AMP INCORPORATED
HARRISBURG, PA., U.S.A.

AMP* TERMI-POINT* PULL TEST TOOL CATALOG NO. 69358-□ AND TEST TIP CATALOG NO. 69544-□

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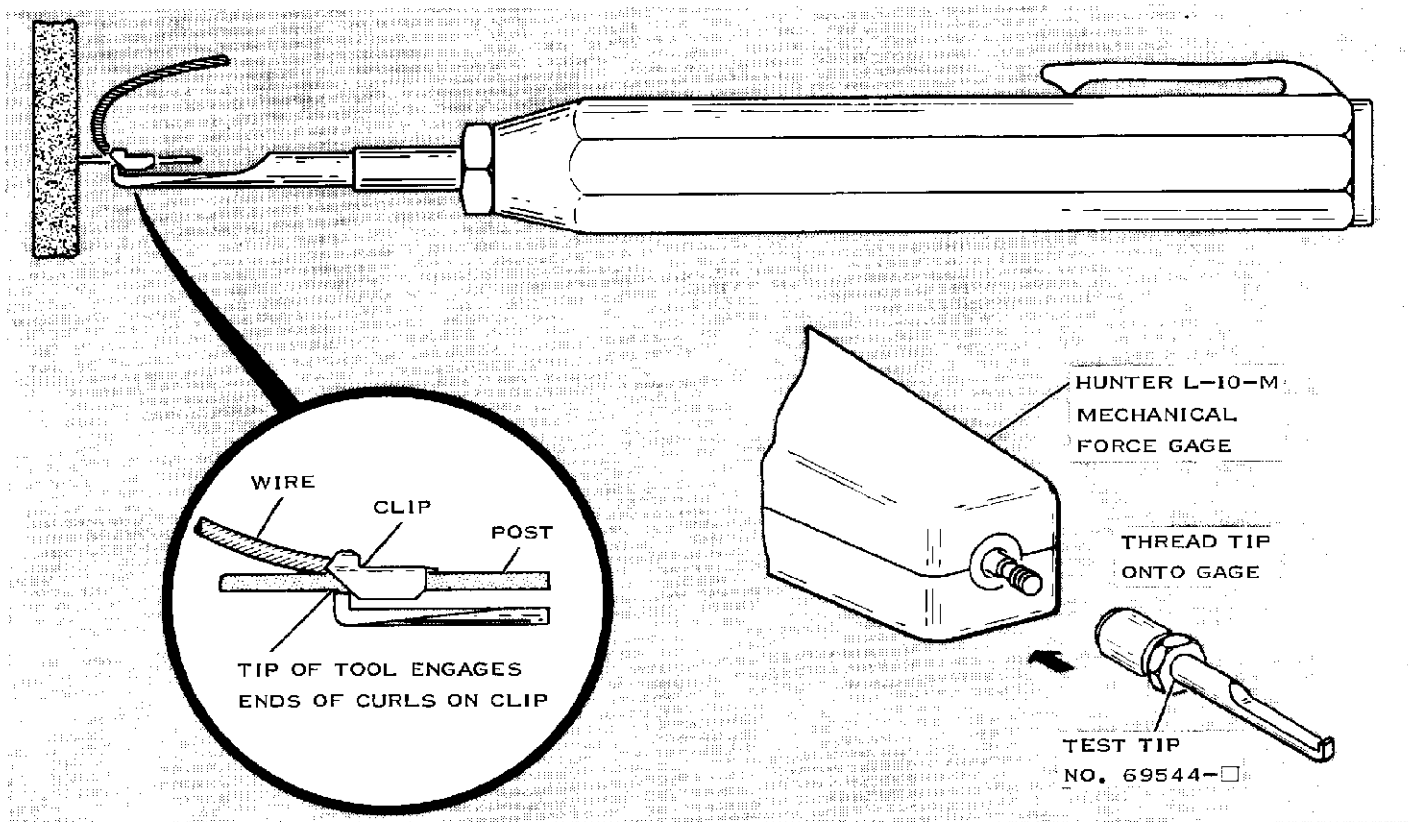


CLIP NUMBER	POST SIZE	PULL TEST TOOL			TEST TIP NUMBER †
		NUMBER	TEST FORCE IN POUNDS	INDICATOR RING COLOR	
□-330495-□	.031" X .062"	69358-2	2.25	YELLOW	69544-1
□-330854-□	.031" X .093"	69358-5	2.25	YELLOW	69544-2
□-67042-□	.022" X .036"	69358-6	0.50	GREEN	69544

† USE WITH HUNTER MECHANICAL FORCE GAGE MODEL L-10-M.

