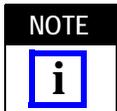


Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly of the AMPLIMITE Connector Cassette and Holder Kits shown in Figure 1. The kits are used to construct cassette and holder units for various applications.

Read these instructions thoroughly before starting assembly.



*Dimensions on this instruction sheet are in inches.*

Reasons for revision are contained in Section 5, REVISION SUMMARY.

## 2. DESCRIPTION

These units provide an interface between magnetic-bubble memories or semiconductor read only memories (ROM) and computer-controlled equipment. The cassettes are available in kits of standard and long sizes. The kits (cassettes and holders) are capable of continuous mating and unmating without loss of mechanical or electrical integrity. Significant features of the assembled cassette and holder units include ease of assembly, quick mating/unmating capability, program protection, and program-mode indication.

The cassette kits consist of a top cover with locking latches, a bottom cover with locking tabs, a write/protect switch, a 33-position receptacle contact connector, and a face plate. These items, when assembled, house the customer-supplied printed circuit board memory assembly. The face plate features three polarizing slots which provide keying. The keying feature eliminates insertion of an incorrect cassette into a holder. The write/protect switch is used to select a program (write) or protect (read only) access to a programmed memory. See Figure 1 and Figure 3.

The holder kits consists of a main body, a panel-mount cover, and a 33-position pin contact connector. The panel-mount cover features three polarizing guides which provide keying and thereby prevent insertion of an undesired cassette. The panel-mount cover also has provisions for light-emitting diodes (LEDs) which are used to indicate a functioning mode.

## 3. ASSEMBLY PROCEDURE

The two connectors in the units are designed to be installed on a .062-in.-thick pc boards. The size of cassette pc board is regulated by the interior dimensions of the cassette. The only limitation placed on the holder pc board is in the location of the connector relative to the edge of the pc board.

