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HARRISBURG, PA 17105

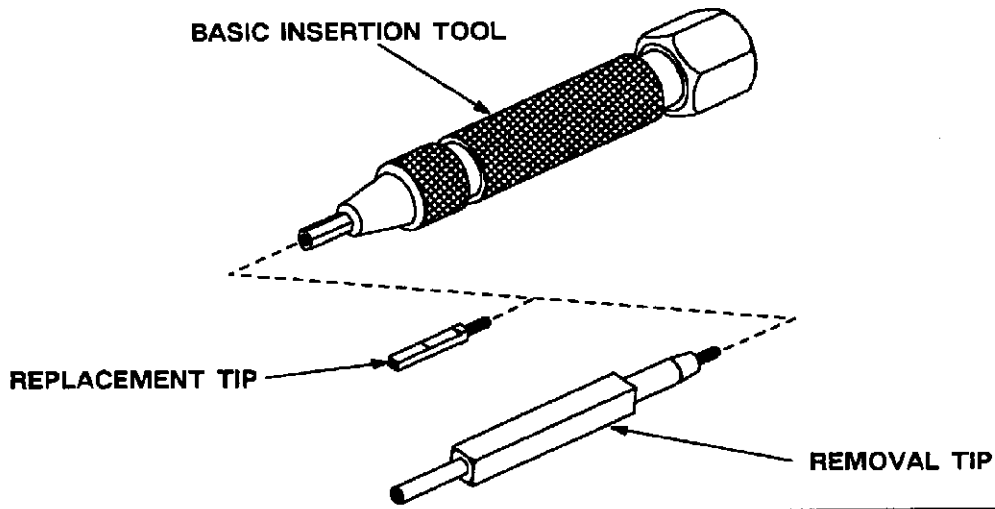
CUSTOMER HOTLINE
1 800 722-1111

# AMP* PIN CONTACT REPLACEMENT TOOL KIT
4-265871-1

REDUCED FOR PACKAGING

**IS 9523**

RELEASED
9-25-90




| HEADER PART NUMBERS | BASIC TOOL NUMBER | REPLACEMENT TIP NUMBER | REMOVAL TIP NUMBER | KIT PART NUMBER |
|---|---|---|---|---|
| 535841-[ ] | 380392-8 | 308554-7 | 265964-1 | 4-265871-1 |
| 535842-[ ] | ↓ | ↓ | ↓ | ↓ |
| 535843-[ ] | | | | |
| 535844-[ ] | | | | |
| 535845-[ ] | | | | |
| 535861-[ ] | | | | |
| 535862-[ ] | | | | |

Fig. 1

## 1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Pin Contact Replacement Tool Kit 4-265871-7 which is used to replace AMP ACTION PIN* contacts in TBC (Twin Beam Connector) Plus Headers listed in Figure 1. Read this instruction sheet thoroughly before using the tool.

**NOTE** *All dimensions on this sheet are in inches.*

## 2. DESCRIPTION (Figure 1)

The tool kit includes the basic tool, replacement tip, and removal tip. The basic tool features a spring-loaded, internally-threaded tip. The removal and replacement tips are designed to remove or replace contacts of specific types and sizes. Refer to the chart in Figure 1 for individual part numbers.

**CAUTION** *The basic tool is impact operated. Do NOT operate unless in actual use or injury could result.*

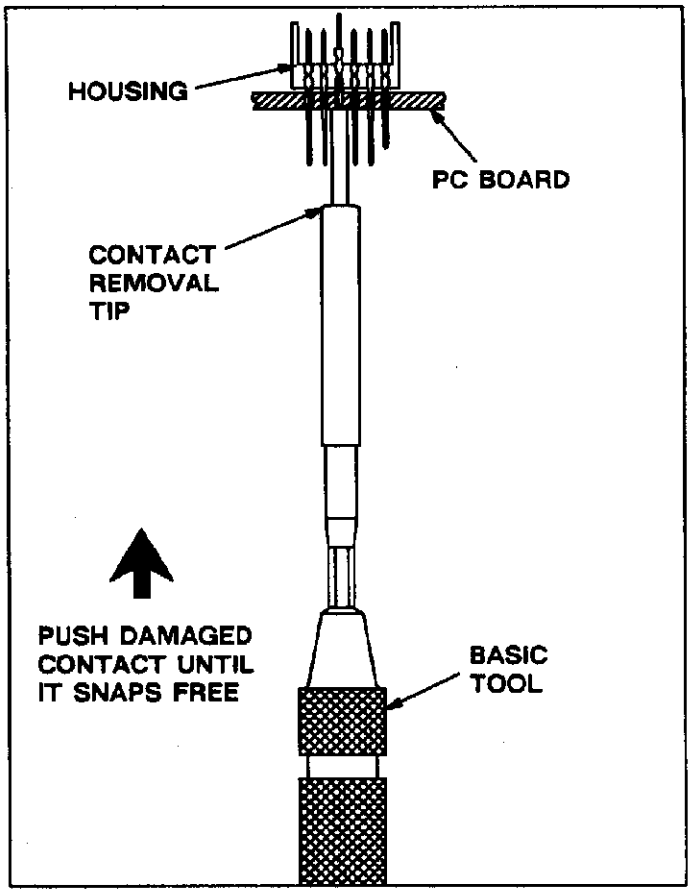
The replacement tip is threaded into the tip of the basic tool and fits onto the appropriate contact to be replaced.