FIG. 1

1. INTRODUCTION

The Pull Test Tools, Catalog No. 69358-□ and Test Tips, Catalog No. 69544-□ (for use with Hunter Mechanical Force Gage, Model L-10-M) are used to make non-destructive tests of the mechanical quality of a termination.

2. TESTING PROCEDURE

2.1 PULL TEST TOOL NO. 69358-□

(a) Hook Tool squarely against end of Clip, with Tip engaging Ends of Curls on Clip. See Figure 1.

(b) Maintain alignment of Tool with Post, and pull slowly until the Indicator Ring is in line with front of Tool. See Figure 1.

(c) Clip may slide, no more than 1/2 the Clip Length, before the Indicator Ring is visible. See Figure 2-A.

(d) Lateral Clip movement during test, see Figure 2-B, does not affect the quality of termination.

NOTE: Clips that move more than 1/2 the Clip Length should be rejected and a new Clip applied and test repeated.

2.2 TEST TIP NO. 69544-□

(a) Thread Tip onto Hunter Mechanical Force Gage, Model L-10-M.

(b) Hook Tip squarely against end of Clip, with Tip engaging End of Curls on Clip. See Figure 1.

(c) Maintain alignment of Gage with Post, and pull slowly until the Gage reaches its maximum reading.
NOTE: Gage must be set in "LOCK" Position to record maximum reading.

(d) Clip may slide no more than 1/2 the Clip Length, before reading is obtained. See Figure 2-A.

(e) Lateral Clip movement during test, see Figure 2-B, does not affect the quality of termination.
NOTE: Clips that move more than 1/2 the Clip Length should be rejected and a new Clip applied and test repeated.