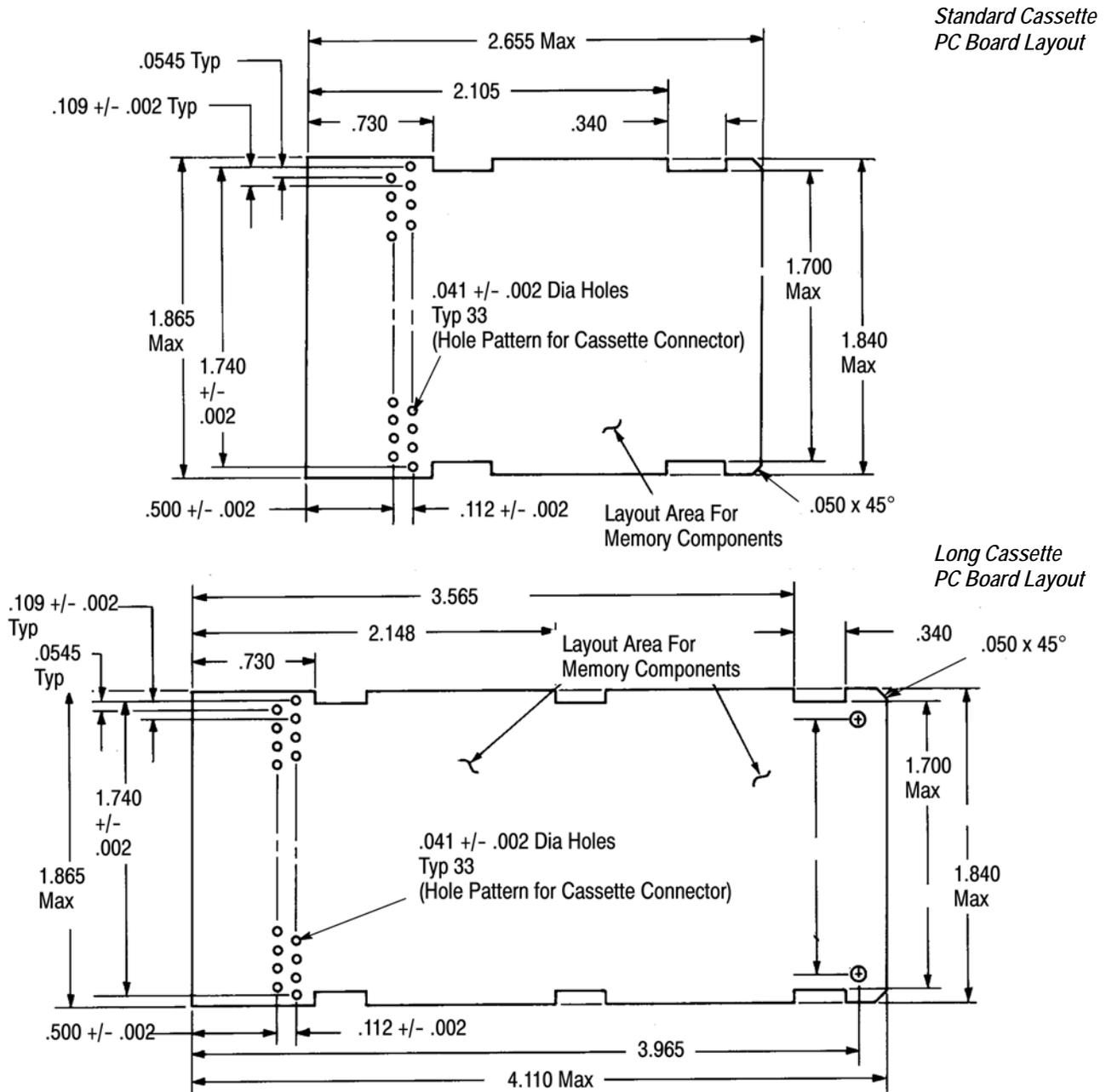


Figure 2

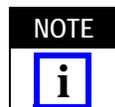
### 3.1. Cassette Assembly (Figure 2 and Figure 3)

1. Determine whether a standard or long unit will be used. Then, using the dimensions shown in Figure 2, select a pc board for the cassette. Make the latch and beveled corner cuts on the pc board edges as shown.

2. Determine the pin pattern for the memory components. Make the hole layout for the memory components and the cassette connector.

3. Install and solder the connector and memory components in the pc board.

4. Determine the number of polarizing slots to be open and select the appropriate cassette and holder kits with the desired keying configuration.



*If a write/protect device is to be installed, place reflective tape (customer-supplied) on the switch pad as indicated in Figure 3.*

