

OPERATING INSTRUCTIONS



11-7364 BENCH TYPE INSERTION TOOL AND ACCESSORY ATTACHMENTS

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Form L-632

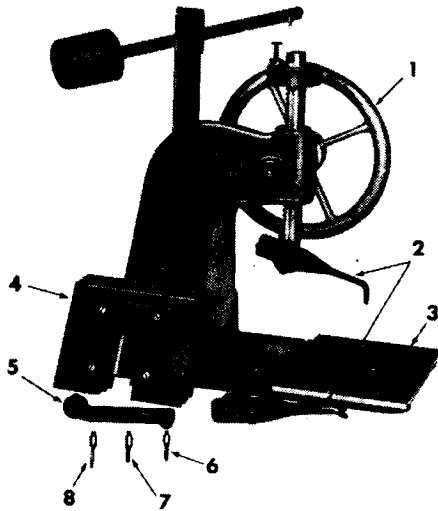


Figure 1. 11-7364 Insertion Tool and Some of the Available Accessory Parts.

The Bendix 11-7364 Bench Type Insertion Tool is designed to aid in the insertion or removal of size 16 through size 0 standard AN and Bendix proprietary type "F" contacts. Various accessories are available (see Tables I, II and III for complete listing) to adapt the

Legend for Figure 1.

1. 11-7364 Insertion Tool.
2. 11-7365-XX Insertion Tool Assy.
3. 11-7664 Back-up Plate Assy.
4. 11-7371-XX Adapter Plates.
5. 11-7369 Holder - Consisting of:
11-7673 Adapter
11-7672 Holder Body
6. 11-3696 Contact Remover (Size 12 AN Pin).
7. 11-3697 Contact Remover (Size 16 AN Pin).
8. 11-3698 Contact Remover (Size 12 and 16 Sockets).

basic insertion tool to the desired contact size.

The basic 11-7364 Insertion Tool is a modified arbor press incorporating a counter-balance and an adjustable stop on the ram. Once the proper adapting accessories have been secured to the Insertion Tool and the ram stop has been properly adjusted, insertion and/or removal of large sizes and quantities of contacts becomes a quick and easy procedure. Insertion of the contact is made in one step, and because of the adjustable stop on ram, all contacts are seated to the same depth.

INSTALLATION

Securely mount the 11-7364 Insertion Tool on a bench so that the cutout in front of

mounting plate extends out over the bench.

TABLE I

Accessories for Use with 11-7364 Tool for Inserting Contacts.

Contact		Insertion Tool Assy P/N	Back-Up Plate Assy
Size	Type		
16	AN Standard & Type "F"	11-7365-1	11-7664
12	AN Standard & Type "F"	11-7365-2	11-7664
8	AN Standard & Type "F"	11-7365-3	11-7664
4	AN Standard & Type "F"	11-7365-4	11-7664
0	AN Standard & Type "F"	11-7365-5	11-7664

CONTACT INSERTION

Loosen the set screw in the ram of the 11-7364 Insertion Tool and install the proper size 11-7365 Insertion Tool in the ram. See Table I. Re-tighten the set screw.

Note

When installing the 11-7365-5 Insertion Tool Assembly (for size 0 contacts) in the 11-7364 Tool, rotate the assembly approximately 45° from the normal position shown in figure 2. This rotation is necessary to provide clearance for the cam lever handle.

Position the 11-7664 Backup Plate over the cutout in mounting plate of 11-7364 Insertion Tool. Place connector on the backup plate.

The large stop ring on the top of the 11-7364 Insertion Tool ram must be adjusted so the contacts for the applicable connector will be seated to the proper depth. To move the stop ring, loosen the set screw on back of collar and slide collar up ram thus providing access to the ram stop. Remove the ram stop and set it in the desired notch. Slide the collar back over the ram stop and retighten the set screw.

Fine adjustment of the ram stop is provided by a stop nut on the collar. This stop nut can be turned up or down to obtain desired ram travel distance.

To insert contact in connector, place the wire well end of contact in the tip of the proper dash number of the 11-7365 Insertion Tool, see figure 3, and push cam lever of tool closed. Position contact in proper insert hole and apply pressure as shown in figure 2 until contact is properly seated.

CAUTION

Do not allow connector to tip when inserting contacts as damage to insert and/or contacts may result.

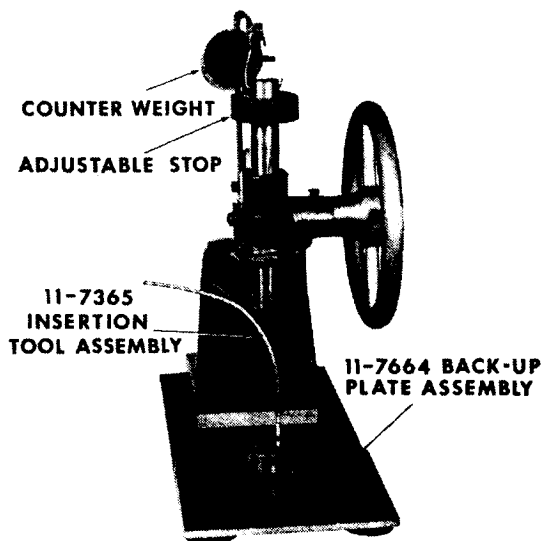


Figure 2. Inserting Contact.

