

1. INTRODUCTION

The following information should be immediately disseminated to your field personnel who are using the AMPACT tool with THREE color-coded grooves around the coupling front. Those three color grooves are YELLOW, BLUE, and RED, in that order. This sheet is also a supplement to Customer Manual 409-2106, and applies to the AMPACT Tool which has THREE color coded grooves around the coupling front. This sheet also sets forth important, specific information and instructions.



Operation (firing) of an AMPACT tool with three color-coded grooves around the coupling front having a broken "Fail Safe," may cause separation of the breech assembly and coupling nut from the coupling, which could result in serious personal injury or property damage

The "Fail Safe" is designed to make the AMPACT tool inoperable when it is broken by allowing the coupling nut to turn so that the power unit cannot be screwed onto or within the tool head.

An AMPACT tool should never be operated with a broken "Fail Safe." A broken "Fail Safe" can be detected by (1) a simple push-and-turn and pull-and-turn test to check if the coupling and coupling nut are jammed together or if the coupling nut can be turned more than 4° (about 3.2 mm [1/8 inch]), and (2) two simple visual inspections.

The following tests and inspections can be easily performed in less than a minute. Any AMPACT tool with a broken "Fail Safe" should be returned immediately to Tyco Electronics. See page 4 for addresses.

It is essential to perform the following tests and inspections EACH TIME BEFORE tool preparation and the insertion of a shell when you use AMPACT tool 69437, AMPACT tool 69611, and Power Unit 69612 with THREE color coded grooves around the coupling front. These tests and inspections are to be performed on a *daily* basis for tools with four color coded grooves. See customer manual 409-2106, for further details. For copies of customer manual 409-2106, or of this document 408-9907; call the Energy Division Customer Service Center at 1-800-327-6966.

Contact your local Tyco Electronics representative for assistance with returning or obtaining replacement AMPACT tools.

2. TOOL PREPARATION

Before performing the following tests and inspections, prepare the tool as follows:

Unscrew the power unit in the tool head so that the red, blue, and yellow lines on the coupling remain visible, with the red marking flush against the tool head. This position is known as the fully-retracted position. Refer to Figure 1. Do NOT remove the power unit from the tool head.

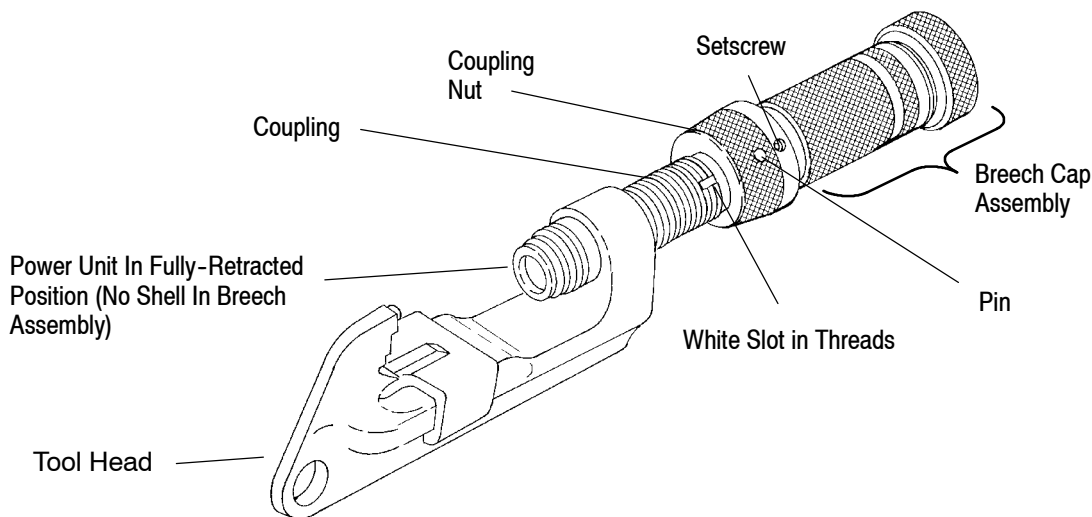


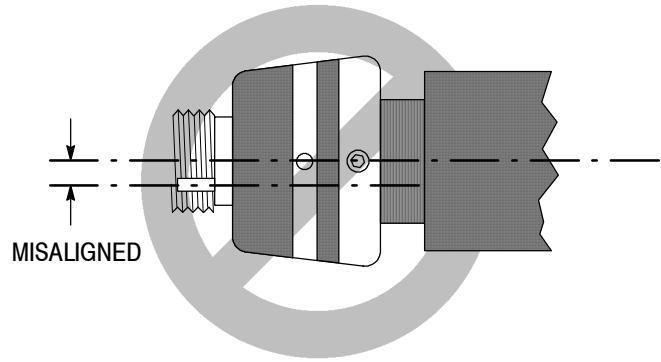
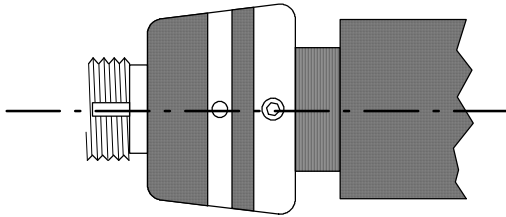
Figure 1

