

AMPAMP INCORPORATED
HARRISBURG, PA 17105**AMPACT* CLEANING TOOL 314199-1****IS 9494**

RELEASED

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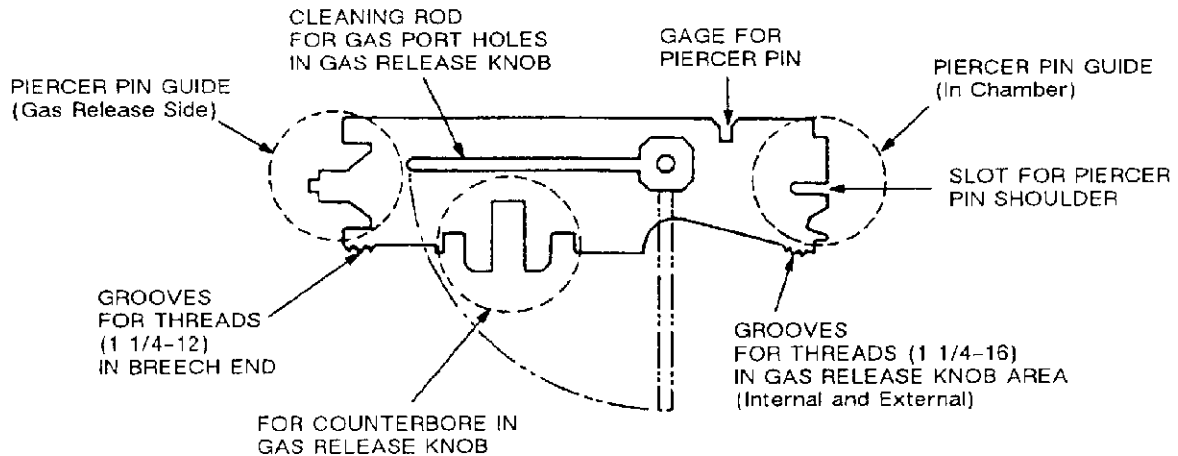
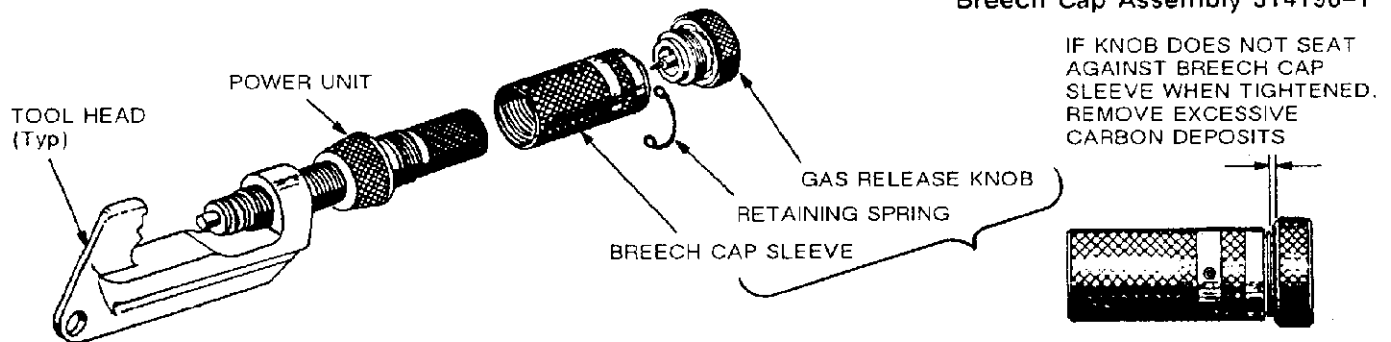
FEATURES OF AMPACT CLEANING TOOL 314199-1**AMPACT Application Tools 69611 and 69437 (Ref)****Breech Cap Assembly 314196-1**

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMPACT Cleaning Tool 314199-1 shown in Figure 1. This multipurpose tool is used to clean carbon and plastic deposits that build up inside the breech cap assembly during normal use of AMPACT Application Tools 69611 (large head) and 69437 (small head). The cleaning tool can also be used to gage piercer pin length in the gas release knob.

Refer to AMP* Customer Manual CM 2106 concerning the use of AMPACT taps, stirrups, and application tooling. Read these instructions and other references thoroughly before proceeding.

2. DESCRIPTION

Figure 1 identifies sections of the all-metal tool and the purposes they serve: grooves (two sizes) to clean interior and exterior threads in the breech cap assembly, a folding rod to clean gas release ports, three contoured sections to clean specific recesses and surfaces in the breech cap sleeve and gas release knob, and a gaging slot to check piercer pin length.

