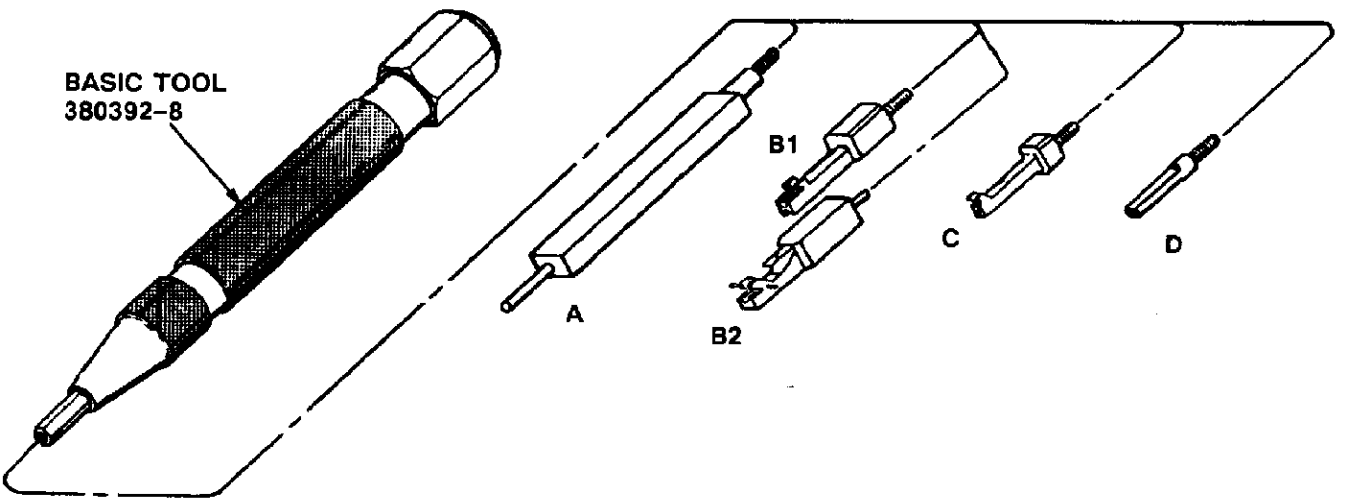
AMP INCORPORATED
HARRISBURG, PA 17105

CUSTOMER HOTLINE
1 800 722-1111

AMP* CONTACT REPLACEMENT TOOL 265871-[ ] FOR ACTION PIN* CONTACTS

IS 2636

RELEASED
9-4-90



TYPE	PART NUMBER	DESCRIPTION	PRODUCT APPLICATION	NOTE
A	265964-1	Removal	.025² Posts	—
B1	308556-[ ]	Replacement	Stacking ZIF	1
B2	310759-[ ]	Replacement	ECONOMATE* I, ZIF Card Edge, AMP PACE*	2
C	308555-1	Replacement	ECONOMATE II	1
D	308554-[ ]	Replacement	Feed-Through Posts, AMP-HDI*, Eurocard, AMPMODU* Connectors	1

1 Tip can be used to remove and install contact.
2 Tip can be used only to install contact.

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the removal and insertion of ACTION PIN contacts with Contact Replacement Tool 265871-[ ]. Each tool kit consists of the following:

- Basic CERTI-LOK* Tool 380392-8.
- Contact Removal Tip 265964-1 (supplied with all tools except 2-265871-1).
- The Contact Replacement Tip corresponding to the contact to be replaced.

This sheet describes the use of the various tips. Be sure to use the proper section of the sheet for your application.

NOTE

Do NOT re-use any ACTION PIN contacts that have been removed from a board or panel.

NOTE

All dimensions on this sheet are in inches. Figures and illustrations are for identification only and are not drawn to scale.

2. DESCRIPTION

The tools are used to remove ACTION PIN contacts from panels or printed circuit (pc) boards. Figure 1 shows the basic tool and the available tips. Figure 2 lists the tool number, the replacement tip included in the tool, and the product used with the tool.

Any tip listed in Figure 2 can be used with the basic tool. Since each tip is designed for a specific contact, make sure the tip in use is compatible with the contact being replaced.

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Replacement tips for the tool are available. For Removal Tip 265964-1, the ram subassembly can be replaced instead of replacing the entire tip. Refer to Section 9, REPAIR.

Additional information on CERTI-LOK Tool 380392-8 is provided in AMP Instruction Sheet IS 2636-1, which is packaged with the tool.

