

HDSCS CONNECTORS

TOOLING

Tools are specific to each contact style. To create a proper crimp and achieve the highest performance specifications, contacts must be crimped with the recommended tooling.



HAND TOOL FOR AMP MCP CONTACTS

Contact Size	Contact Type	Strip Form Part Number	Loose Piece Part Number	Hand Tool Part Number	Die Set Part Number
1.5K	Receptacle	1564324	1564325	539635-1	4-1579016-0
		1241380	1241381		539950-2
		1418884	1418885		5-1579001-3
	Tab	969028	969029		539663-2
		963902	963903		539651-2
		2141884	2141885		539663-2
		963904	963905		539651-2
		964269	964270		539663-2
		1703278	1703279	-	-
2.8	Receptacle	2141859	-	-	-
		968855	968875	539635-1	539726-2
		968857	968876		539727-2
		968859	968877		539727-2
		1719506	-	-	-
	Tab	965982	965983	539635-1	539737-2
		962915	963748		539758-2
		962916	963749		539758-2
		968947	968966		539727-2
		1719504	1719503	-	-
6.3 / 4.8K	Receptacle	1241410	1241411	539635-1	539955-2
		1241412	1241413		539955-2
		1241414	1241415		539956-2
		1241416	1241417		539956-2
		1241418	1241419		3-1579021-7
	Tab	962917	963742		539757-2
		962918	963743		539757-2
		962919	963744		539757-2
		2112966	2112965	-	-

Other tooling configurations available upon request. Please contact TE for additional information.

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AUTOMATED FOR AMP MCP CONTACTS



OCEAN 2.0 Applicator

Contact Size	Contact Type	Strip Form Part Number	Feed	Type	Applicator Part Number
1.5K	Receptacle	1564324	Side	Mechanical	2151469-1
				Pneumatic	2151469-2
		1241380		Mechanical	2151064-1
				Pneumatic	2151064-2
		1418884		Mechanical	2151424-1
				Pneumatic	2151424-2
	Tab	969028		Mechanical	2151056-1
				Pneumatic	2151056-2
		963902		Mechanical	2151167-1
				Pneumatic	2151167-2
		2141884		Mechanical	2151056-1
				Pneumatic	2151056-2
		963904		Mechanical	2151170-1
				Pneumatic	2151170-2
		964269		Mechanical	2151057-1
				Pneumatic	2151057-2
		1703278		Mechanical	2151701-1
				Pneumatic	2151701-2
2.8	Receptacle	2141859	Side	-	-
		968855		Mechanical	2151227-1
				Pneumatic	2151227-2
		968857		Mechanical	2151346-1
				Pneumatic	2151346-2
		968859		Mechanical	2151173-1
				Pneumatic	2151173-2
	Tab	1719506		Mechanical	2836789-1
				Pneumatic	2836789-2
		965982		Mechanical	2151840-1
				Pneumatic	2151840-2
		962915		Mechanical	2151181-1
				Pneumatic	2151181-2
		962916		Mechanical	2151260-1
				Pneumatic	2151260-2
		968947		Mechanical	2151173-1
				Pneumatic	2151173-2
		1719504		Mechanical	2836092-1
				Pneumatic	2836092-2

Other tooling configurations available upon request. Please contact TE for additional information.

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AUTOMATED FOR AMP MCP CONTACTS (Continued)



OCEAN 2.0 Applicator

Contact Size	Contact Type	Strip Form Part Number	Feed	Type	Applicator Part Number
6.3 / 4.8K	Receptacle	1241410	Side	Pneumatic	2151695-2
		1241412		Pneumatic	2151234-2
		1241414		Pneumatic	2151177-2
		1241416		Pneumatic	2151151-2
		1241418		Mechanical	2151466-1
	Tab	962917		Pneumatic	2151466-2
		962918		Pneumatic	2266535-2
		962919		Pneumatic	2151783-2
		2112966		Pneumatic	2151782-2
				Pneumatic	2151841-2

Other tooling configurations available upon request. Please contact TE for additional information.

EXTRACTION AND INSERTION TOOLS FOR AMP MCP CONTACTS

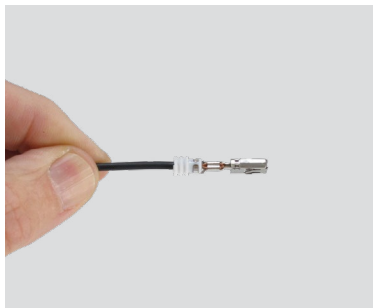
Contact Size	Contact Type	Tool Type	Part Number
1.5K	Receptacle	Insertion	5-1579018-6
		Extraction	1-1579007-1
2.8	Tab	Extraction	539960-1
		Extraction	519609-1
	Receptacle	Insertion	1579007-1
		Extraction	1-1579007-6
6.3 / 4.8K	Receptacle	Insertion	6-1579018-3
		Extraction	1-1579007-3
	Tab	Extraction	1-1579007-6



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HOW-TO INSTRUCTIONS

CONTACT INSERTION



STEP 1:

Grasp crimped contact approximately one inch behind the contact barrel.



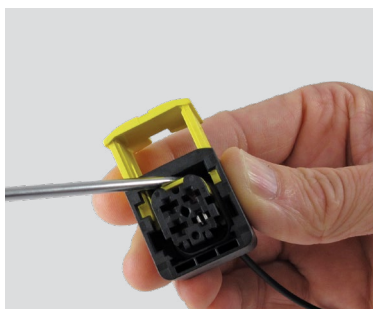
STEP 2:

Make sure the contact is in the correct orientation. Verify the integrated secondary lock is in the unlocked position.



STEP 3:

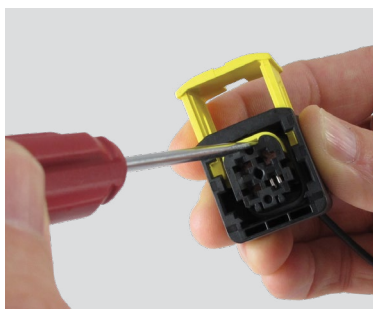
Push contact straight into connector grommet until a click is felt. A slight tug will confirm that it is properly locked in place.



STEP 4:

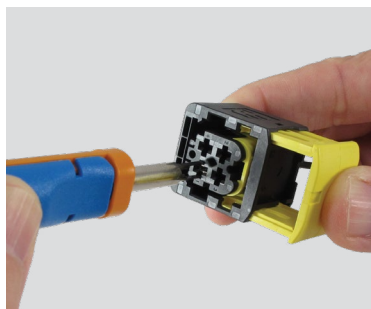
Push the integrated secondary lock into the locked position with a DT-RT1 or a screwdriver.

CONTACT REMOVAL



STEP 1:

Using a DT-RT1 or a screwdriver, unlock the integrated secondary lock.



STEP 2:

Using the appropriate extraction tool, insert the blades into the contact cavity until they stop.



STEP 3:

Pull contact wire assembly out of connector.

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