## 3. CONTACT REMOVAL (Figure 2)

**NOTE** *If the printed circuit board or panel has been soldered, contact removal requires use of a soldering iron along with the tool for Steps 2 and 3. Hold hot tip of soldering iron against the pin to be removed, NOT against the pc board or panel. After the contact is removed, use a .038-in. drill bit to clean and size the hole for contact replacement. Do NOT re-use ACTION PIN contacts after they have been removed.*

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1. Thread the contact removal tip into the tip of the basic tool.

2. Position contact removal tip over square post of contact.

3. Holding basic tool and pc board firmly, push contact straight out of the pc board and housing.

## 4. CONTACT REPLACEMENT (Figure 3)

1. Thread the replacement tip into tip of replacement tool.

2. Orient and start replacement contact into hole.

3. Fit slot in replacement tip over contact, rotate tool to locate contact in proper position, and apply force in direction of arrow.

**NOTE**

*Ensure that shoulder of contact is aligned with slot of replacement tip before applying force on replacement contact.*

4. Rotate tool 90° to locate tip shoulders on contact shoulder and apply force in direction of arrow to fully seat contact

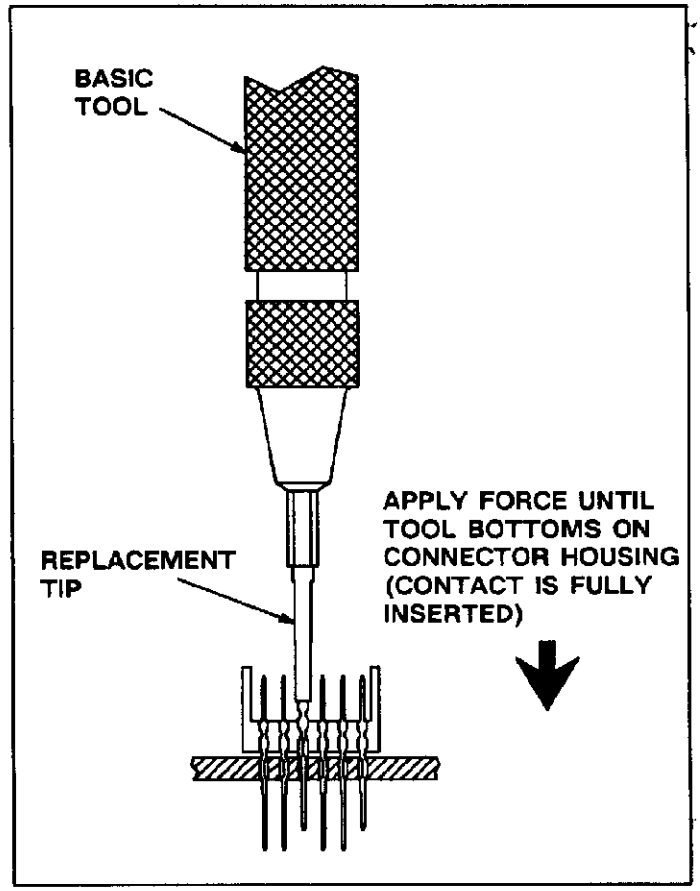



Fig. 3

**NOTE**

*After the contact is fully seated, the contact shoulder should be flush with housing.*