CAUTION *Before using the tool, make sure that the tool tip is securely screwed to the base tool.*

TOOL PART NUMBER	TIP PART NUMBER	TIP TYPE	CONTACT BASE PN	PRODUCT APPLICATION
265871-7	308554-1	D	117249 117272 117269	ECONOMATE I Connector Feed-Through Posts
			532538	Eurocard Connectors
			532420 532421	AMP-HDI Connectors
			--	AMPMODU Connectors
265871-8	308554-1	D	118721	ECONOMATE II Receptacle Connectors
	308555-1	C	119272	
1-265871-1	308556-6	B1	117880	Stacking ZIF
1-265871-7	265964-1	A	--	Removal Tool for all .025² Posts
2-265871-1	308554-6	D	117311 118243	Feed Through Posts, .025², Center Carrier
2-265871-2	310759-1	B2	117285 117795 118778	ECONOMATE I Low-Profile Connectors, .100 x .200; .156 x .200
2-265871-4	310759-3	B2	117794	ECONOMATE I Low-Profile Connectors, .125 x .250
2-265871-5	310759-4	B2	117793	ECONOMATE I Low-Profile Connectors, .125 x .125
2-265871-6	310759-5	B2	118915	ECONOMATE I High-Profile Connectors, .125 x .125
			119355	AMP PACE Connectors, .125 x .125
3-265871-1	310759-8	B2	119715	AMP PACE Connectors, .100 x .200
3-265871-2	1-310759-0	B2	119196	ZIF Card-Edge Connectors, .100 x .100
3-265871-3	310759-9	B2	119712	AMP PACE Connectors, .125 x .250

NOTE *All tools are packaged with Contact Removal Tip 265964-1. Except for AMP PACE connectors, listed contact part numbers are for reeled product. Contacts are also available in combs. Contact you AMP Representative about comb part numbers. AMP PACE contact part numbers are for combs of 25 contacts.*

Fig. 2

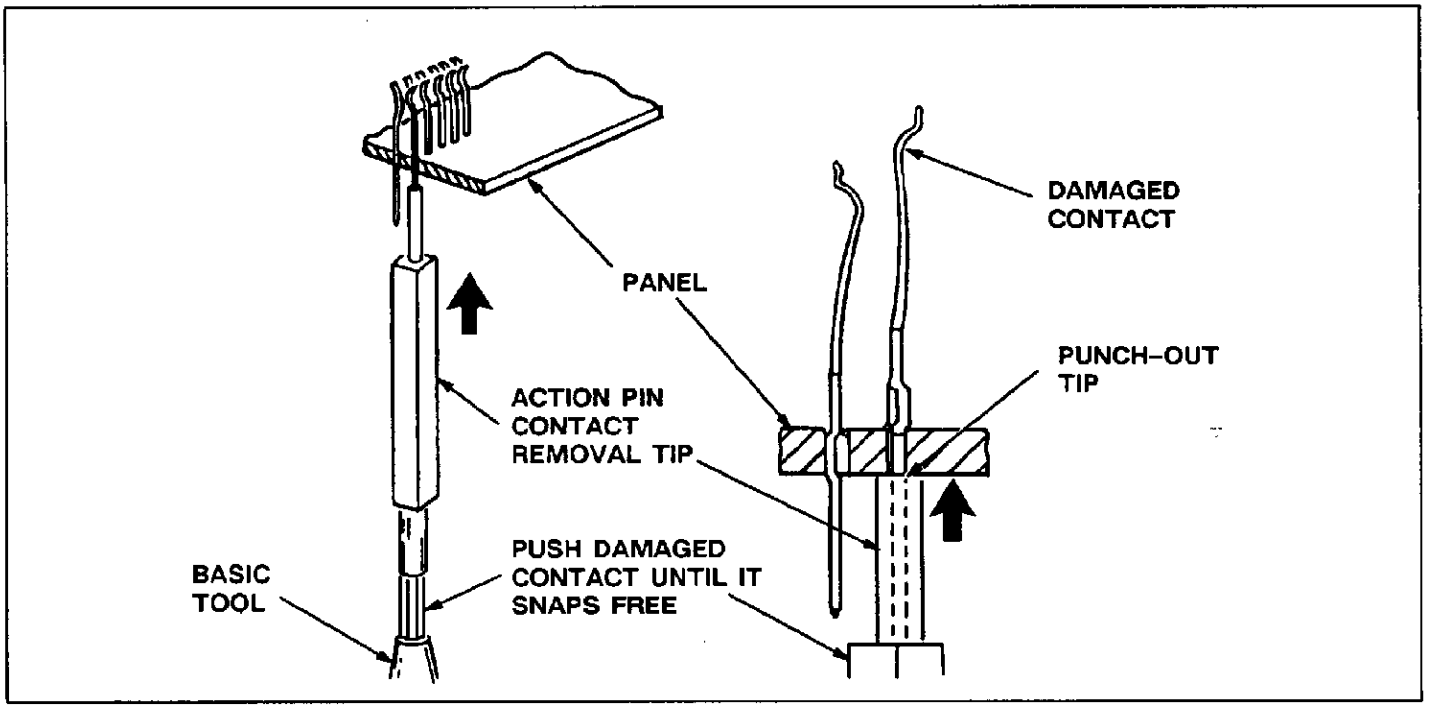


Fig. 3

3. CONTACT REMOVAL WITH TIP 265964-1 (Figures 3 and 4)

NOTE

If the contact has been soldered to the panel, pin removal requires the use of a soldering iron along with the removal tool. Hold the hot iron against the pin, NOT against the panel. After the pin has been removed, use a No. 62 drill bit (.038-in diameter) to clean and size the hole. Do NOT re-use the contact.

If the contact is accessible through the top of the housing, the housing does not need to be removed to replace the contact. Insert a pc board into the slot of the housing to hold the contact in position for removal (otherwise the contact may jam into the center of the housing). After the contact snaps free, use a hemostat to remove the contact from the housing. Refer to Figure 4.

