

# Amphenol

TB-2058

MALE BLADE CONTACT INSERTION TOOL (002 LENGTH BLADE)  
FOR M1000, M1001, M1200, M1201, M1500, AND M1501 SERIES  
PART NO. 600-0663-000

REVISION “-”

## SPECIFICATION REVISION STATUS

<u>Revision</u>	<u>SCR No.</u>	<u>Description</u>	<u>Initial</u>	<u>Date</u>
“-”	26418	Initial Release (Supersedes TB-230)	H. Cook	12-18-98

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1.0 SCOPE

- 1.1 This technical bulletin covers Male Blade Contact Insertion Tools (002 Length Blade) for M1000, M1001, M1200, M1201, M1500, and M1501 Series, Part No. 600-0663-000.

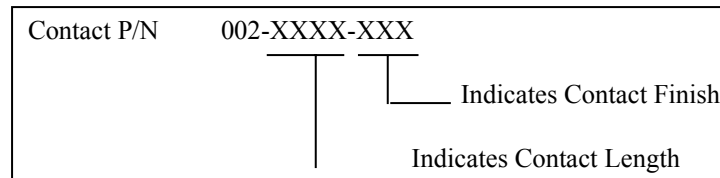
2.0 PROCEDURE

- 2.1 Intended Use – For insertion of replacement contacts into vacated contact positions in extruded aluminum body connectors (headers).

## 2.2 Method of Use

- 2.2.1 Be certain that the new contacts and insulators are the correct replacement part.

## 2.2.1.1 Contact



## 2.2.1.2 Insulator

Part No.	Series
304-0001-002	M1000, M1001
305-0001-002	M1200, M1201
307-0001-002	M1500, M1501

- 2.2.2 Support connector body with blade end of contact facing up. If connector is two row, with bent contacts and contact is to be inserted into first row, bend the contact in the second row 90° to a straight position. This will allow room for the new contact to be inserted. A three row connector must be treated similarly when inserting new contacts in first or second row. The connector should rest on parallel supports to give maximum support while protecting contact tails. The face of the supports should be covered with a protective material such as masking tape to prevent damage to the connector.
- 2.2.3 Place contact into insulator.
- 2.2.4 Orient contact/insulator assembly into vacant hole.

- 2.2.5 Insert the tip of the insertion tool over the fork of the new contact.
- 2.2.6 Hold the tool so that it is perpendicular to the connector in all planes and also so that the blade is in line with any other contacts in the same row.
- 2.2.7 Press the tool down gently but firmly until the contact is fully seated.
- 2.2.8 Bend or rebend contacts as required. Use Tool No. 600-0001-000.
- 2.2.9 Inspect for the following:
- 2.2.9.1 Contact is properly seated.
  - 2.2.9.2 Contact is properly aligned with respect to the other contacts in the row.
  - 2.2.9.3 Contact finish has not been scraped during insertion.
- NOTE: This tool is not intended for production use. Rows of contacts inserted by this tool do not, therefore, reflect the integrity of alignment made possible by volume production tools.

