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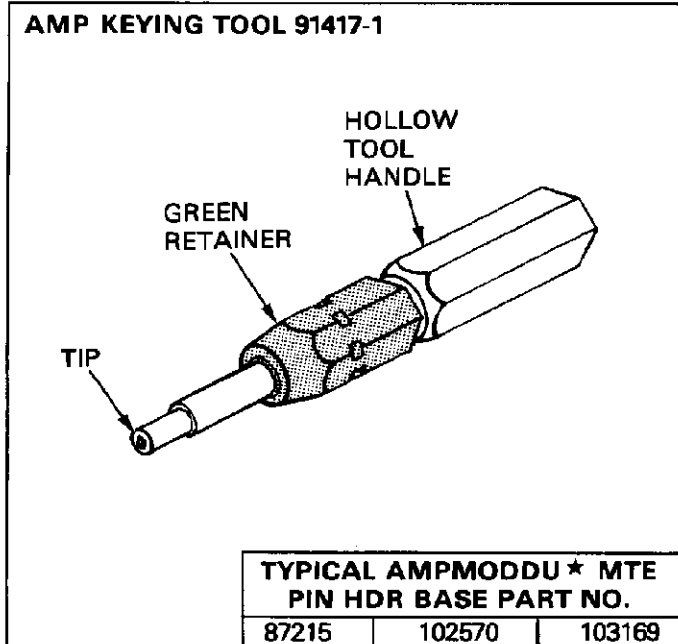


Fig. 1

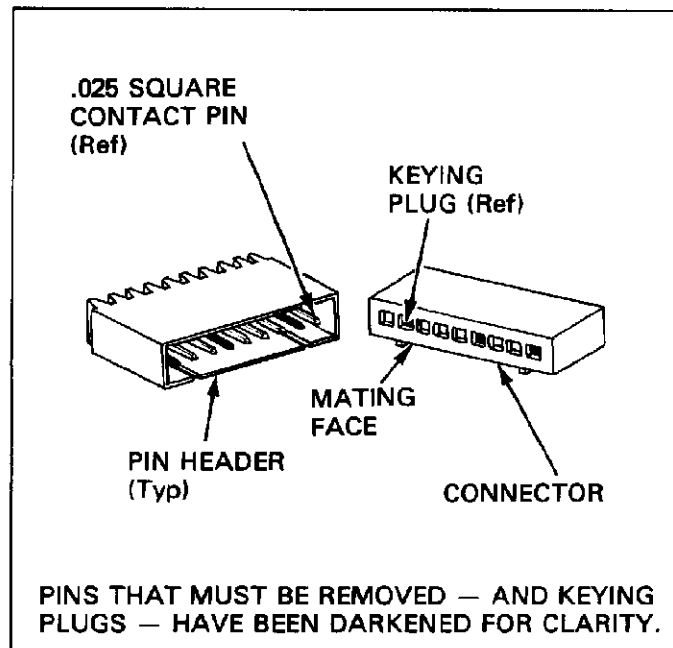


Fig. 2

1. INTRODUCTION

This instruction sheet (IS) covers AMP Keying Tool 91417-1, which is shown in Figure 1. Read this material thoroughly before starting.

NOTE All dimensions on this sheet are in inches.

2. DESCRIPTION (Figure 1)

AMP Keying Tool 91417-1 is designed to remove .025 square pin contacts from AMPMODU MTE pin headers, such as those listed in Figure 1. The tool features a hollow tool handle, a tool tip, a green tip retainer, and a gage bushing (inside retainer). For further information regarding AMPMODU MTE Connectors, refer to AMP Instruction Sheet IS 6919.

3. KEYING PROCEDURE

Pin headers are keyed by removing pin contacts that align with keying plugs in a keyed connector (refer to Figure 2). Headers can be keyed before or after being attached to a printed-circuit (pc) board.

To key a header, proceed as follows:

1. Determine which contact pin position(s) will align with a corresponding keying plug in the mating connector. Refer to Figure 2.
2. Align the tip of the tool with the appropriate contact pin, as shown in Figure 3.

