

**AMP* CLINCHING TOOL 91117-7
FOR
AMP-HDI* SERIES 50 CONNECTORS**

CUSTOMER HOTLINE 1 800 722-1111

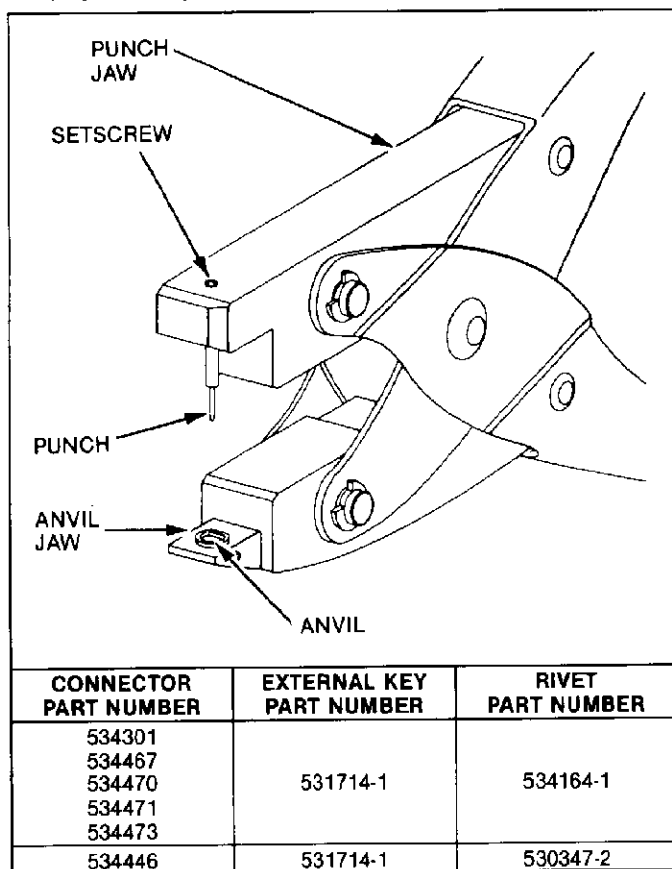


Fig. 1

1. INTRODUCTION

AMP Clinching Tool 91117-7 is used to install external keys into AMP-HDI Series 50 connectors. These connectors have centerline spacings of .050 x .100 in. The tool clinches a rivet that secures the key.

The key polarizes the connector. Its octagonal shape allows it to be installed in any of eight positions. The two keying cavities in a connector allow 64 different keying combinations. One cavity is labeled with the numbers 1 through 8; the other cavity is labeled with the letters A through H.

NOTE All dimensions on this sheet are in inches.

2. DESCRIPTION (Figure 1)

The clinching tool features two jaws holding a punch and an anvil. The punch clinches the rivet. The anvil supports the connector. Both the punch and the anvil are replaceable.

3. CLINCHING PROCEDURE (Figure 2)

Before starting, make sure you have the correct connector, key, and rivet.

1. Insert the rivet into the back of the connector.
2. Place the key in the keying cavity in the desired keying position.
3. Open the tool handles.
4. Insert the punch into the key, and then twist the connector until the rivet rests on the anvil.
5. Close the tool handles to start the punch into the key.
6. Squeeze the handles until jaws bottom.

If necessary, repeat this procedure to install a key at the other end of the connector.

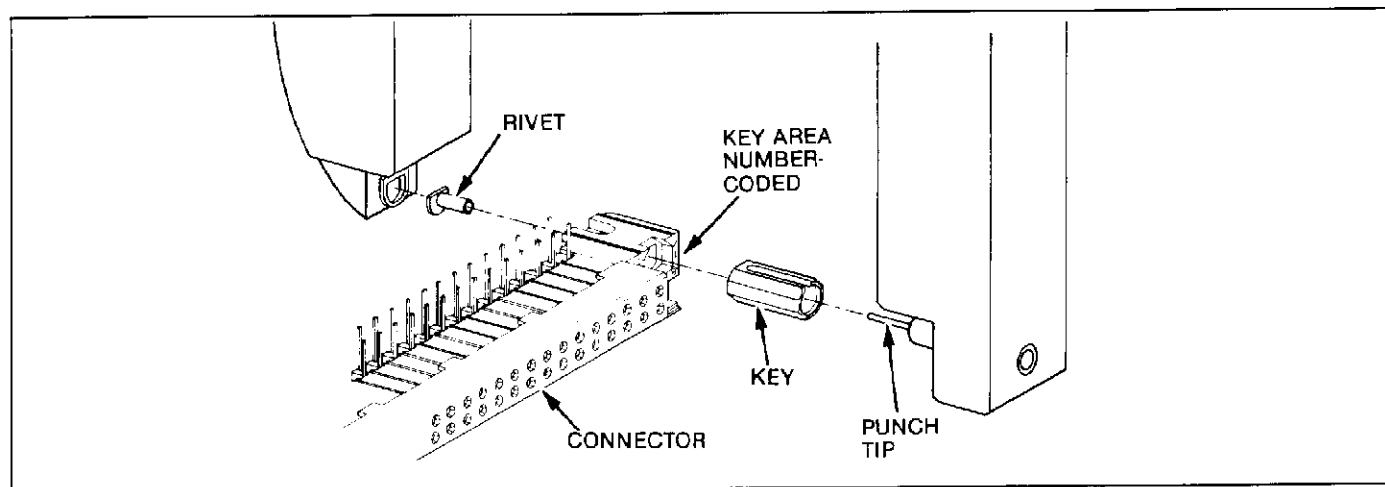


Fig. 2

4. TOOL ADJUSTMENT (Figure 3)

When the tool is closed, there should be a .020-in. gap between the punch and anvil. An incorrect gap will prevent the key from seating properly. Adjust the gap by loosening the setscrew in the top of the punch jaw, threading the punch in or out to obtain the .020-in. gap, and tightening the setscrew.