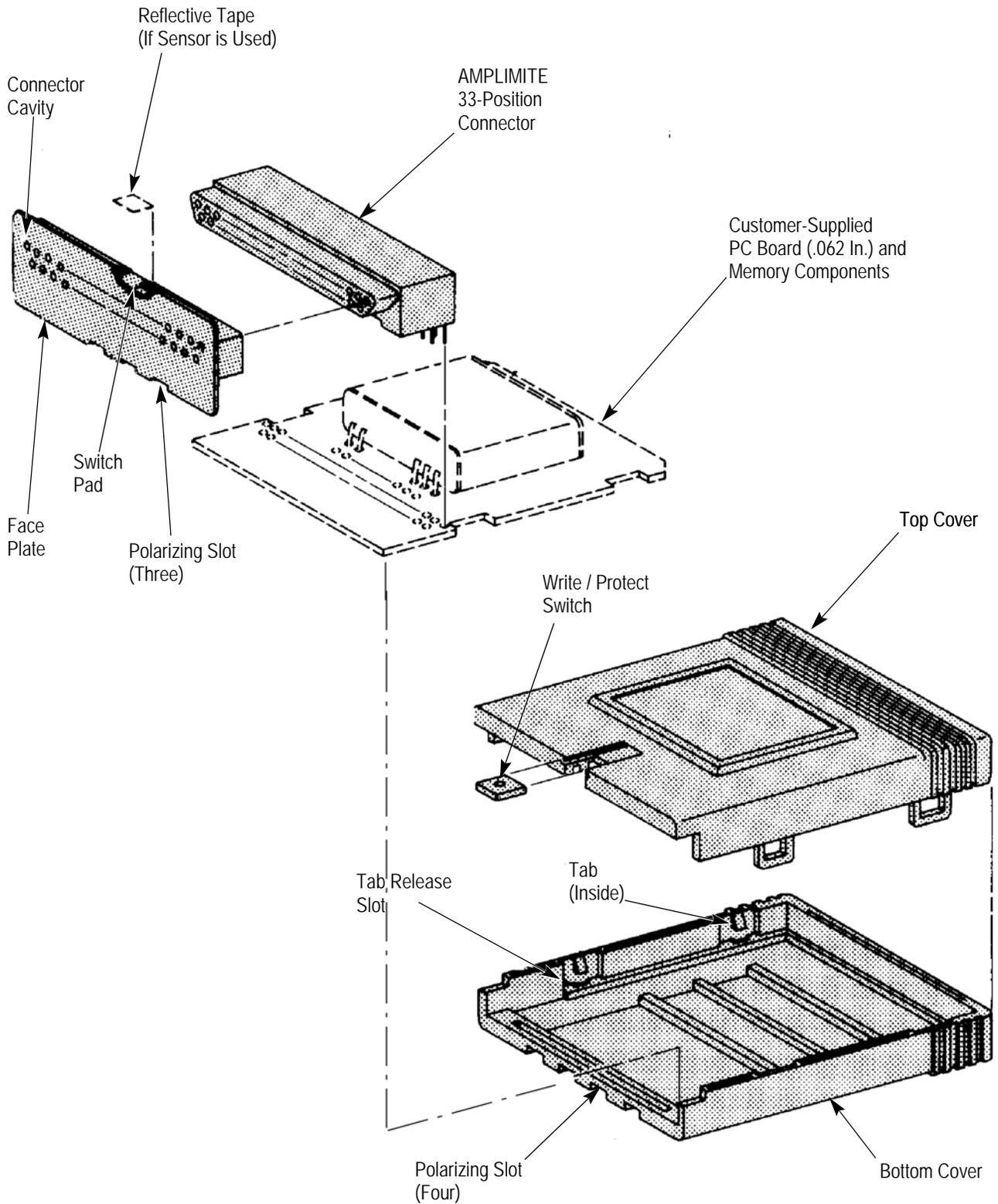
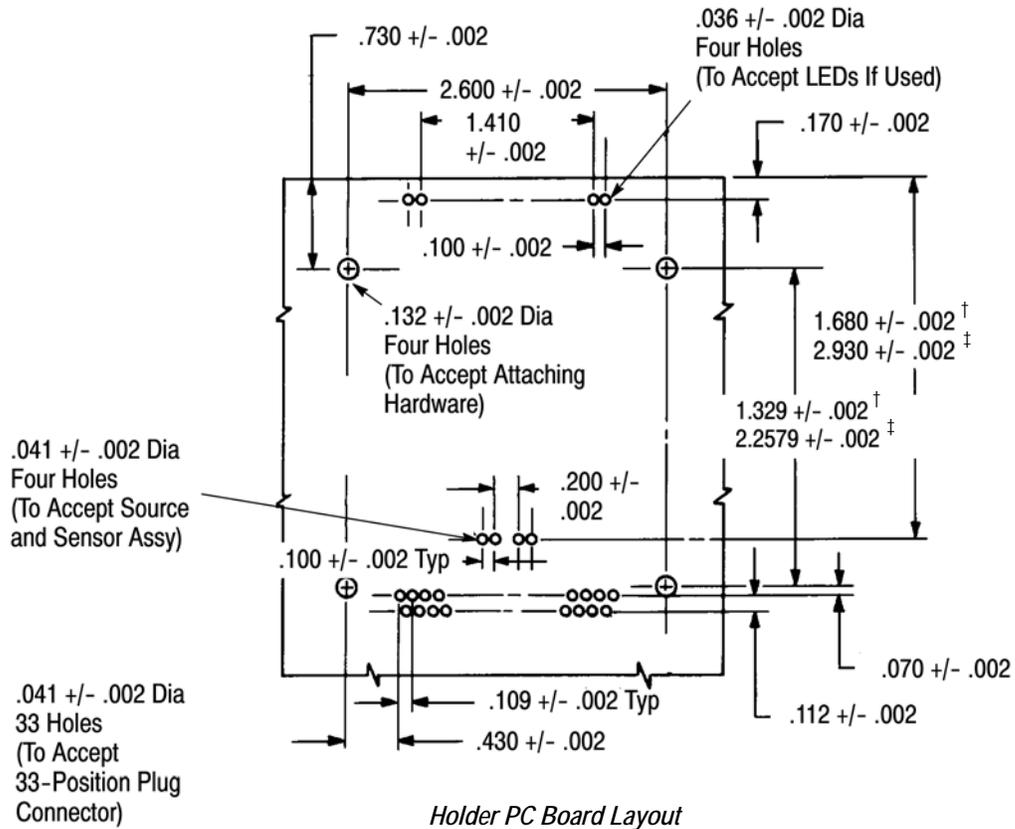