3. CLEANING AND GAGING PROCEDURES

Unscrew the breech cap assembly from the power unit as shown in Figure 1 and proceed as follows:

A. Cleaning the Gas Release Knob

1. Pry one end of retaining spring out of slot in breech cap assembly, using screwdriver or end of tool. Remove retaining spring and unscrew gas release knob. See Figure 1.

2. Dislodge compressed deposits by positioning cleaning tool against counterbore and piercer pin as shown in Figure 2. Rotate tool until all surfaces are clean.

3. Clean exterior threads (1 1/4-16) on gas release knob as shown in Figure 3. Using correct section of cleaning tool, align grooves in the tool with threads in the knob. Rotate until threads are clean.

4. Unfold cleaning rod and clean carbon deposits from holes in gas release knob by rotating rod several times in each hole. See Figure 4.

NOTE

If holes are blocked or reduced in size from peening action of hammer blows, return the entire breech cap assembly for replacement or repairs.

5. Before gaging piercer pin length, clean carbon deposits from base of piercer pin, using slot in tool as shown in Figure 5.

6. Gage piercer pin length as shown in Figure 6. If pin passes through slot in gage, return the entire breech cap assembly for repair or replacement.

7. Coat all cleaned surfaces and threads on gas release knob with solvent.

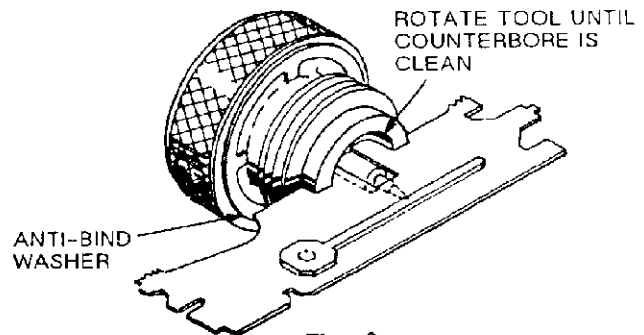


Fig. 2

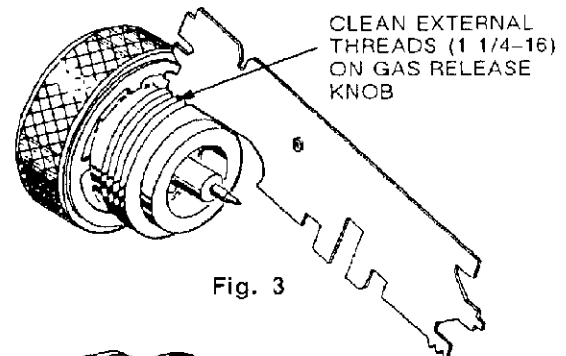


Fig. 3

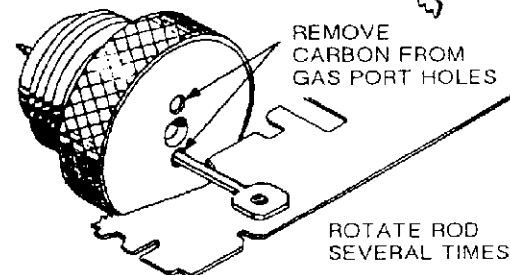


Fig. 4

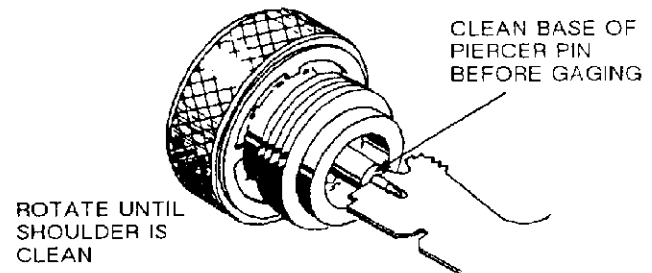


Fig. 5

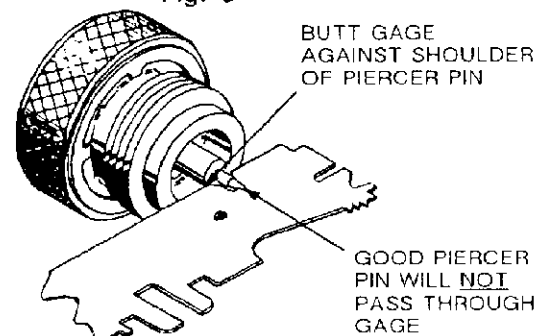


Fig. 6

B. Cleaning Breech Cap Sleeve

1. Insert correct end of cleaning tool into gas release end of sleeve. Rotate tool until piercer pin guide and surfaces shown in Figure 7 are clean. If pin guide hole is oval or worn, return entire breech cap assembly for replacement or repair.