This tip (type A in Figure 1) removes any ACTION PIN contact with a .025[2] post. To remove the contact:

1. Screw the removal tip onto the end of the basic tool.
2. If necessary, insert a pc board into the housing to hold the contact in the proper removal position.
3. Locate the tool tip over the post and push the tool until the contact snaps free.
4. Use the proper replacement tip to insert a new contact.

4. ECONOMATE CONTACT REPLACEMENT (Figure 5)

NOTE

If the housing is not removed, assemble the replacement contact into the housing and seat the contact using Tool 266178-[ ] or 266220-[ ].

1. Screw the proper replacement tip onto the basic tool.

NOTE

If tip B2 is provided, the contact must first be removed with the removal tip (tip A).

2. Locate the tool over the contact post and push the tool until the contact snaps free.
3. Remove and discard the damaged contact.
4. Start the new contact into the hole. Make sure that the contact is properly aligned with the installed contacts.
5. Fit the tool over the contact so that the contact push shoulder is positioned under the push hooks of the tip, the pushout notch in the center of the contact push shoulder rests in the notch of the replacement tip, and the contact is

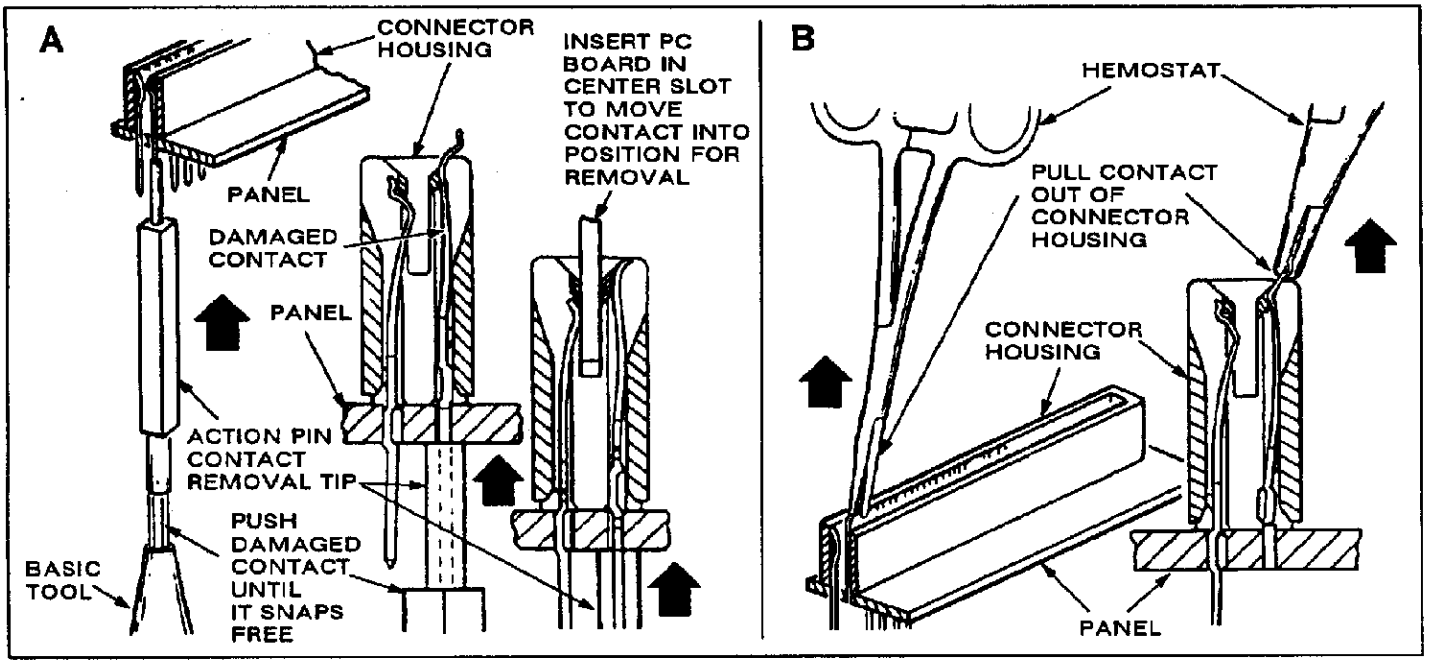


Fig. 4

properly aligned with the others in the row. Apply force straight downward until the contact push shoulder bottoms on the panel or pc board.

5. ECONOMATE II CONTACT REPLACEMENT (Figure 6)

1. Screw the proper replacement tip onto the basic tool.
2. Fit the hole in the replacement tip over the post of the contact and apply pressure straight upward until the contact snaps free.
3. Remove and discard the damaged contact.
4. Start the new contact into the hole.
5. Fit the tool over the contact so that the push shoulder is positioned under the push hooks of the tip and the top of the contact is aligned with the other contacts in the row. Apply force straight downward until the push shoulder on the contact bottoms on the panel or pc board.

6. FEED-THROUGH POST REPLACEMENT (Figure 7)

Feed-through posts can normally be removed with the proper replacement tip (type D in Figure 1). If the post has been broken off near the surface of the panel, it may be necessary to use the removal tool as described in Section 3.