Figure 3

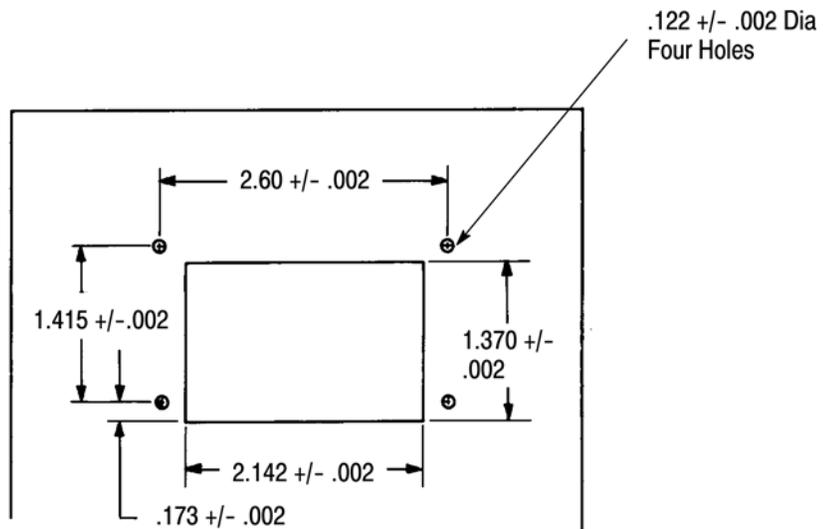
5. Align the connector with the face plate connector cavity and insert the connector into the cavity.

6. Place the pc board and it's attached components into the bottom of the cover as indicated in Figure 3. Make sure the face plate and bottom cover polarizing slots are properly aligned.



*Holder PC Board Layout*

<sup>†</sup> For Standard Sized Holder  
<sup>‡</sup> For Long Sized Holder



*Panel Cutout Dimensions*

*Figure 4*

7. Align the top cover with the bottom cover and insert the latches until they are engaged with the tabs

8. If the covers require separation for repair of internal components, obtain the Release Tool 91251-1 and refer to 408-6809 for the cover separation procedure.

**3.2. Holder Assembly** (Figure 4 and Figure 5)

1. Determine the location for the holder. Then make a hole layout on the pc board using the dimensions shown in Figure 4.

**NOTE** *If applicable, make holes for the sensor and the LED.*

2. Orient the pin connector so that the pins and mounting holes are aligned with the holes in the pc board and insert the pins into the pc board.

**NOTE** *The holder may be secured to the pc board with rivets, screws, bolts and nuts, or other suitable hardware. Rivets may be installed before soldering, but all other types of hardware should be installed after soldering.*

3. If applicable, insert LED and sensor pins.

4. With the components firmly seated on the pc board, solder the pins in place.

5. Align the locking latches of the body with the locking tabs on the connector and then slide the body onto the connector until the latches snap over the tabs.

6. Place the panel-mount cover on the body and position the panel over the holder. Secure the panel with four No. 4-40 screws.

