Seating Tool 318866–1 and Support Anvil 318867–1 for Z–PACK* 2mm HM Connectors with ACTION PIN* Contacts

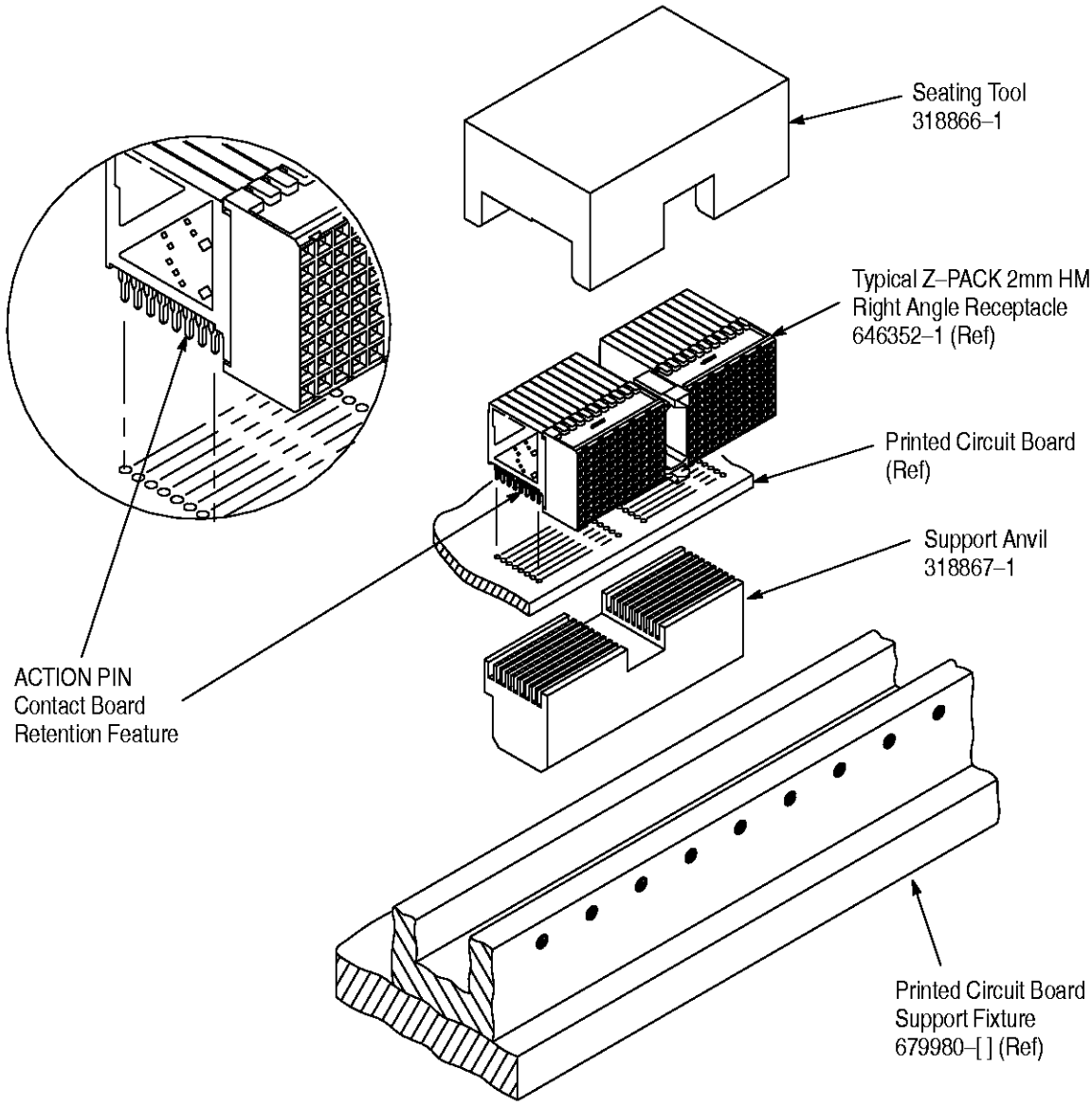


Figure 1

1. INTRODUCTION

This instruction sheet covers the use and maintenance of AMP* Seating Tool 318866–1 and Support Anvil 318867–1. The tool and anvil are used to seat Z–PACK 2mm HM connectors. The connectors contain ACTION PIN contacts to allow solderless printed circuit (pc) board installation. See Figure 1.

NOTE *All dimensions on this document are in metric units [with U.S. customary units in brackets].*

Read these instructions and understand them before using the seating tool and support anvil.

Reasons for reissue are provided in Section 8, REVISION SUMMARY.