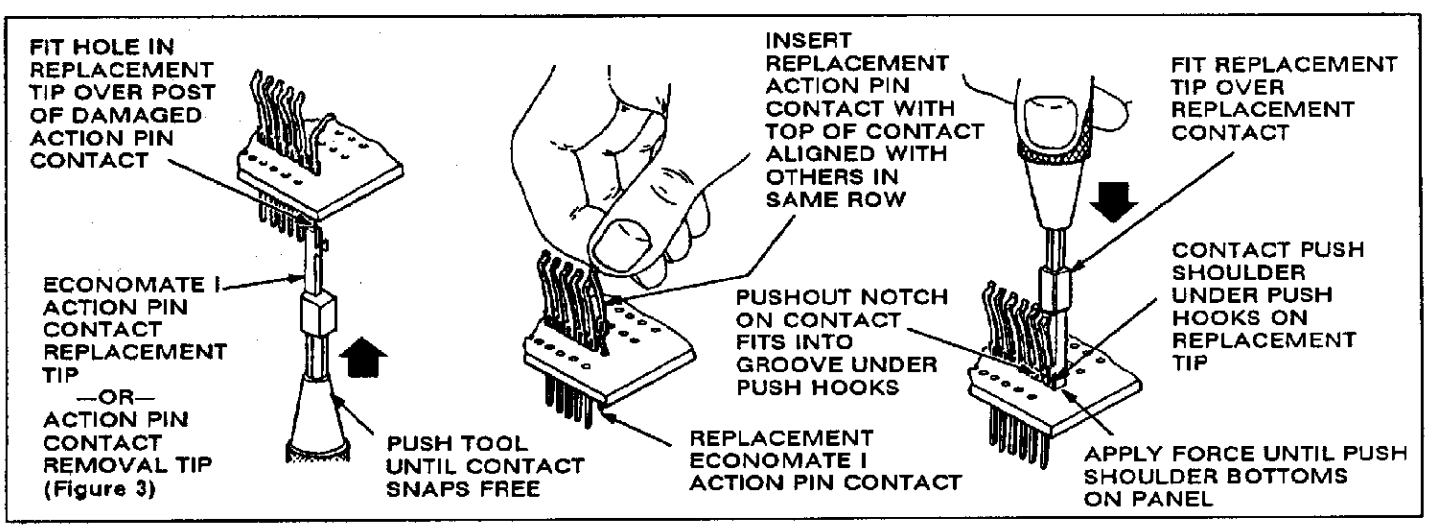


Fig. 5

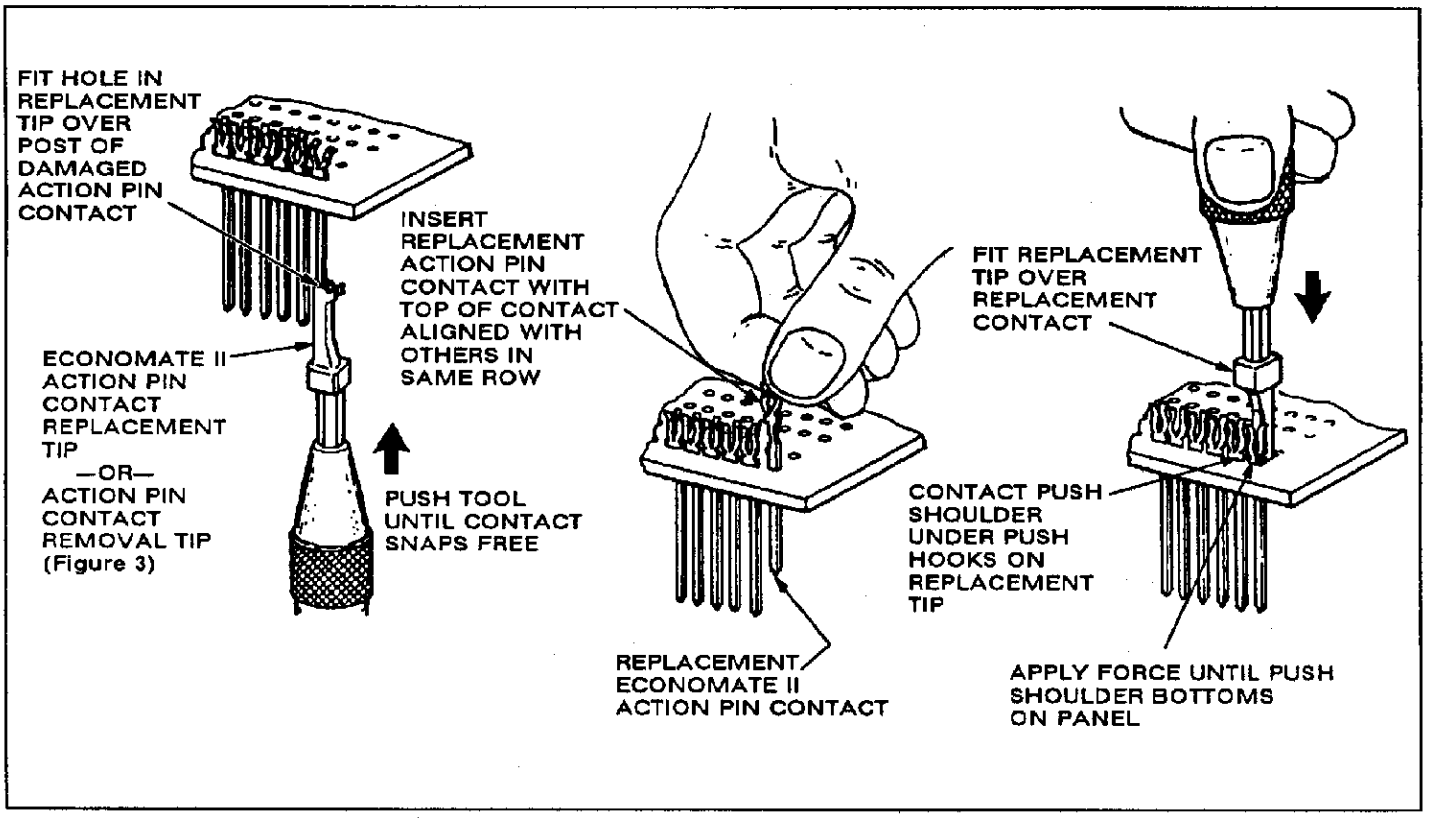

FIT HOLE IN REPLACEMENT TIP OVER POST OF DAMAGED ACTION PIN CONTACT
ECONOMATE II ACTION PIN CONTACT REPLACEMENT TIP
—OR—
ACTION PIN CONTACT REMOVAL TIP (Figure 3)
INSERT REPLACEMENT ACTION PIN CONTACT WITH TOP OF CONTACT ALIGNED WITH OTHERS IN SAME ROW
PUSH TOOL UNTIL CONTACT SNAPS FREE
REPLACEMENT ECONOMATE II ACTION PIN CONTACT
FIT REPLACEMENT TIP OVER REPLACEMENT CONTACT
CONTACT PUSH SHOULDER UNDER PUSH HOOKS ON REPLACEMENT TIP
APPLY FORCE UNTIL PUSH SHOULDER BOTTOMS ON PANEL

