

AMP

AMP INCORPORATED
HARRISBURG, PA 17105

CUSTOMER HOTLINE
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AMP* SEATING TOOL 58366-1
FOR MINI-EDGE CONNECTORS
WITH ACTION PIN* CONTACTS

IS 9437

RELEASED
8-2-88

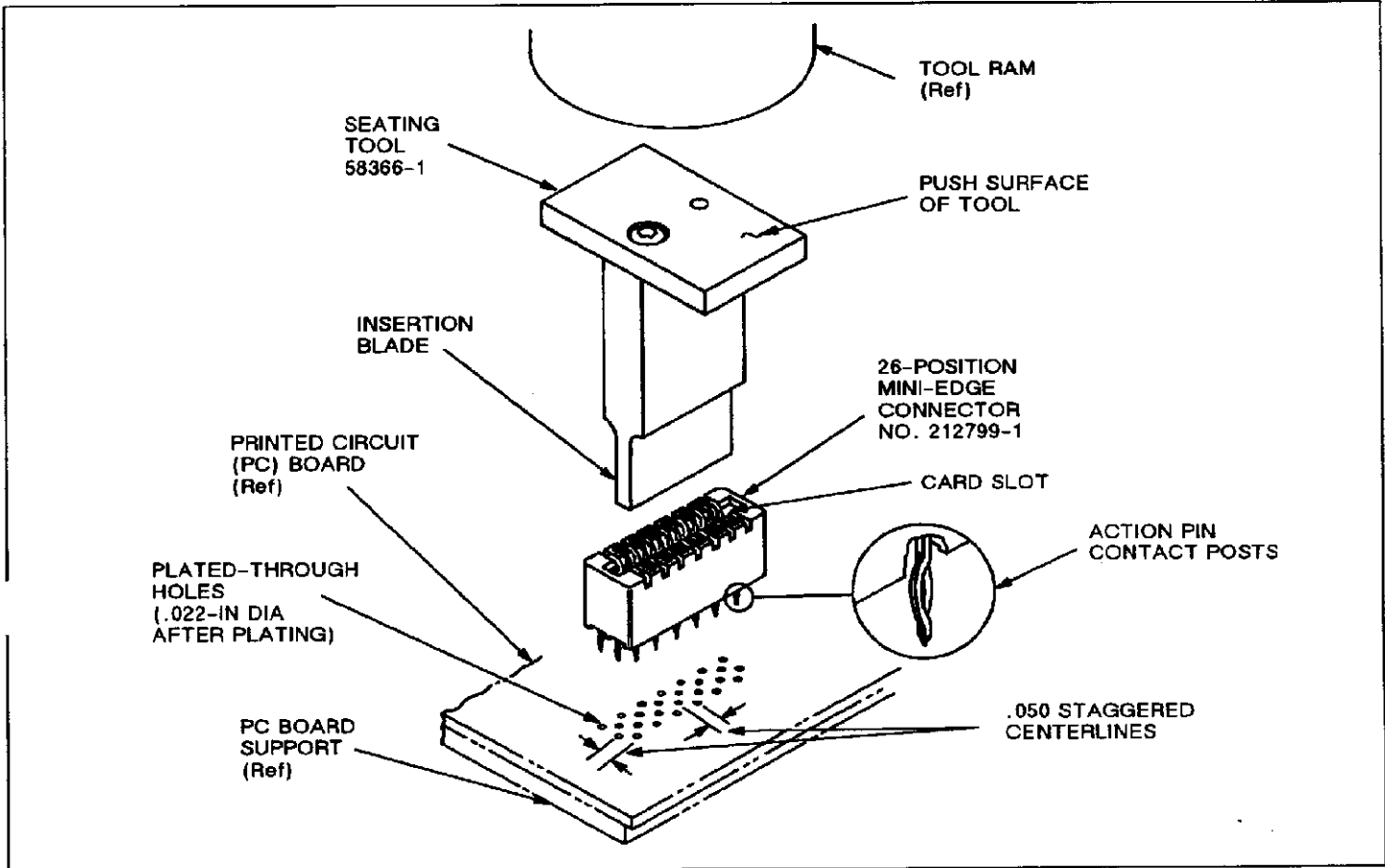


Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Seating Tool 58366-1 shown in Figure 1. The tool is used to insert AMP Mini-Edge connectors (26 positions) pre-loaded with ACTION PIN contacts into .062-in.-thick printed circuit (pc) boards. Refer to AMP Product Specification 108-10043 for pc board and plated-through hole requirements. Read all instructions carefully before installing any connectors.

NOTE

All dimensions on this instruction sheet are in inches.