Note

Neosol or proprietary denatured ethyl alcohol is recommended as a lubricant to assist in contact insertion.

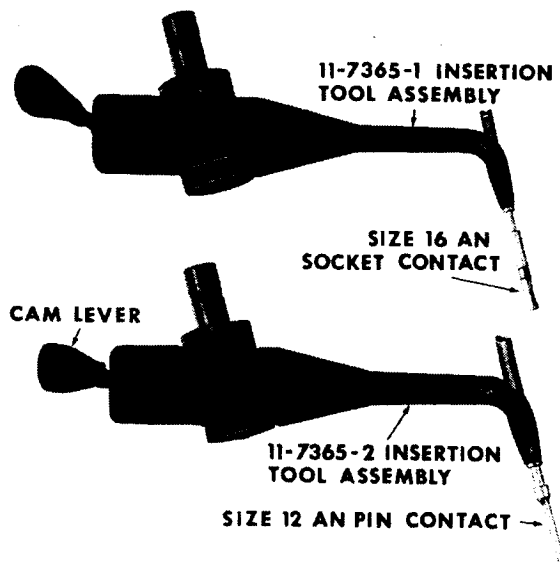


Figure 3. 11-7365 Insertion Tool Assembly.

TABLE II

Removal Tool to be Used With 11-7364 Tool for Removing Contacts.

Removal Tool P/N	Pin (P) or Socket (S)	Contact	
		Size	Type
11-3696	P	12	AN Standard & Type "F"
11-3697	P	16	AN Standard & Type "F"
11-3698	S	16 & 12	AN Standard & Type "F"
11-7370-3	P	8	AN Standard & Type "F"
11-7370-4	P	4	AN Standard & Type "F"
11-7370-5	P	0	AN Standard & Type "F"
11-7674-1	S	8	AN Standard & Type "F"
11-7674-2	S	4	AN Standard & Type "F"
11-7674-3	S	0	AN Standard & Type "F"

CONTACT REMOVAL

Loosen set screw in ram of 11-7364 Bench Type Insertion Tool and install the 11-7369 Holder in ram. Re-tighten set screw. See figure 4.

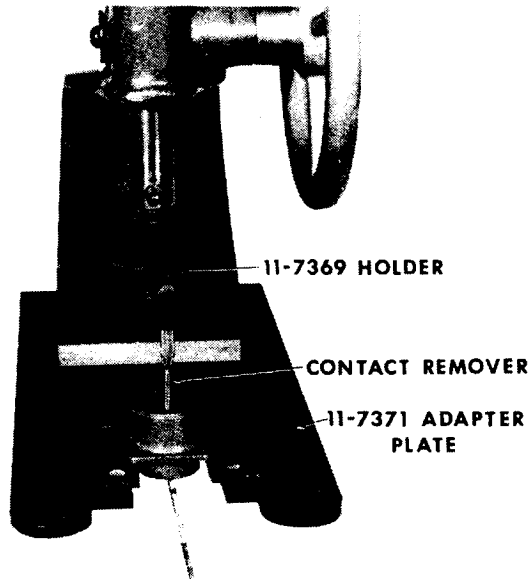


Figure 4. Removing Contacts.

Select the proper size contact removal tool using Table II as a guide, and thread removal tool into the threaded adapter of the 11-7369 Holder. Position the proper 11-7371 Adapter Plate (see Table III) over the cutout in base of 11-7364 Tool.

Place the connector on the adapter plate rear face down. Adjust stop on ram so it will provide sufficient ram travel to push contact back out of seated position by approximately 3/8 to 1/4 inch.

To adjust stop, loosen the set screw on back of collar and slide collar up ram thus providing access to the ram stop. Remove the ram stop and set it in the desired notch. Slide collar

back over the ram stop and re-tighten the set screw. Fine adjustment of ram stop is provided by a stop nut on the collar. This stop nut can be turned up or down to obtain desired ram travel distance.

Align the removal tool with the connector contact to be removed. Apply pressure on contact until it is unseated. Working from rear of connector assembly, pull wire and contact free from insert. See figure 4.

CAUTION

Do not allow connector to tip during contact removal procedures as damage to insert and/or contacts may result.

TABLE III

Adapter Plate to be Used with 11-7364 Tool for Removing Contacts.

Adapter Plate Part No.	Shell Size
11-7371-8	8S
11-7371-10	10S
11-7371-12	10SL, 12S, 12
11-7371-14	14S, 14
11-7371-16	16S, 16
11-7371-18	18
11-7371-20	20
11-7371-22	22
11-7371-24	24
11-7371-28	28
11-7371-32	32
11-7371-36	36
11-7371-40	40
11-7371-44	44
11-7371-48	48

INSPECTION

Periodically check the 11-7364 Insertion Tool and accessory attachments for distortion, mutilation or breakage. Replace damaged parts.

Check the clamping action of 11-7365 Insertion Tool Assembly tips to assure that contacts are being firmly held. To perform check, use a check pin in accordance with Table IV. Close the cam lever so the tool tips are in their fully locked position. The check pin should not pass through hole in tool tips. If tool is worn or sprung, it should be replaced.

TABLE IV

Insertion Tool Assembly P/N	Contact Size	Check Pin ± 0.001
11-7365-1	16	0.093
11-7365-2	12	0.125
11-7365-3	8	0.218
11-7365-4	4	0.343
11-7365-5	0	0.515