Fig. 6

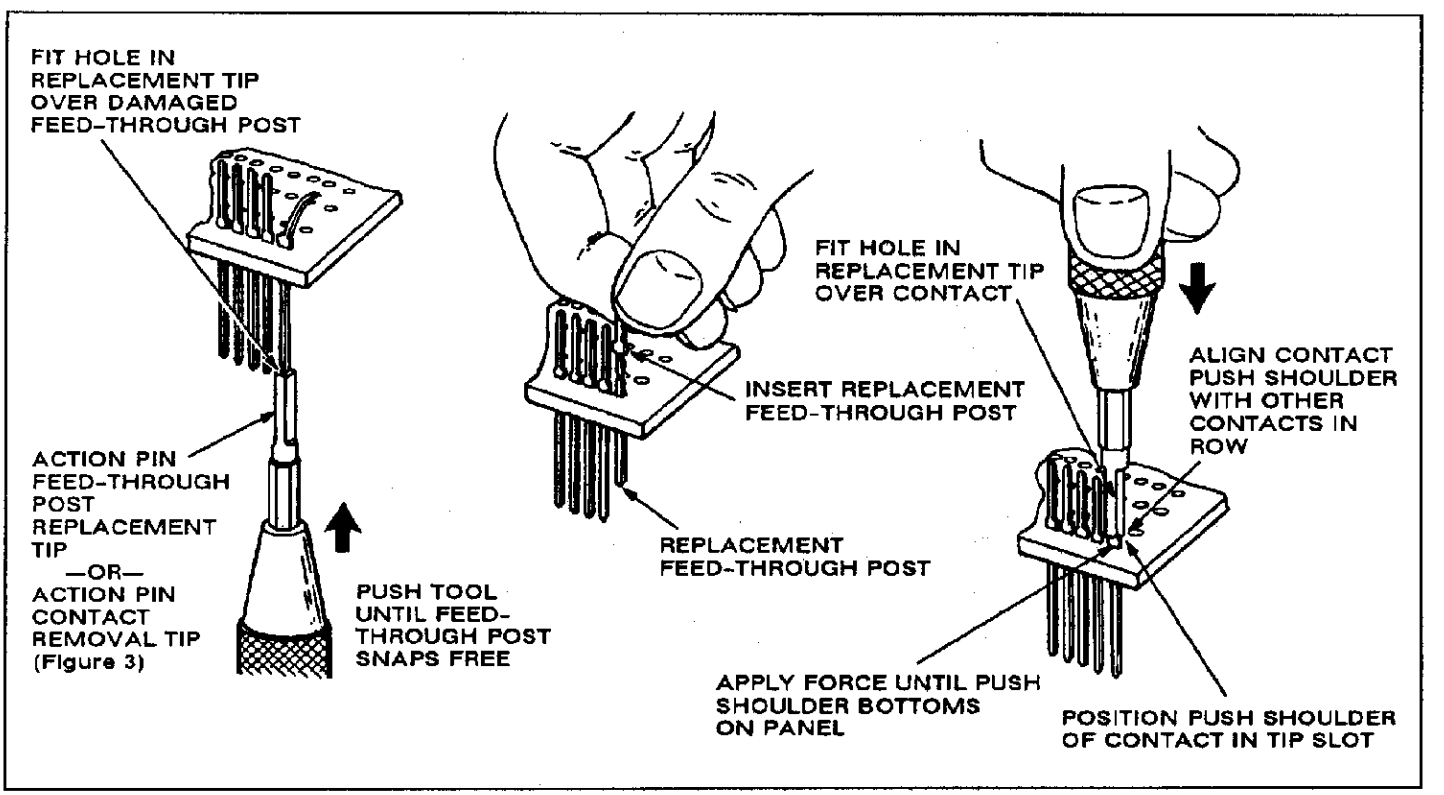

FIT HOLE IN REPLACEMENT TIP OVER DAMAGED FEED-THROUGH POST
ACTION PIN FEED-THROUGH POST REPLACEMENT TIP
—OR—
ACTION PIN CONTACT REMOVAL TIP (Figure 3)
PUSH TOOL UNTIL FEED-THROUGH POST SNAPS FREE
INSERT REPLACEMENT FEED-THROUGH POST
REPLACEMENT FEED-THROUGH POST
FIT HOLE IN REPLACEMENT TIP OVER CONTACT
ALIGN CONTACT PUSH SHOULDER WITH OTHER CONTACTS IN ROW
APPLY FORCE UNTIL PUSH SHOULDER BOTTOMS ON PANEL
POSITION PUSH SHOULDER OF CONTACT IN TIP SLOT

Fig. 7

1. Screw the proper replacement tip onto the basic tool.

2. Fit the hole in the replacement tip over the post of the contact and apply pressure straight upward until the contact snaps free.

3. Remove and discard the damaged contact.

4. Start the new post into the hole.

5. Fit the hole in the replacement tip over the contact, rotate the tool to locate the contact in position (contact push shoulder aligns in slot of the tip), and apply pressure straight downward until the push shoulder bottoms on the panel or pc board.

7. AMP-HDI, EUROCARD, AND AMPMODU CONTACT REPLACEMENT (Figure 8)

1. Remove the contact with the removal tip as described in Section 3.

2. Screw the proper replacement tip (type D in Figure 1) tightly into the basic tool.

3. Insert the new contact into the panel hole.

4. Fit the hole in the replacement tip over the contact. Align the contact with the others in the row. Rotate the tip so the slot in the tip is 90° from the contact shoulders and then apply force straight downward until the tool bottoms on the connector housing.

8. TOOL MAINTENANCE

The tool tips require little maintenance other than keeping them clean. To prevent a tip from breaking during use, make sure that it is tightly screwed into the basic tool.

Refer to IS 2636-1 for information on the care and adjustment of the basic tool.

9. REPAIR

Except for Removal Tip 265964-1, damaged tips should be replaced. Ram Subassembly 310113-1 of the removal tip can be replaced as follows:

1. Remove the slotted pin from the tip.

2. Remove the ram subassembly, being careful to avoid losing the spring.

3. Making sure that the spring is properly seated in the tube, install the new ram subassembly.

4. Secure the subassembly with the slotted pin. Use Loctite† on the pin to ensure that it is secure.

Additional tips can be purchased from:

AMP Incorporated
Customer Service (38-35)
P.O. Box 3608
Harrisburg, PA 17105-3608

† Trademark of Loctite Corp.