2. DESCRIPTION (Figure 1)

The all-metal seating tool features a push surface

which serves as a bearing surface for the applicator ram, and an insertion blade which fits into the card slot for connector seating. The compact Mini-Edge connector features 26 anti-overstress contacts (13 for each board side) with ACTION PIN posts. The compliant pin area compresses during insertion into .022-in.-dia plated-through holes. The continuous normal force provides a gas-tight connection, with no need for soldering. Contact posts are arranged in a staggered .050-in. centerline pattern, shown in Figure 1.

Connectors can be seated singly or gang-inserted provided that the application tooling (arbor frame assembly, H-Frame or other machine) is capable of exerting 20 lb (max) pressure per contact or 520 lb per connector.

3. REQUIREMENTS

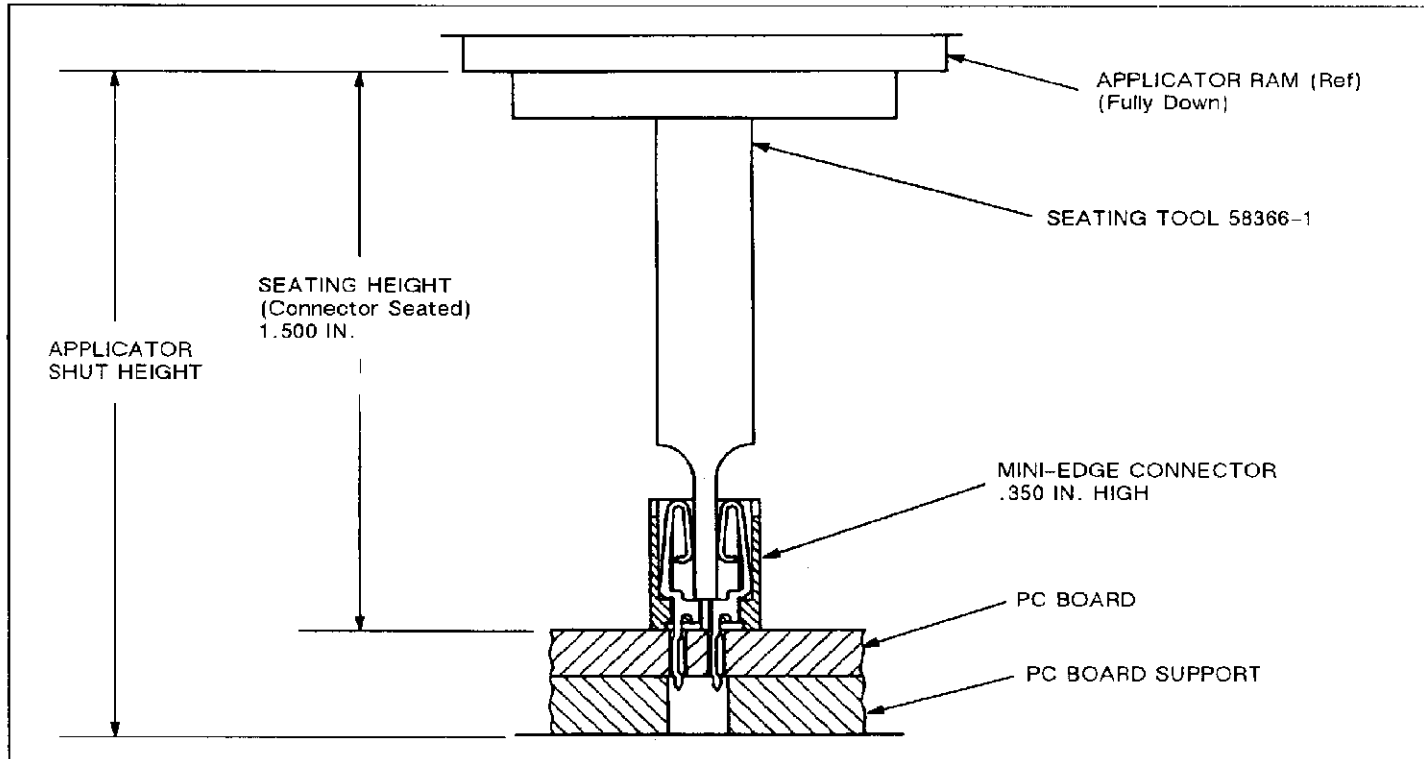
A. PC Board Support (Customer Supplied)

A pc board fixture is required to ensure that: 1) each connector is aligned with the tool during the seating process, and 2) posts are protected during the procedures. Fixtures are **not** furnished by AMP, and must be

supplied by the customer. Refer to IS 6297 for AMP design recommendations.

B. Seating Height

The seating height — the distance from the bottom surface of the ram to the top of the pc board when the ram is DOWN — must be set at 1.500 in. before starting the seating procedure. Refer to Figure 2.



NOTE: Shut height equals seating height plus thickness of pc board and pc board support.