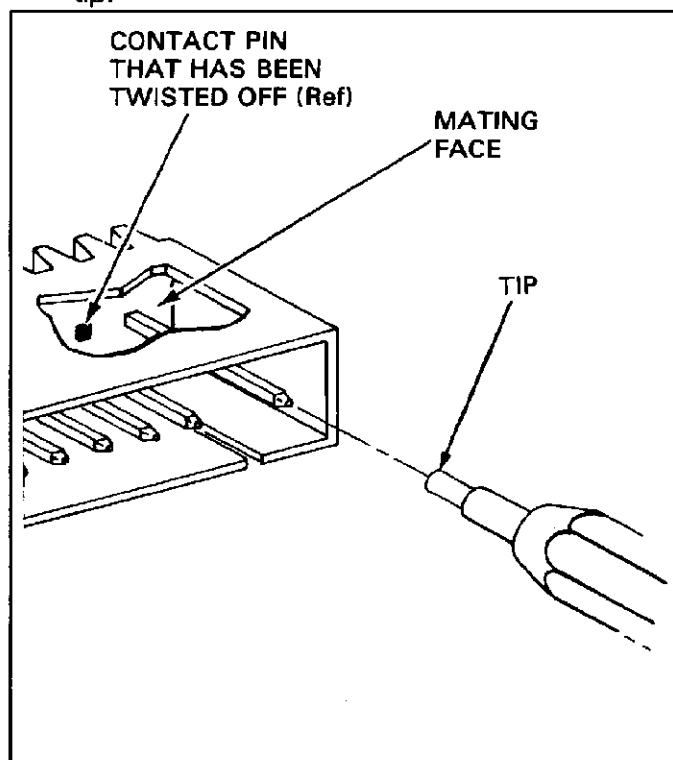


Fig. 3

4. Keeping the tool tip seated on the mating face, twist the tool handle until the pin snaps off. It is not necessary to remove the contact pin from the tip of the tool, since it will push through the hollow handle when the tool tip is installed over the next pin.
5. Repeat Steps 1 through 4 until all of the appropriate pins have been removed.

CAUTION

Before mating the connector with the pin header, align the assemblies and check to be sure that all contact pins corresponding to connector keying plugs have been removed.

4. TOOL INSPECTION

The information in Figure 4 provides the design specifications required to permit continuous use and reliability of the tool. The tool should be inspected immediately upon its arrival at your facility to be sure that it has NOT been damaged in transit, and it should be inspected regularly to be sure it remains functional. Should additional tools be needed, send your purchase to:

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

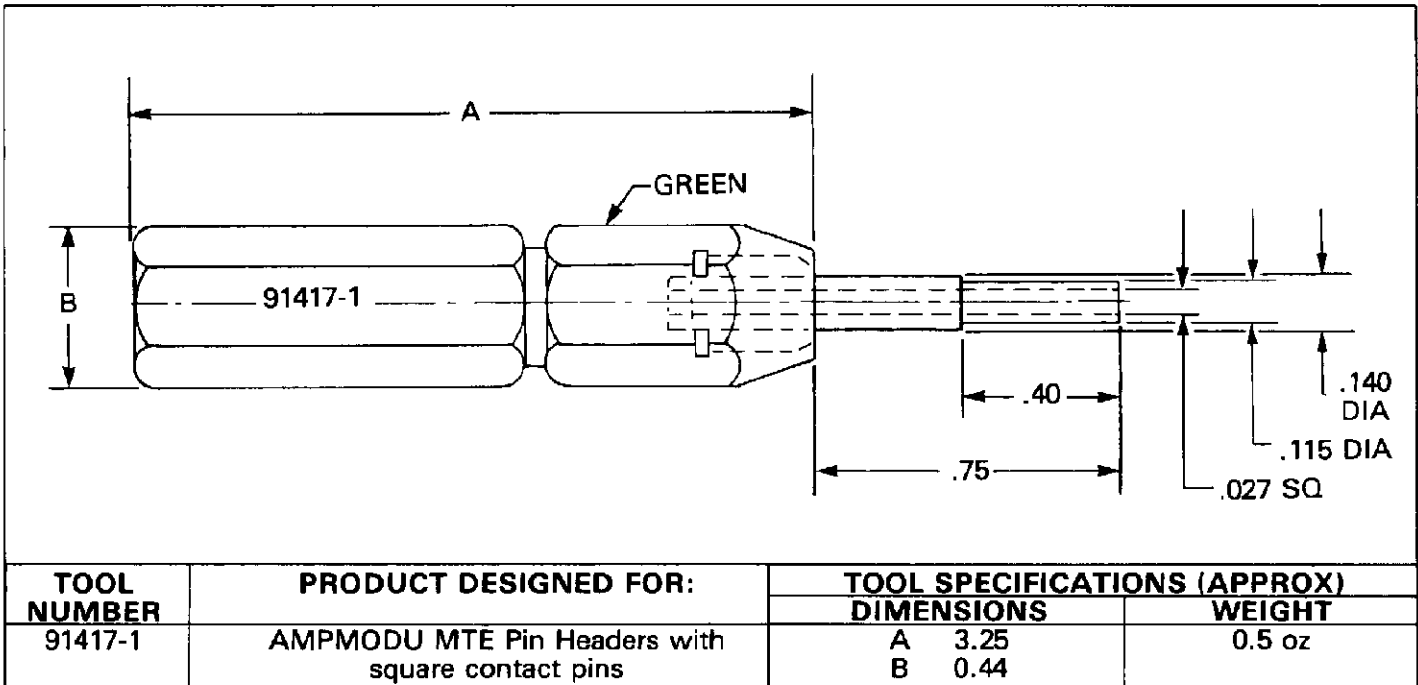


Fig. 4

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[91417-1](#)