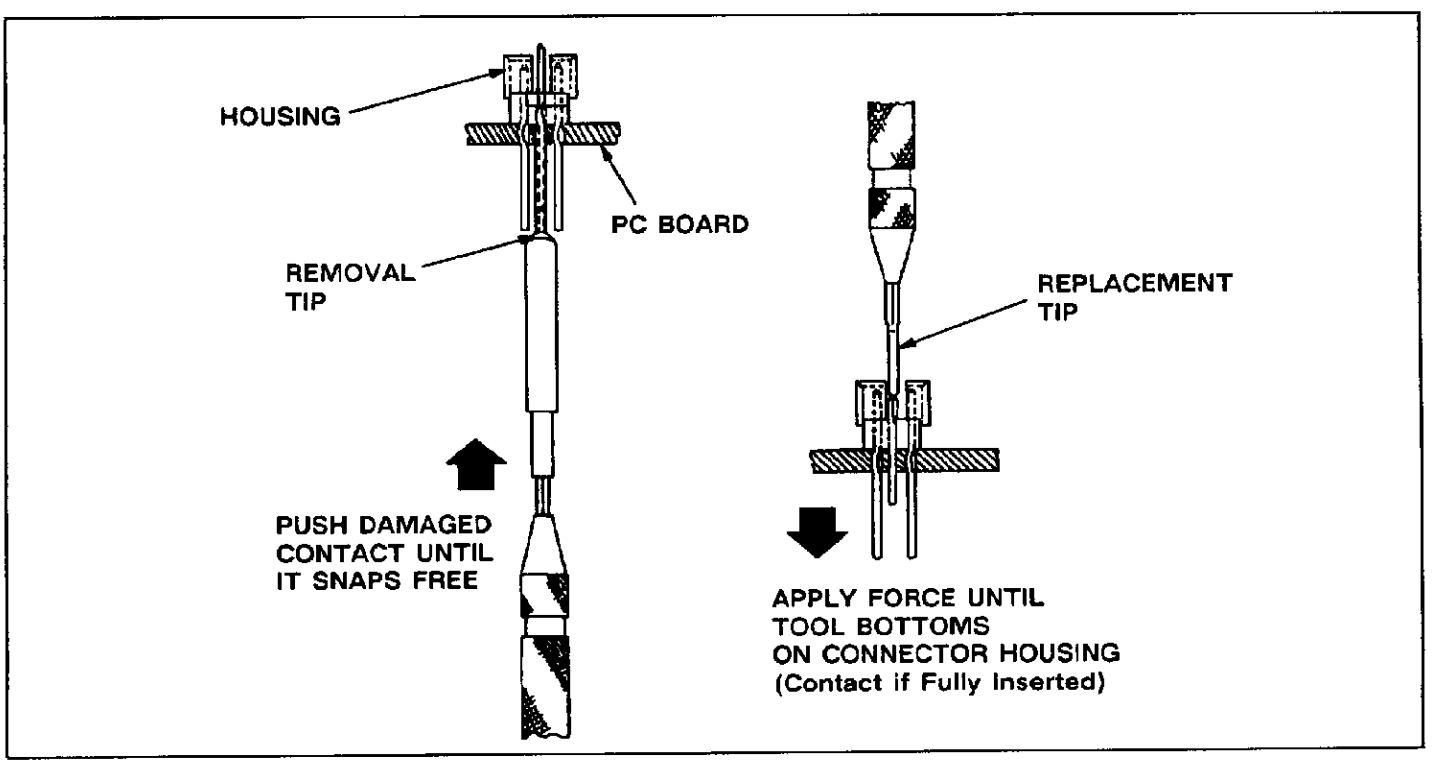
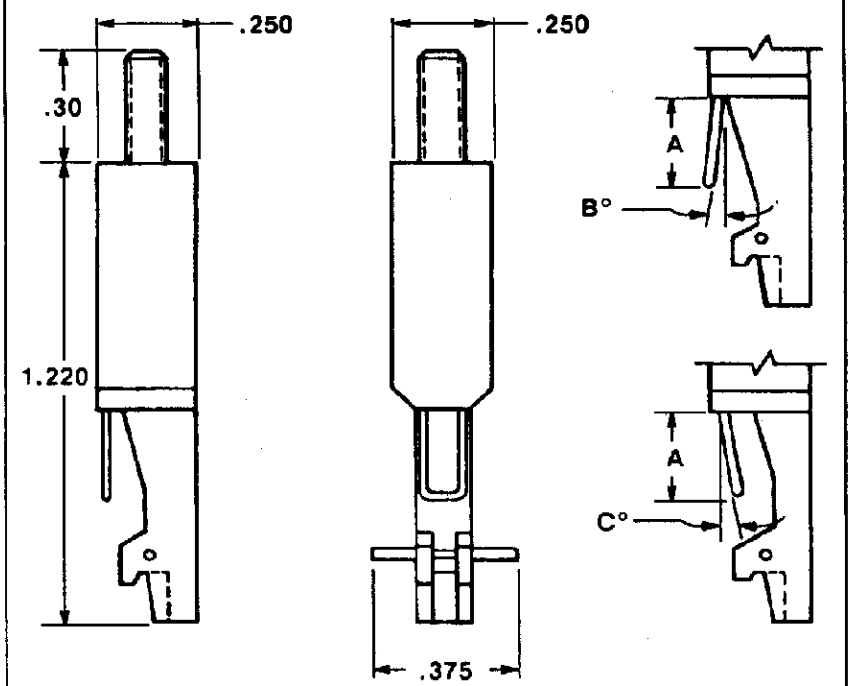
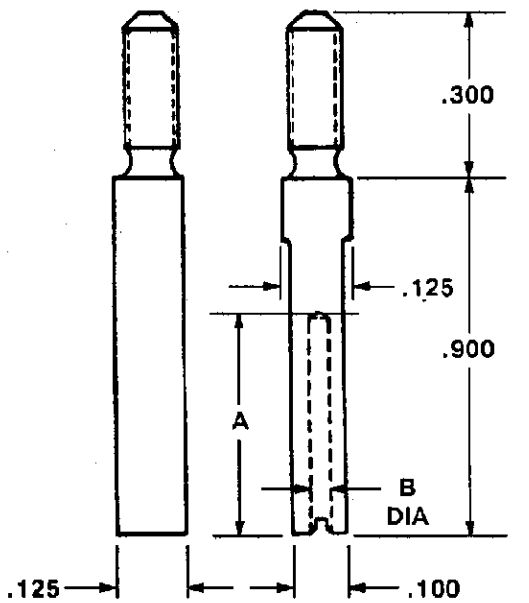