2. DESCRIPTION

The seating tool and support anvil are each a one–piece aluminum design.

During seating, the seating tool covers the connector and presses on the top surface of the connector when the applicator ram applies force to the seating tool. The support anvil is positioned into a pc board support fixture to support the pc board.

3. REQUIREMENTS

3.1. PC Board Support Fixture

A pc board support must be used to provide proper support for the pc board and alignment of the tool to the receptacle pins, and to protect the pc board and connector contacts from damage. AMP PC Board Support Fixture 679980–[ ] is available and recommended for use with this seating tool and support anvil. For proper selection and detailed information, refer to instruction sheet 408–4038.

NOTE *As an alternative, you can design a pc board support fixture for your specific needs, using the recommendations in 408–6927.*

3.2. Application Tooling

Power for seating tool must be provided by a machine capable of supplying a downward force of 89 Newtons (N) [20 lb] per contact. You may use AMP 10/20–Ton "H"–Frame Assembly 803880–6 (Customer Manual 409–5567 provides instructions) or AMP SM–3 Frame Assembly 814700–2 (409–5626).

4. SEATING

1. Set seating height to the dimension shown in Figure 2. (Applicator *shut height* will equal the seating height PLUS the combined thicknesses of the pc board, support anvil, and pc board support.)

2. Position support anvil, grooved side up, into the pc board support fixture and center it under the applicator ram of the power source. Position pc board with receptacle over support anvil.

3. Position connector onto pc board so that connector contacts are properly aligned to the pc board and support anvil. See Figure 2.

4. Insert contacts into pc board until ACTION PIN section of the contacts are resting securely on, but have not fully entered, the pc board.

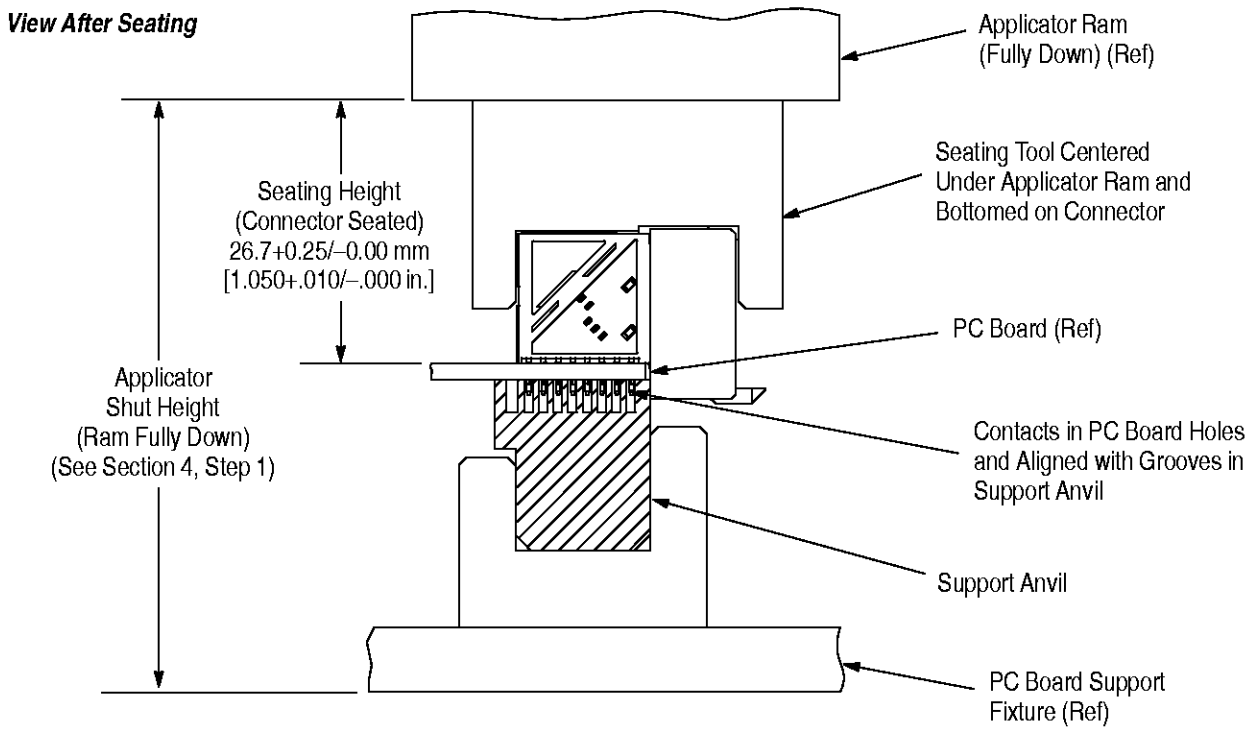
5. Position the seating tool onto the connector.