5. Remove basic tool from contact, being careful not to damage the other contacts.

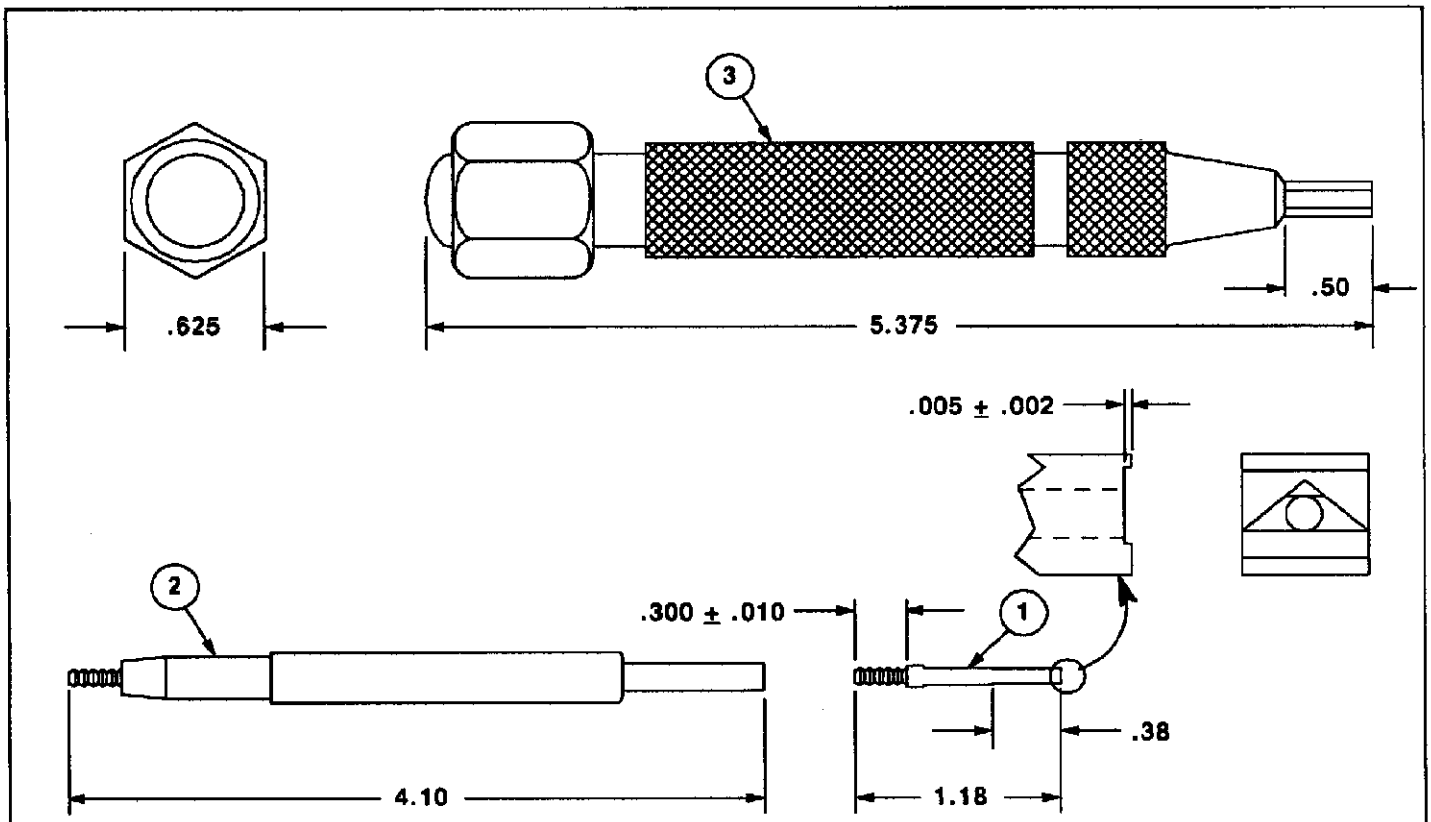
## 5. TOOL INSPECTION

The tool kit listed in this instruction sheet should be verified with the information provided in Figure 4. We recommend that you inspect the tool kit immediately upon arrival in your factory, and at regularly scheduled intervals, to ensure that the tool kit has not been damaged during handling.

Additional tool kits can be purchased from:

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

or a wholly owned subsidiary of AMP Incorporated.




| REPLACEMENT TOOL KIT | TOOL DESIGNED FOR | WEIGHT | REPLACEMENT PARTS | | |
|---|---|---|---|---|---|
| | | | ITEM | PART NUMBER | DESCRIPTION |
| 4-265871-1 | ACTION PIN Contacts | 5 oz | 1 | 308554-7 | TIP, Replacement |
| | | | 2 | 265964-1 | TIP, Removal |
| | | | 3 | 380392-8 | TOOL, Replacement |

Fig. 4

## 6. REPAIR

The parts listed in Figure 4 are customer-replaceable. A complete inventory should be stocked to prevent lost time when replacement of parts becomes necessary. The tool kit can also be returned to AMP for evaluation and repair. Send the tool kit with a written description of the problem to:

AMP Incorporated
Customer Repair (01-12)
1523 North 4th Street
Harrisburg, PA 17102-1604

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