5. CERTIFICATION AND MAINTENANCE

The tool should be certified with the information in Figure 3. We recommend you inspect the tool on its arrival and at regularly scheduled intervals to ensure it has not been damaged or worn.

The following are the recommended steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean brush or soft, lint-free cloth. Do not use objects that could damage the tool.
2. Make sure the proper retaining pins are in place and secured with retaining rings.

3. Make certain all pins, pivot points, and bearing surfaces are protected with a thin coat of SAE No. 20 motor oil. Do not oil excessively.

6. REPAIR AND REPLACEMENT

The parts listed in Figure 3 are customer replaceable. They should be replaced when they become worn or damaged. Replacement parts can be ordered from

AMP Incorporated
P.O. Box 3608
Harrisburg, PA 17105-3608

Parts other than those listed in Figure 3 should be replaced by AMP to ensure certification of the tool. When repair is necessary, return the tool with a written description of the problem to

AMP Incorporated
Customer Repair
1523 N. 4th St.
Harrisburg, PA 17102-1604

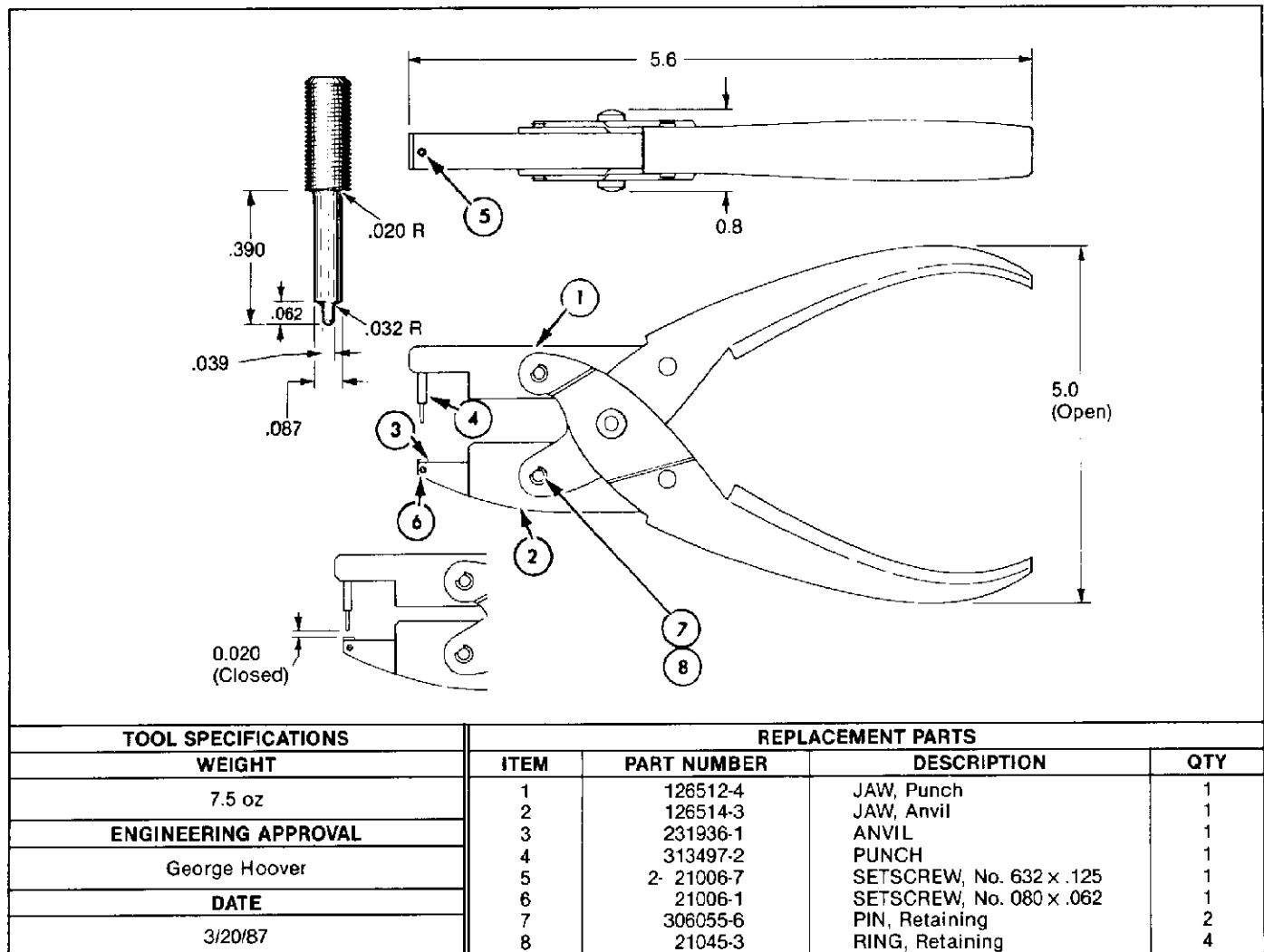


Fig. 3

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[91117-7](#)