

**PROPER USE GUIDELINES**

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.

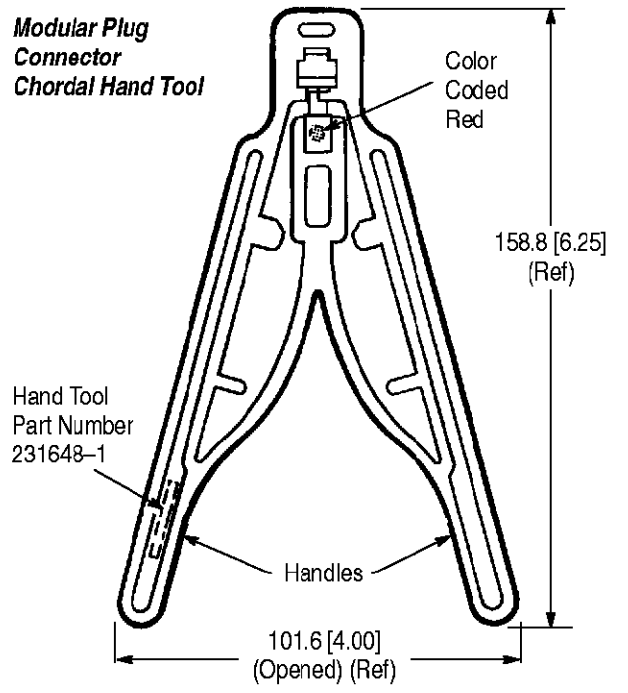


Figure 1

**1. INTRODUCTION**

This instruction sheet covers the AMP\* Modular Plug Connector Chordal Hand Tool 231648-1 and 231648-2. The tool is designed to strip cable jacket insulation and terminate loose piece 2-, 4-, and 6-position line cord modular plug connectors. Read these instructions thoroughly before using the tools.

**NOTE** Please note that part number 231648-2 is Chordal Hand Tool 231648-1 packaged differently.

**NOTE** Measurements are in millimeters [followed by inch equivalents in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

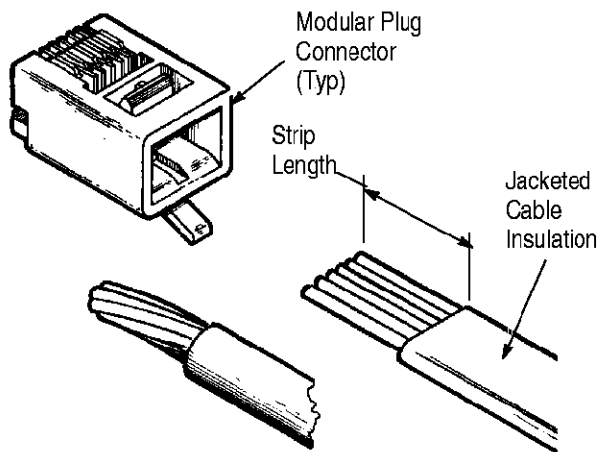
Reasons for reissue of this document are provided in Section 7, REVISION SUMMARY.

**2. DESCRIPTION**

The tool is molded of black plastic and features preset, non-replaceable, cable jacket stripper and connector termination dies. Hand tool part number 231648-1 is located on the handle as shown in Figure 1.

**3. CABLE SPECIFICATIONS**

Refer to the table in Figure 2 for the recommended cable and conductor dimensions and the specified cable jacket strip length. Make sure cable has the appropriate number of conductors for the connector size to be terminated.



MODULAR PLUG CONNECTOR TYPE	JACKETED CABLE	
	TYPE	STRIP LENGTH
2-, 4-, and 6-Position Line	Round or Oval	6.35 - 7.14 [.25 to .28]