Fig. 2

4. SEATING PROCEDURE

After the machine is properly set up with the pc board support and pc board in place, proceed as follows:

1. Insert contact posts of connector(s) into the pc board until the compliant pin sections start to enter the board holes.
2. Position the seating tool so that the insertion blade bottoms in the connector card slot.
3. Center the push surface of the seating tool under the ram. **MAKE SURE** ram is properly aligned with the connector.
4. Lower the ram carefully until ACTION PIN posts are fully inserted and the connector assembly bottoms on the pc board.
5. Retract the ram, and remove the seating tool from the seated connector by using a straight-upward motion.

This completes the seating procedure.

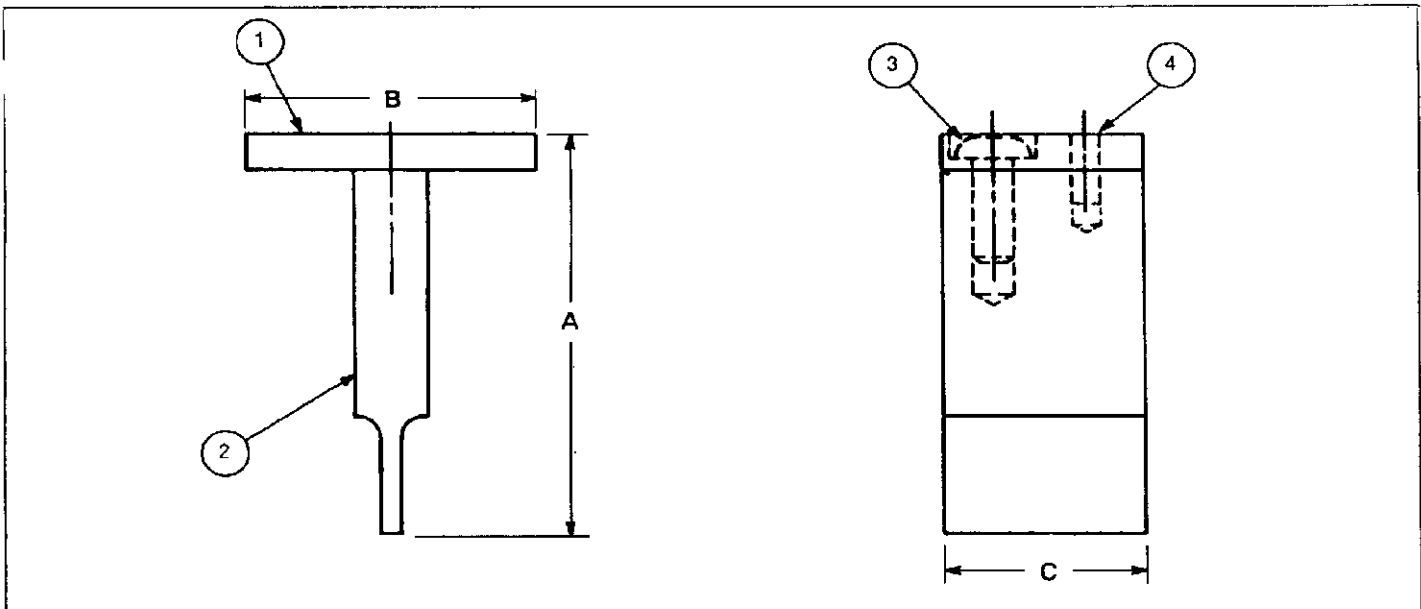
5. TOOL INSPECTION

Each seating tool is inspected before shipment. AMP recommends that the tool be inspected immediately upon its arrival at your facility, and at regularly scheduled intervals, to ensure that it has not been damaged during handling and use.

6. MAINTENANCE

Keep the seating tool clean. Remove all foreign particles with a clean, soft brush or clean lint-free cloth. If particles cannot be removed easily or if push plate or insertion plate appear to be bent, worn, or out of alignment, return the tool to your supervisor for repair or replacement. When the tool is not in use, store it in a clean, dry place.

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to responsible supervisory personnel.



REPLACEMENT PARTS

ITEM	PART NO.	DESCRIPTION	QUANTITY	TOOL DIMENSIONS
1	843118-1	PLATE, Top	1	A 1.420
2	843119-1	BLADE, Insertion	1	B 1.000
3	1-21022-7	SCREW, Btnhd Cap 6-32 x .38	1	C 0.687
4	21919-9	PIN, Dowel, .094 Dia x .25	1	WT 1/2 oz

Fig. 3

7. TOOL REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 3. Spare parts or tools should be stocked and controlled to prevent lost time when tool repair or replacement is necessary. Replacement parts or additional tools can be ordered from:

AMP Incorporated
 P.O. Box 3608
 Harrisburg, PA 17105-3608

or a wholly-owned subsidiary of AMP Incorporated.