

M O L E X  
AM-60512 I.D.T. DIE  
OPERATING MANUAL

The Molex hand tool AM-60512 is designed exclusively for the 70156 power connector. This tool features IDT termination and feed-to/feed-through capability.

## OPERATION

The 70156 connector may be inserted into the tool two different ways. This ambiguity can be cleared if the operator notices that the connector has a colored stripe (and/or a bump between the first and second IDT contacts) on one side. The operator must be aware of this to correctly assemble a harness.

The AM-60512 hand tool operates in one of two modes: "feed-to" in which the connector is at the end of a harness or "feed-through" in which the connector is within a harness (daisy-chain configuration).

**Feed-To Operation:** Insert a connector, in the proper orientation, into the tool. Push the connector all the way in until it stops. On the bottom of the tool there is a 1/8" diameter pin. Pull this pin towards the gun until it stops. This action moves a wire stop into place so wires cannot be fed past the connector. Obtain a wire and insert it through the slot in the guard and into the tool. Notice that the wire stop prevents the operator from pushing the wire past the connector. Actuate the lever on the gun. Repeat this process for the other three wires. It is best to do the feed-to operation one wire at a time. It can become rather awkward to try to hold four wires simultaneously for mass termination.

The feed-to harness may be removed from the tool by gently pulling on the wires.

**Feed-Through Operation:** Insert a connector in the proper orientation into the tool. Push the connector all the way in until it stops. Be sure the wire stop (used in the feed-to operation) is disengaged: push the 1/8" diameter pin (on the bottom of the tool) away from the gun. Obtain four wires and insert them through the slots in the guards, one wire per slot. Actuate the lever on the gun. Mass termination is possible in the feed-through operation since four wires are available (and are held by the feed-to connector).

The feed-through harness may be removed from the tool by gently pulling on the wires.

#### **ADJUSTMENT**

The depth to which the wire is inserted may be adjusted in this tool. Remove the tool from the gun. There is a set screw on the tool which contacts the gun's plunger. Turning this set screw counter-clockwise causes the wire to be inserted deeper into the connector. Turning the set screw clockwise produces an opposite effect. If the set screw is excessively turned counter-clockwise it will protrude into the rectangular cut-out and it will be impossible to install the tool onto the gun.

The feed-to operation is performed one wire at a time. Sometimes the actuation of the tool will disengage the wire stop. On the sides of the tool (above the 1/8" diameter pin) there are two small screws. These are detents for the wire stop. Turning these screws clockwise will solve the disengagement problem. If they are turned too far the wire stop will jam.