3. INITIAL VISUAL INSPECTION (Figure 2)

PASS Slot Aligned With Pin and Setscrew on Coupling Nut



FAIL Slot Not Aligned With Pin And Setscrew on Coupling Nut. "Fail Safe" Is Broken. **DO NOT FIRE TOOL**



PASS Coupling Taper Does Not Extend Beyond Coupling Nut



FAIL Coupling Taper Extends Beyond Coupling Nut. "Fail Safe" Is Broken. **DO NOT FIRE TOOL**

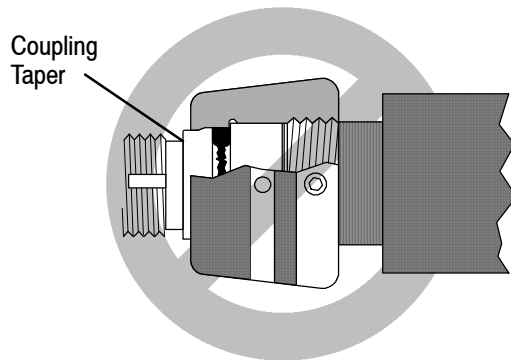
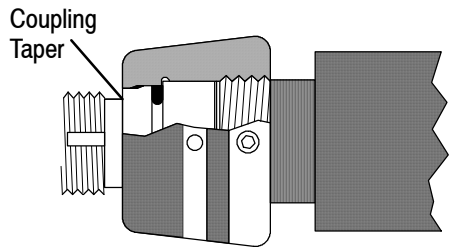
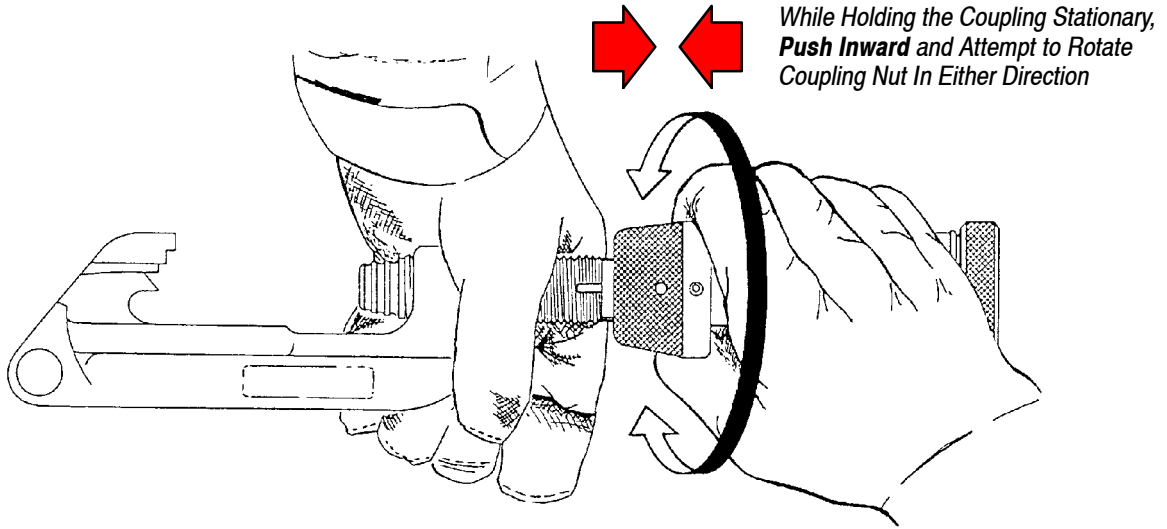


Figure 2

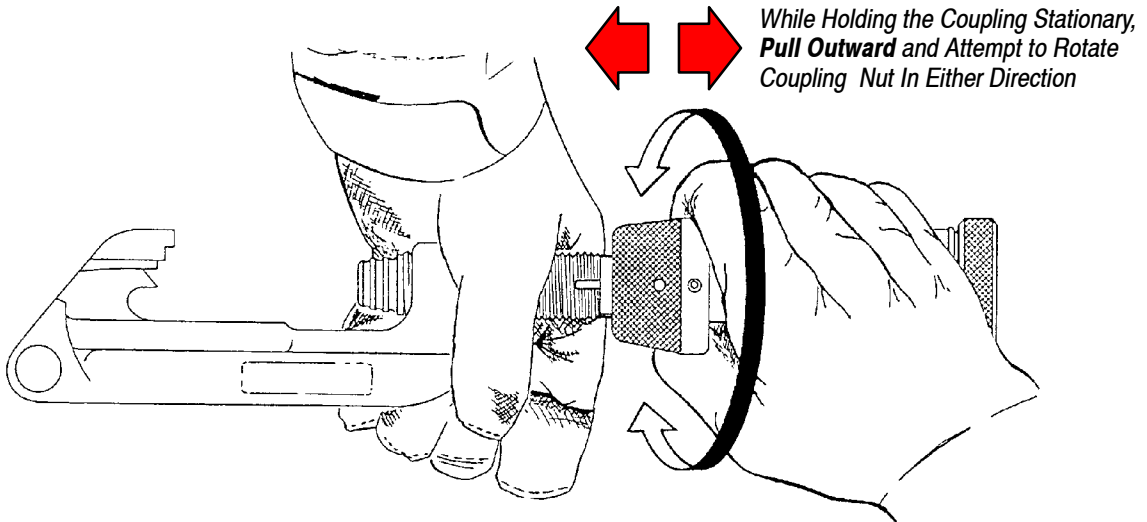
3.1. Push- and-Turn Inspection (Figure 3)