This completes the assembly of the holder. It may be disassembled by removing the four No. 4-40 screws, removing the panel mount cover, and disengaging the body locking latches from the locking tabs.

**4. MATING AND UNMATING** (Figure 6)

If a sensor was installed, determine whether the cassette is to be in the write (program) or in the protect mode, and place the sliding write/protect switch in the appropriate position.

To insert the cassette, orient it so that the polarizing slots align with the polarizing guides, and then insert it straight into the holder until it bottoms.

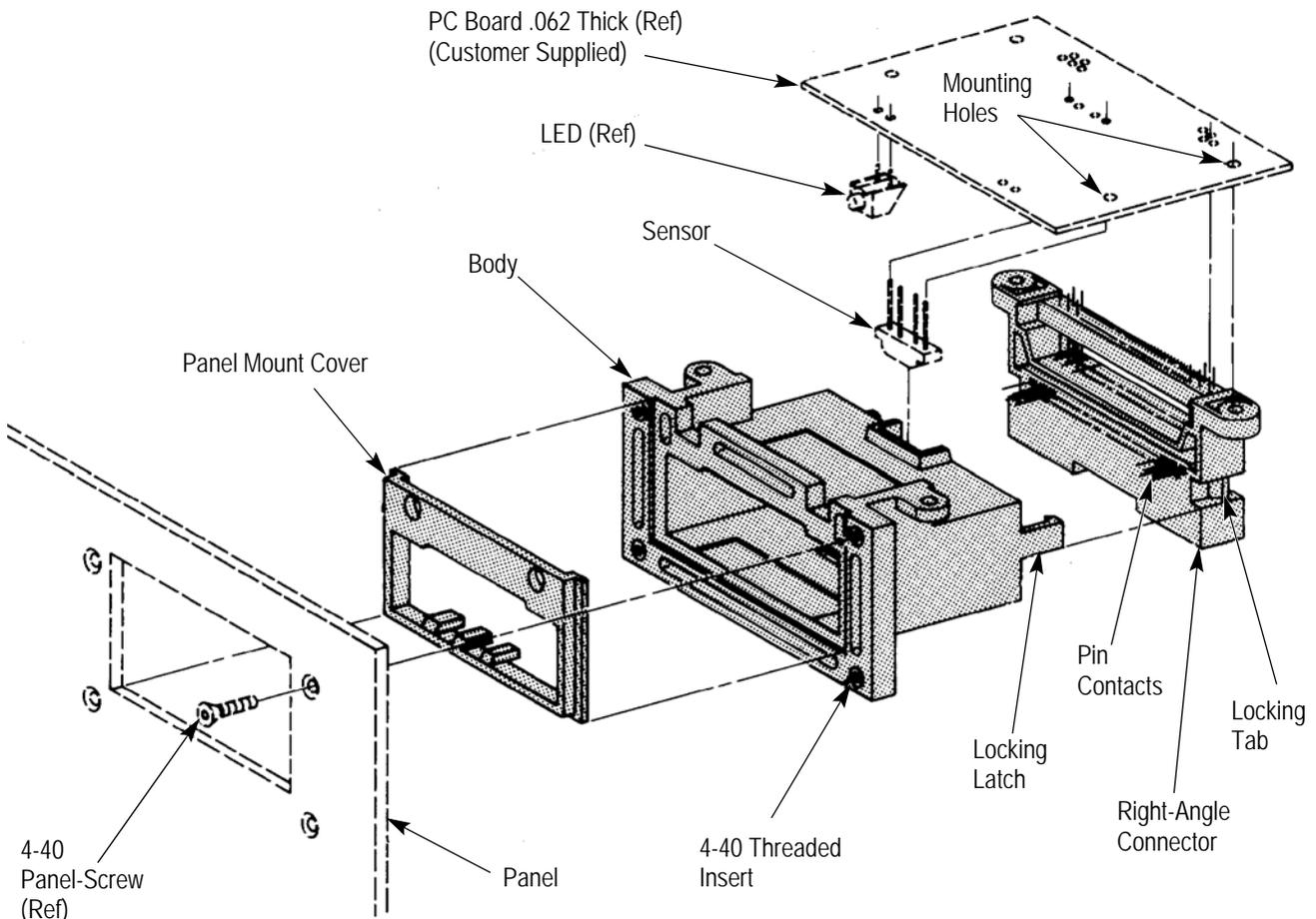


Figure 5

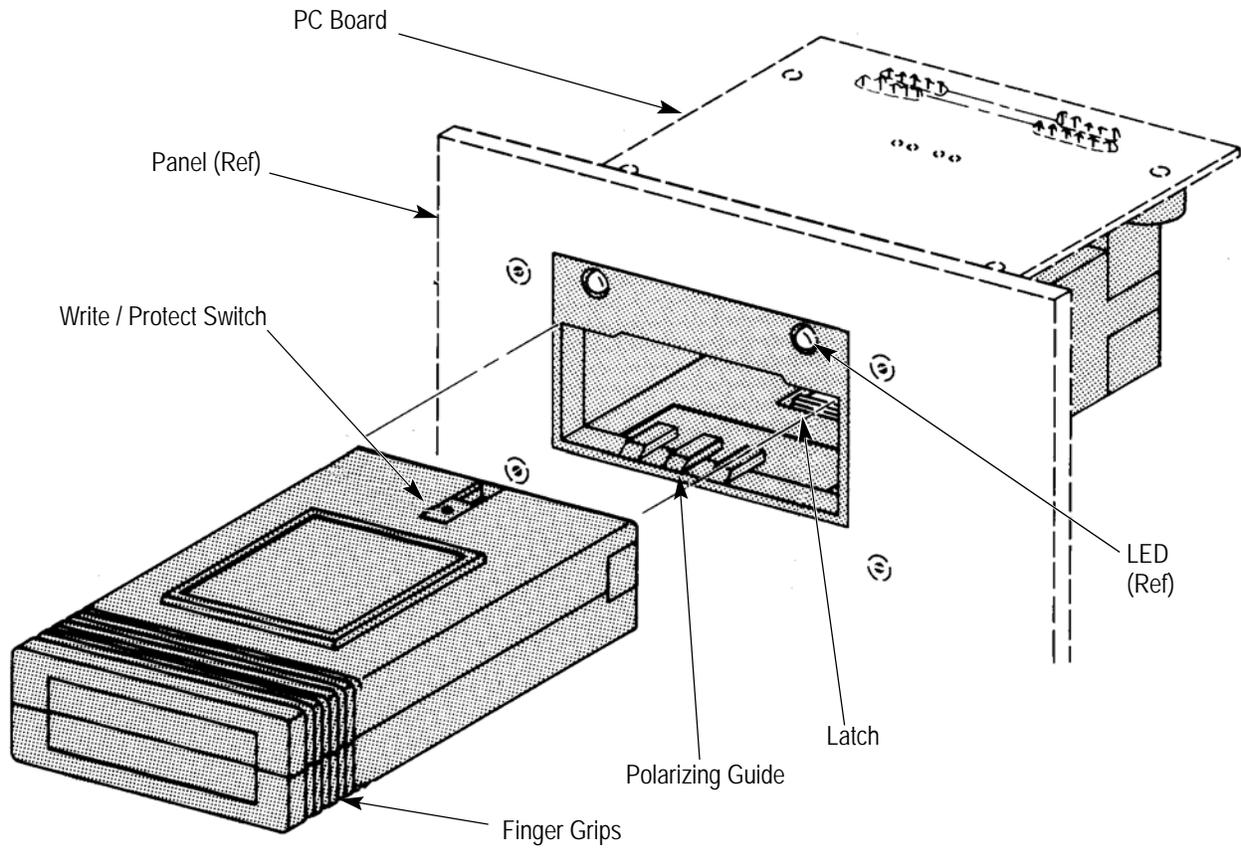
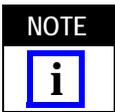


Figure 6



*LEDs, if installed, will glow to indicate that the cassette is in the selected mode of operation.*

To remove the cassette, grasp the finger grips firmly and pull the cassette straight out of the holder.

## 5. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.