

Figure 1

1. INTRODUCTION

Clinching Tool 91117-2 is designed to install External Key 53072-1 into Mini-Box connectors (reference part number 530719-1) to provide polarization of mating connectors. Read these instructions thoroughly before using the tool.

NOTE



Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

2. DESCRIPTION

The clinching tool features an upper jaw and a lower jaw. The upper jaw contains a replaceable punch

which clinches the key in the connector. The lower jaw supports the rivet and connector when the tool handles are closed. See Figure 1.

3. CLINCHING PROCEDURE

Before starting, be sure that the connector and external key are compatible. Also, close the tool handles and check that the punch tip is bottomed on the lower jaw. If necessary, adjust the setscrew of the upper jaw until the punch tip bottoms.

Then, refer to Figure 2, and proceed as follows:

1. Determine the keying position required.
2. Place the key into the cavity at the desired position.
3. Open the tool handles, and position the tool perpendicular to the connector.
4. Place the lower jaw against the back of the connector, and close the tool punch tip through the key mounting hole.
5. Squeeze the tool handles together until the key presses into the cavity and the jaws are bottomed.
6. Remove the tool and, if required, repeat these steps for the other end of the connector. Make sure that the key is properly oriented.
7. Check the orientation of the keys in the keying cavities. An aligning tool similar to the tool shown in Figure 3 can be used to rotate a key that is slightly out of orientation. This type of tool can also be used to prevent a key from twisting in the connector when mounting it to the printed circuit (pc) board.

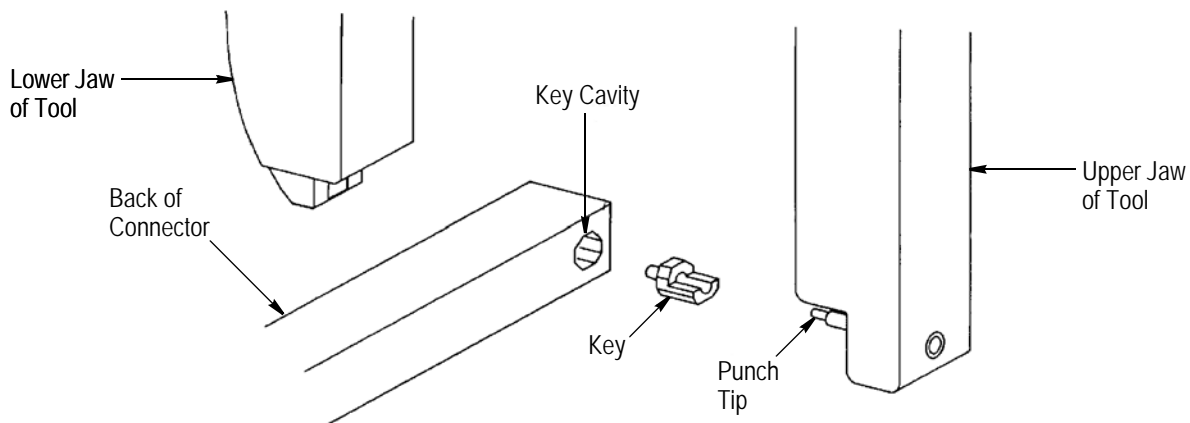


Figure 2

Note: Not to Scale

Note: This tool is customer supplied.

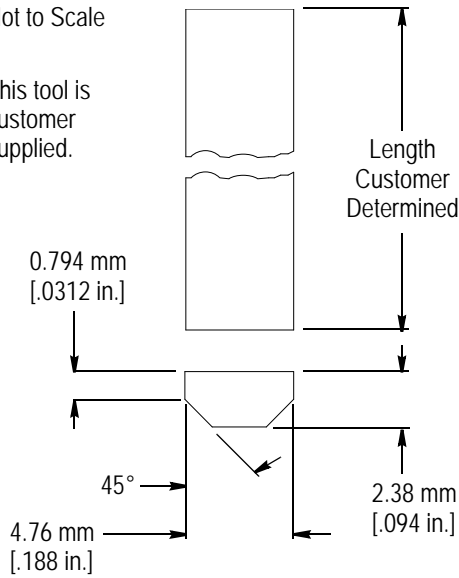


Figure 3

4. MAINTENANCE AND INSPECTION

The clinching tool should be inspected immediately upon arrival at your facility to ensure that the tool has not been damaged during handling. The tool should also be inspected at regularly scheduled intervals to ensure proper operation of the tool.

4.1. Daily Maintenance

It is recommended that each operator 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 a soft lint-free cloth.
2. Make sure all pins, pivot points, and bearing surfaces are protected with a THIN coat of SAE 20 motor oil. DO NOT oil excessively.

5. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 4. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Parts other than those listed should be replaced by TE Connectivity to ensure quality and reliability. Order replacement parts 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

For customer repair service, call 1-800-526-5136.

6. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company logo
- Updated instruction sheet to corporate requirements
- Removed length and width dimensions of tool from and added jaw opening dimension to Figure 4

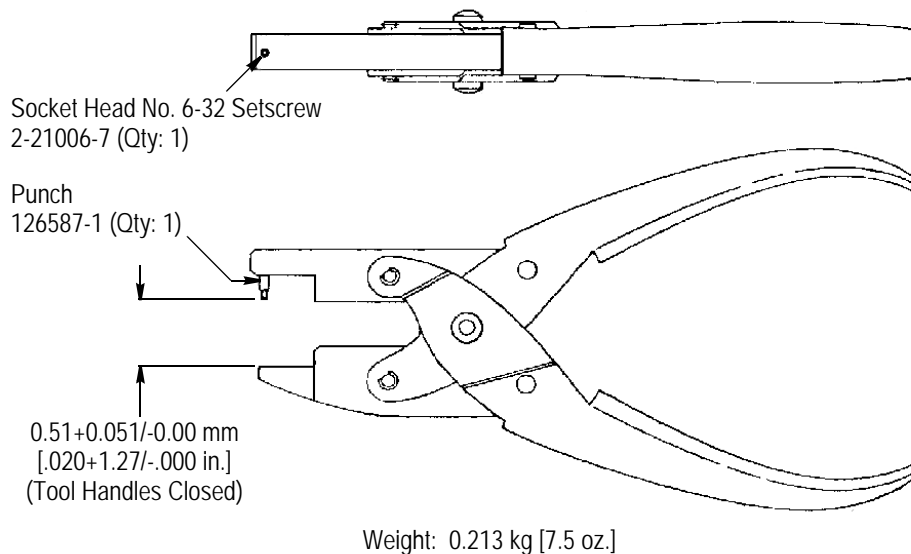


Figure 4