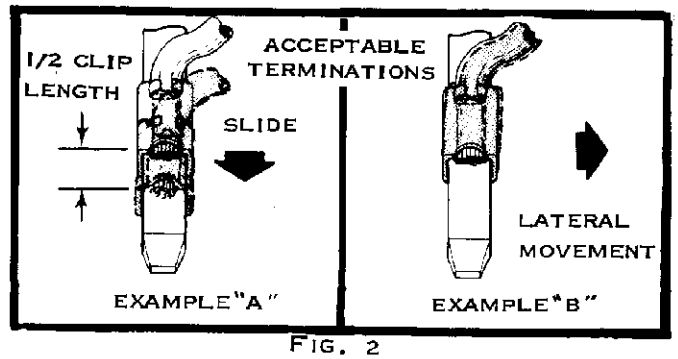
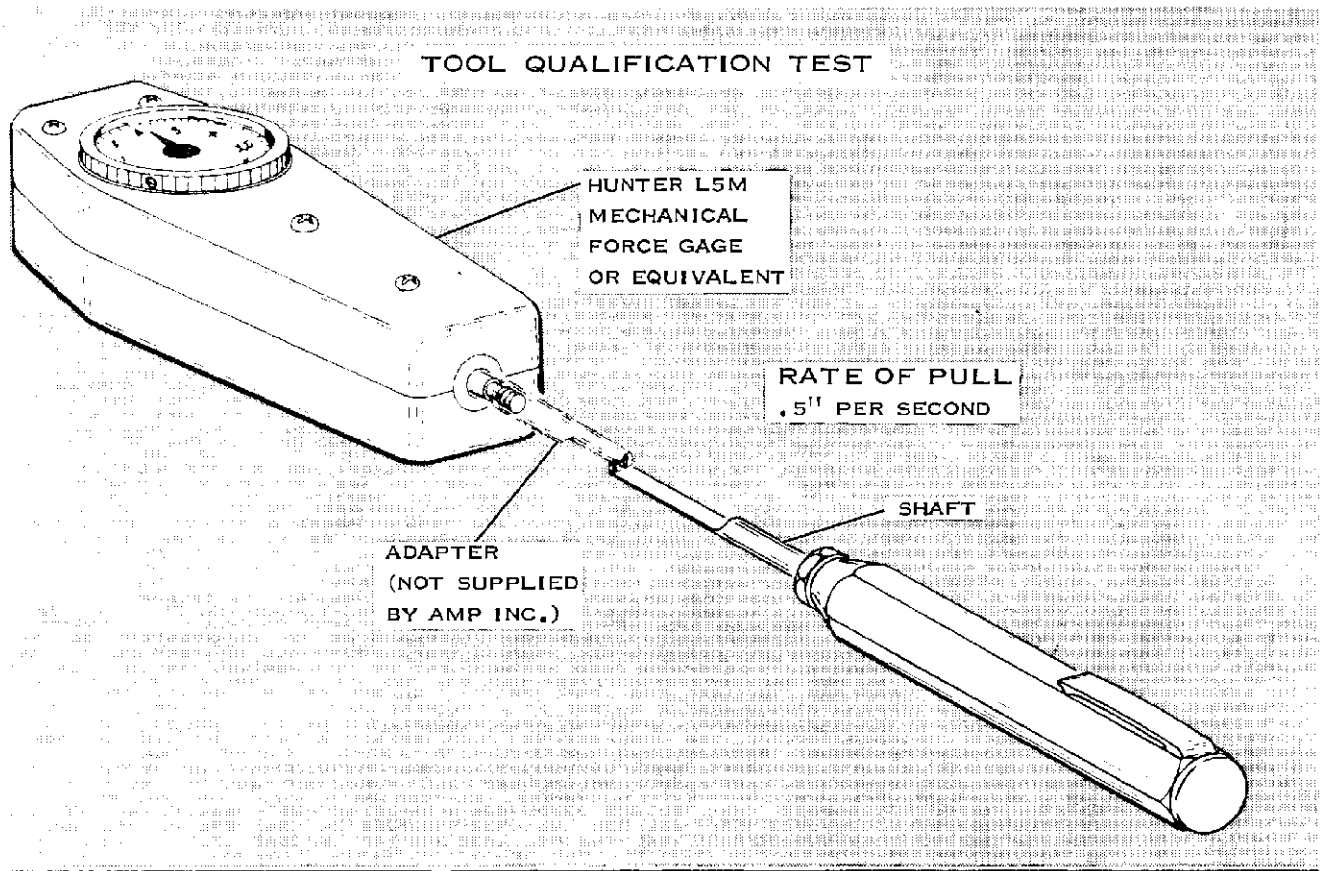


FIG. 2



TOOL NUMBER	INDICATOR RING COLOR	CALIBRATION FORCE IN POUNDS
69358-2	YELLOW	2.25 ± .10
69358-5	YELLOW	2.25 ± .10
69358-6	GREEN	0.50 ± .10

FIG. 3

3. TOOL QUALIFICATION TEST

A periodic Tool Qualification Test should be made to make certain that Tool No. 69358-□ is maintaining the proper calibration. Use the following procedure to check Tool Calibration:

(a) Connect TERMI-POINT Test Tool to an accurate Mechanical Force Gage. A typical set-up using a Hunter L5M Force Gage and Adapter is shown in Figure 3.
NOTE: Gage must be set in "LOCK" Position to record maximum reading.

(b) Force Gage and Test Tool must be held in a horizontal plane and be aligned when making the test. Care must be taken to prevent binding between shaft and end of Test Tool. See Figure 3.

(c) Pull Tool, using a pull rate of .5 inches per second.

(d) Gradually decrease pull rate until Indicator Ring is in line with front of Tool. Check Gage Reading.

(e) If Gage Reading is not satisfactory, Test Tool should be returned to AMP Incorporated.