2. To clean interior threads (1 1/4-16) in gas release end of sleeve, tilt correct end of cleaning tool and insert into sleeve. Make sure that grooves in tool are aligned with sleeve threads, as shown in Figure 8. Rotate tool until threaded surfaces are clean.

3. To clean breech end, insert correct end of cleaning tool into front end of sleeve as shown in Figure 9. Rotate tool until recessed surface is clean.

4. To clean interior threads (1 1/4-12) in the breech end, insert correct end of cleaning tool into sleeve as shown in Figure 10. Make sure tool grooves are aligned with threads in breech sleeve. Rotate tool until an adequate threaded area is clean.

5. Coat all cleaned surfaces and threads with solvent. Screw gas release knob with anti-bind washer into breech cap sleeve until it bottoms.

6. Install retaining spring by placing one end of loop into slot in breech cap sleeve. Slide other loop into groove and snap spring into place.

7. Unscrew gas release knob against retaining spring loops to ensure that they are properly seated.

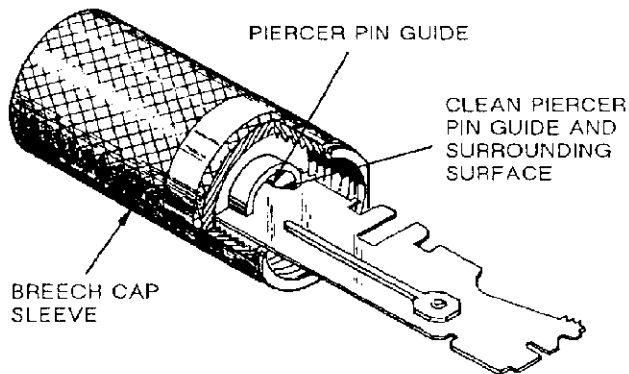


Fig. 7

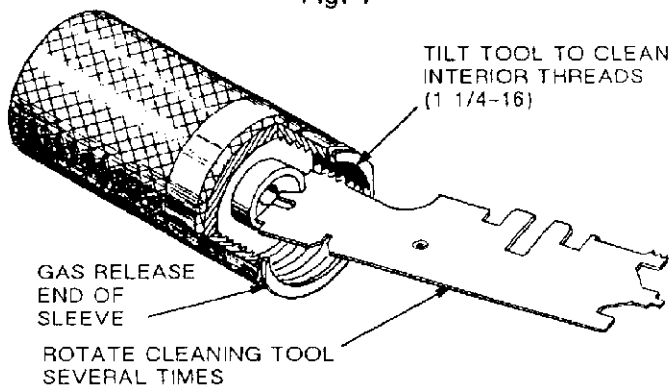


Fig. 8

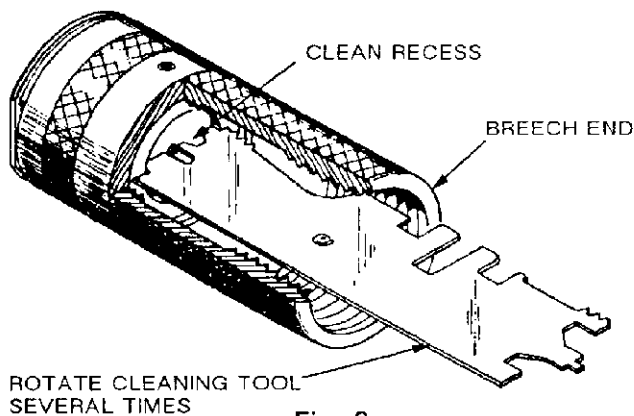


Fig. 9

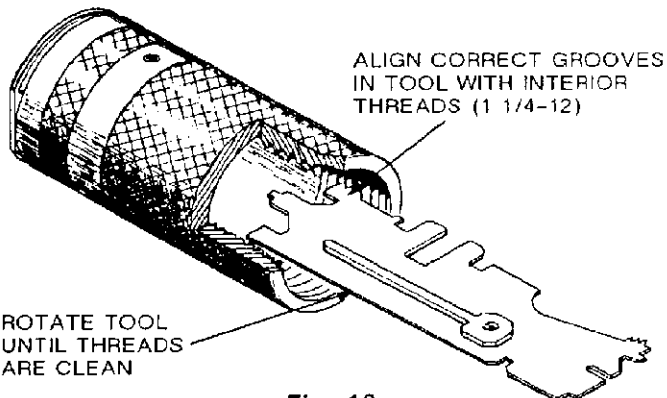


Fig. 10

NOTE

To order additional cleaning tools, contact your AMP Field Representative or local AMP distribution center.