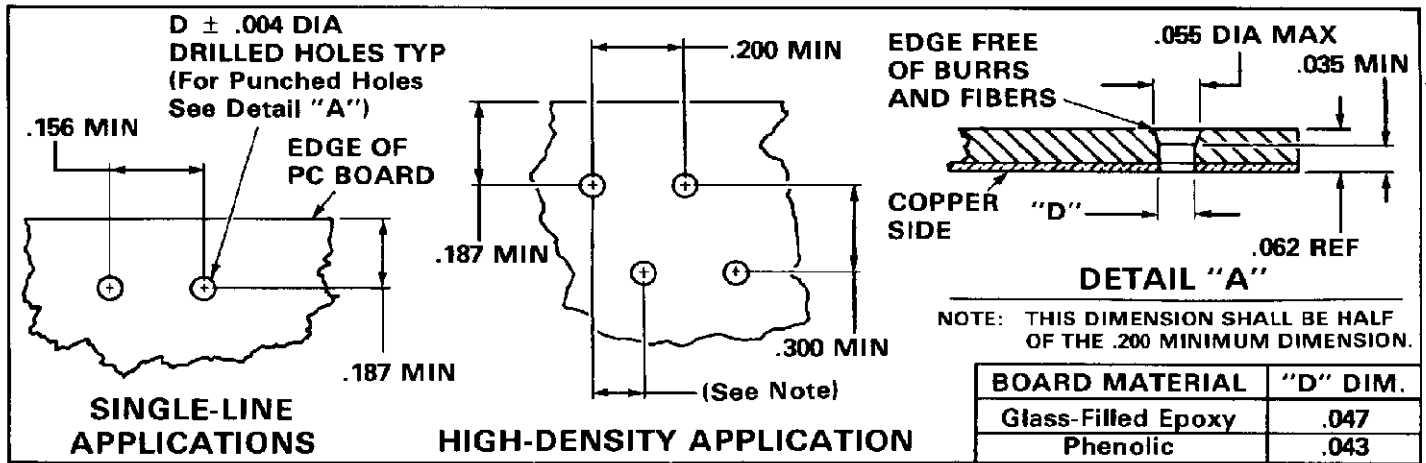


Fig. 2

Insert wire into terminal as follows (Figure 3):

4. Place wire in terminal, aligning wire with insulation displacement slot of terminal.
5. Align groove of tool insertion tip with wire and press tool firmly on wire into slot of terminal until tool bottoms.
6. Remove insertion tool from terminal.

**4. TOOL CERTIFICATION**

The tool listed in this instruction sheet should be certified with the information provided in Figure 4.

We recommend that you inspect the tool immediately upon arrival in your factory, and at regularly scheduled intervals, to ensure that the tool has not been damaged.

Additional tools can be purchased from:

AMP Incorporated  
 Eisenhower Boulevard  
 Harrisburg, PA 17102

**NOTE**

For additional product information, refer to AMP Application Specification 114-2051.

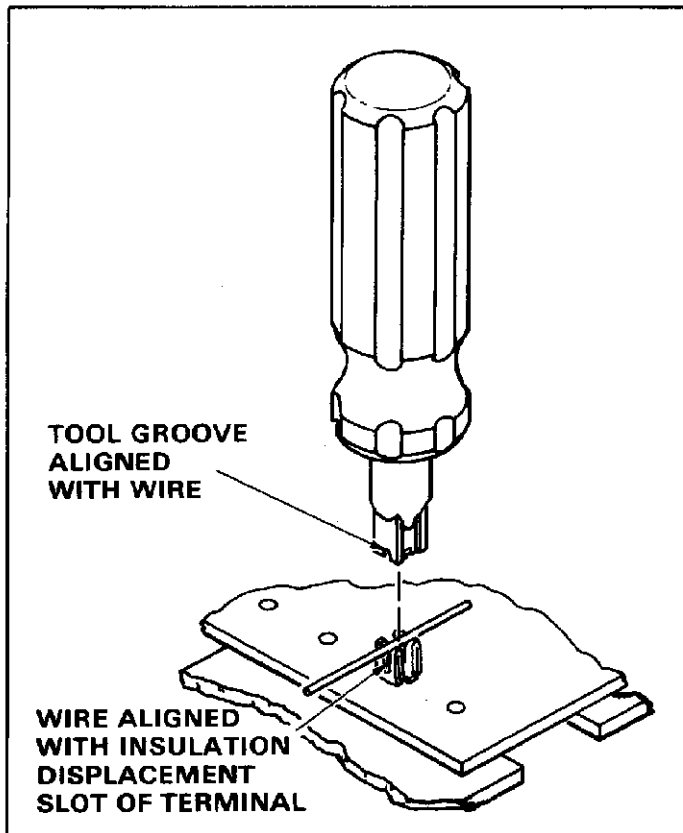


Fig. 3

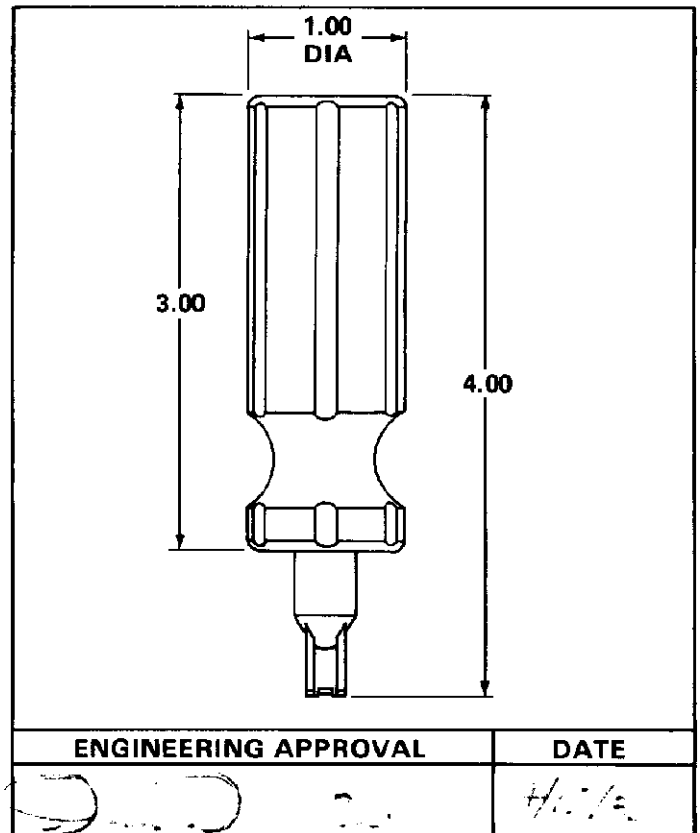


Fig. 4