Figure 2

**4. CABLE TERMINATION**

1. Trim cable end flush. See Figure 3.

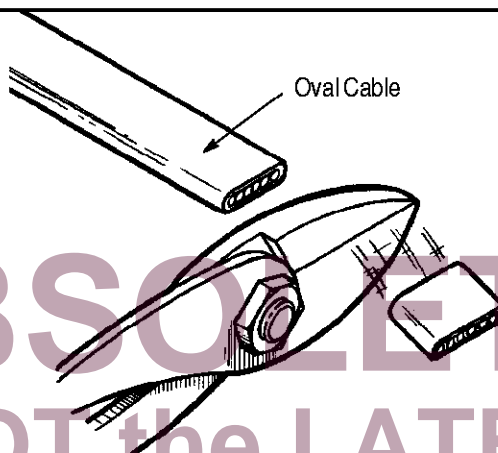


Figure 3

OBSOLETE  
NOT the LATEST REVISION

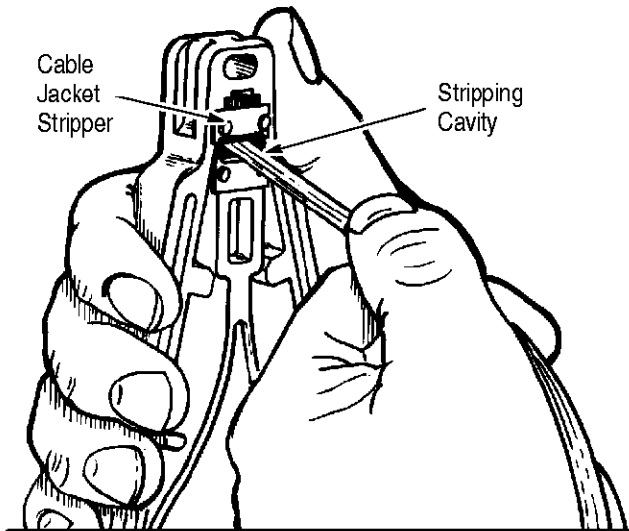


Figure 4

2. Hold tool as shown in Figure 4 and insert cable into stripping cavity.
3. Hold cable against stop and squeeze tool handles together. Strip cable jacket by pulling cable STRAIGHT out of cavity.
4. Allow tool handles to open to remove stripped cable jacket end from cavity.
5. Insert conductors into wire slots in connector until wires fully bottom. Be sure to maintain proper conductor polarity for application. See Figure 5.

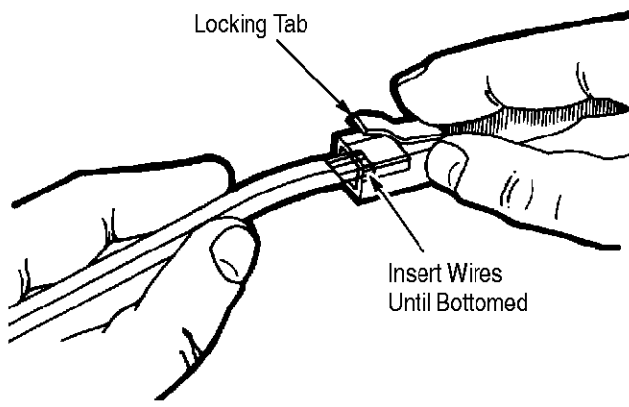


Figure 5

6. Insert modular plug connector – TAB UP – into die set. LOCKING TAB MUST SNAP INTO CAVITY. See Figure 6.
7. Squeeze tool handles together until movable anvil is completely bottomed. Two “clicks” or “snaps” should be heard or felt.

8. Allow tool handles to open fully, depress locking tab on connector, and remove terminated connector.

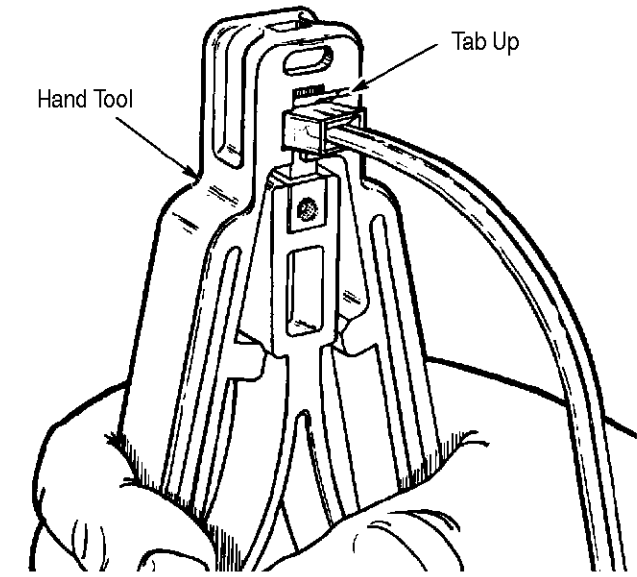


Figure 6

## 5. TOOL INSPECTION

Modular Plug Connector Chordal Hand Tool 231648-1 and 231648-2 should be verified with the dimensions provided in Figure 1. It is recommended that each tool be inspected immediately upon arrival at your facility to ensure that the tool has not been damaged during shipment.

## 6. ORDERING INFORMATION

Additional hand tools can be ordered through your Tyco representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (38-35)  
TYCO ELECTRONICS CORPORATION  
P.O. BOX 3608  
HARRISBURG, PA 17105-3608

## 7. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made per EC 0990-0748-00:

- Added Hand Tool 231648-2
- Updated document to corporate requirements and new format
- Added metric dimensioning