6. Center seating tool and connector under the applicator ram of the power source; slowly lower ram until it just meets the seating tool. Verify the alignment of the board support, pc board, connector, seating tool, and support anvil.

CAUTION *Damage to the pc board, seating tool, or connector may occur if seating height is improperly set, if pc board is not properly positioned over the support anvil, or if tool is not properly seated on the connector before cycling the applicator ram.*

7. Cycle applicator ram according to instructions for the power source. Check assembly for proper seating using the requirements in Figure 2.

8. Remove pc board with seated connector, or reposition board and board support for seating additional connectors.



Note: Not to scale.

Figure 2

5. TOOL INSPECTION

The seating tool and support anvil are inspected before shipment. It is recommended that the tool and anvil be inspected, using Figure 3, immediately upon its arrival at your plant to ensure that it has not been damaged during shipment.

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to supervisory personnel responsible for the tool. The inspection frequency should be based on the amount of use, working conditions, operator training and skill, and established company standards.

6. MAINTENANCE

It is recommended that each operator be made aware of, and responsible for, the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean, soft brush, or lint–free cloth. Do NOT use objects that could damage the tool or the anvil.

2. When the tool or anvil are not in use, store them in a clean, dry area.

7. ORDERING INFORMATION AND REPAIR

Order additional tools and anvils through your AMP 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 (038–035)
AMP INCORPORATED
PO BOX 3608
HARRISBURG PA 17105–3608

Tools and anvils may be returned to AMP for evaluation and repair. For repairs, send tool and anvil, with a written description of the problem, to:

CUSTOMER REPAIR (01–12)
AMP INCORPORATED
1523 NORTH 4TH STREET
HARRISBURG PA 17102–1604

8. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made:

Per EC 0990–1443–98

- Updated Figures 1 and 2 to show pre–attached shield
- Removed connector part numbers in Section 1
- Changed downward force from 133 Newtons to 89 Newtons in Paragraph 3.2

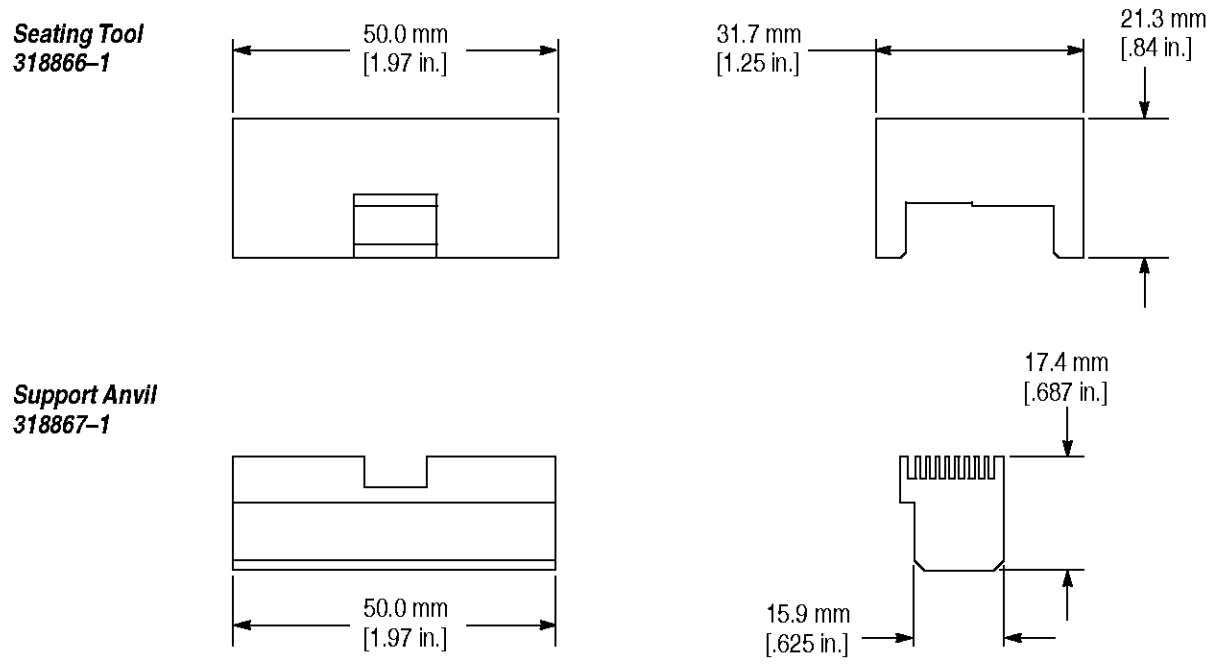


Figure 3