If Coupling Nut and Coupling Are Jammed Together and Cannot Be Moved At All, OR If Coupling Nut Turns More Than 4° (Approx 3.2 mm [1/8 Inch]), The "Fail Safe" Is Broken. **DO NOT FIRE THE TOOL.**

Figure 3

3.2. Pull- and-Turn Inspection (Figure 4)



If Coupling Nut and Coupling Are Jammed Together and Cannot Be Moved At All, OR If Coupling Nut Turns More Than 4° (Approx 3.2 mm [1/8 Inch]), The "Fail Safe" Is Broken. **DO NOT FIRE THE TOOL.**

Figure 4

3.3. Final Visual Inspection - Coupling Taper (Figure 5)



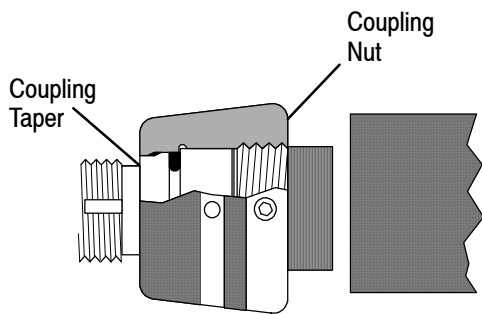
This inspection is used to check if the part of the coupling called the “coupling taper” extends past the coupling nut.

1. Refer to Figure 5 and locate the surface of the front of the coupling nut and the coupling facing the tool head. Also locate the “coupling taper,” which is the part of the coupling that should be covered by

the coupling nut. The coupling taper is smooth and rounded, and is also the same height as the top height of the threads on the coupling.

2. Compare the surfaces of the coupling taper and the coupling nut. If ANY portion of the coupling taper extends beyond the face of the coupling nut (refer to Figure 5), **DO NOT USE THE AMPACT TOOL - RETURN THE POWER UNIT IMMEDIATELY TO AMP INCORPORATED FOR REPLACEMENT.**

PASS Coupling Taper Does Not Extend Beyond Coupling Nut



FAIL Coupling Taper Extends Beyond Coupling Nut. “Fail Safe” Is Broken. **DO NOT FIRE TOOL**

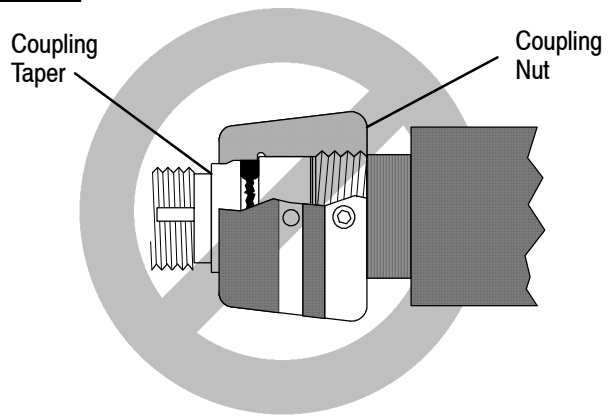


Figure 5



*If you are not sure whether your AMPACT tool passes these inspections, **DO NOT FIRE THE TOOL.** Return the power unit immediately to Tyco Electronics for evaluation and/or replacement.*

For telephone assistance, call the Energy Division Customer Service Center: 1-800-327-6966.

4. TOOL RETURN OR REPLACEMENT

In the U.S., return tools to:

TYCO ELECTRONICS
ENERGY DIVISION
8009 PURFOY ROAD
FUQUAY-VARINA NC 27526
ATTN: AMPACT TOOL REPAIR

In Canada, return tools to:

TYCO ELECTRONICS CANADA LTD
20 ESNA PARK DRIVE
MARKHAM ONTARIO
CANADA L3R 1E1
ATTN: AMPACT TOOL REPAIR, ENERGY
DIVISION, BUILDING 1

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed the Tyco Electronics contact phone numbers;
- Changed the Tyco Electronics return addresses;
- Applied the TE logo; and
- Updated the format to the current corporate requirements