

Figure 1

1. INTRODUCTION

AMP* Alignment Tools 532925-2, 58294-1, and 58302-[] are used to align the contacts in AMP-HDI (high-density interconnect) connectors and TBC Plus (twin-beam contact) connectors with the pc board contact holes.

Read these instructions thoroughly before using the tool.

NOTE

Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The alignment tool features a rail guide and cam lever. The tool slides onto the connector so that the contacts fit into the holes in the rail guide. The cam lever is closed to hold the connector to the tool. After the contacts are properly aligned with the pc board holes, the connector can be seated onto the pc board.

The cam lever is opened to release the contacts and the tool can be removed from the connector.

3. INSERTION PROCEDURE

1. Select the appropriate alignment tool according to the following:

ALIGNMENT TOOL	NO. OF CONNECTOR ROWS	MAXIMUM NO. OF CONTACTS PER CONNECTOR ROW*
532925-2	3 or 4	135
58294-1	5	180
58302-2	6	135
58302-3	6	173

* Refer to the connector customer drawing for contact count.

2. Adjust the cam lever to the open (or angled) position. Refer to Figure 1.
3. Slide the tool onto the connector so that the contacts fit between the slots and into the holes in the rail guide.

NOTE Depending on connector size, the connector may not fill all holes in the rail guide.

4. Adjust the cam lever to the closed (or straight) position.
5. Align the contacts with the appropriate pc board holes, and partially insert the contacts into the holes.

CAUTION The connector should be handled only by the housing to avoid deformation, contamination, or other damage to the contacts.

6. Holding the connector in place, move the cam lever on the alignment tool to the open (or angled) position. Carefully slide the tool from the connector and pc board.
7. Seat the connector onto the pc board.

NOTE For detailed information on application requirements for AMP-HDI connectors, refer to Application Specification 114-9008, and for TBC Plus connectors, refer to 114-25036.

4. INSPECTION AND MAINTENANCE

The alignment tools must conform to the dimensions provided in Figure 2. Inspect the tool upon receipt to make sure that it has not been damaged in transit, and at regularly scheduled intervals to ensure that it remains functional.

Order replacement tools through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605 or write to:

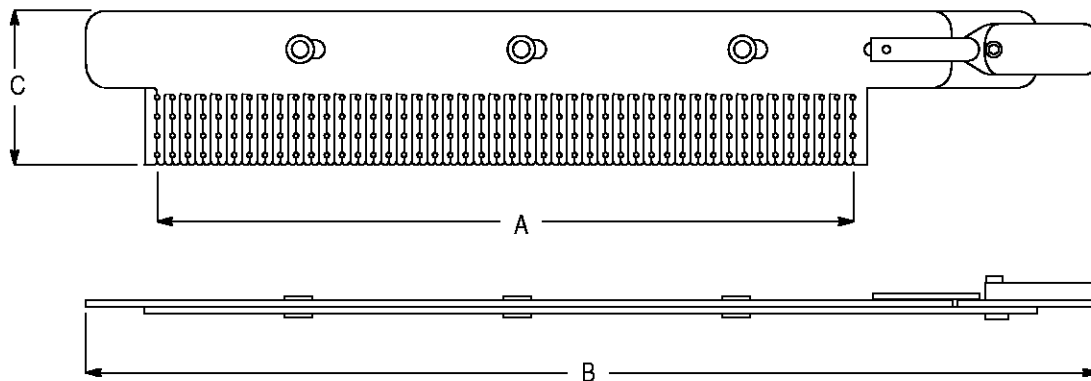
CUSTOMER SERVICE (038-035)
 AMP INCORPORATED
 PO BOX 3608
 HARRISBURG PA 17105-3608

For customer repair service, please contact an AMP representative at 1-800-526-5136.

5. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0591-99 include:

- Updated to corporate requirements
- Added TBC Plus connectors to Section 1
- Removed obsolete alignment tools
- Modified Figure 1
- Removed reference to catalog
- Added CAUTION to Step 5 and NOTE to Step 7 in Section 3
- Added information for replacement tools to Section 4
- Replaced customer repair address with phone number



ALIGNMENT TOOL	DIMENSIONS (mm [in.])			WEIGHT
	A	B ±1.27 [±.05]	C ±0.25 [±.01]	
532925-2	341 [13.42]	378 [14.90]	20.3 [.80]	.057 kg [2.0 oz]
58294-1	455 [17.93]	505 [19.90]	22.8 [.90]	.096 kg [3.4 oz]
58302-2	341 [13.43]	378 [14.90]	25.4 [1.0]	.068 kg [2.4 oz]
58302-3	437 [17.22]	475 [18.70]	25.4 [1.0]	.102 kg [3.6 oz]

Figure 2