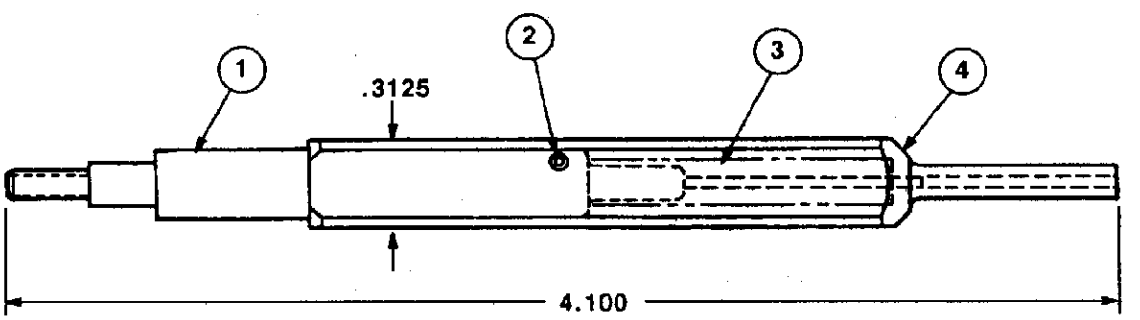
Fig. 8



TIP NO.	A	B°	C°
310759-1	.235	—	—
310759-2	.220	9	—
310759-3	.240	—	6
310759-4	.200	9	—
310759-5	.205	4	—
310759-8	.246	—	4
310759-9	.240	—	6
1-310759-0	.180	15	—



TIP NO.	A	B
308554-1	.40	.036
308554-6	.66	.036



TIP 265964-1

ITEM	PART NUMBER	DESCRIPTION	QTY
1	310113-1	RAM SUBASSEMBLY	1
2	21028-3	PIN, Slotted Spring	1
3	2-22279-5	SPRING	1
4	310111-1	HOUSING	1

Fig. 9

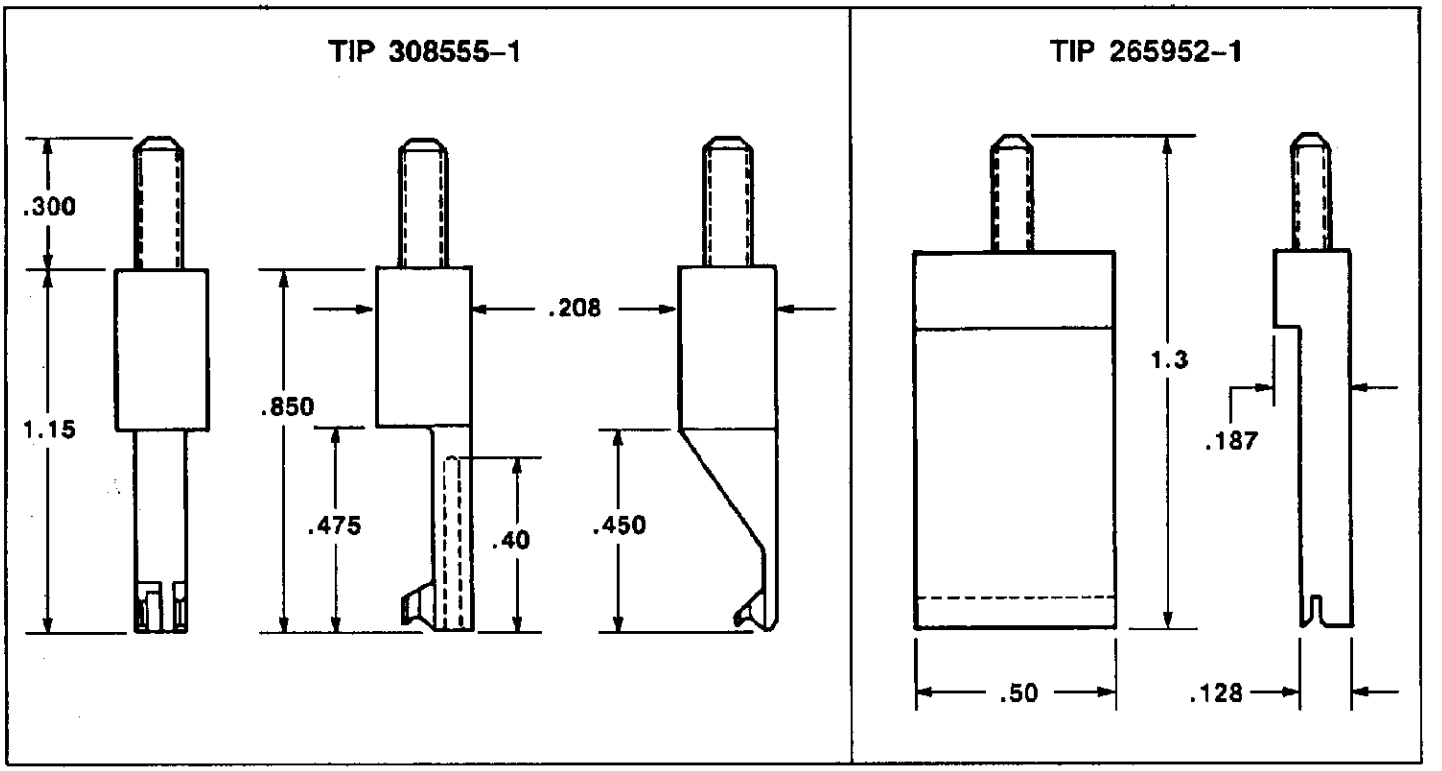

TIP 308555-1
.300
1.15
.850
.475
.40
.208
.450
TIP 265952-1
1.3
.187
.50
.128

Fig. 10

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