

SEATING TOOL ASSEMBLY	AMPLIMITE SERIES .050 RECEPTACLE SIZE (No. of Positions)
856371-1	20
856371-2	26
856371-5	50
856371-7	68
856371-9	100
1-856371-0	120

Figure 1

1. INTRODUCTION

Seating Tool Assemblies 856371-[] are designed to seat AMPLIMITE Series .050 receptacles with ACTION PIN contacts to allow solderless pc board installation. Each seating tool is specifically designed for the number of positions in the receptacle. Refer to Figure 1.

Read these and any referenced instruction material before using the seating tool.



All numerical values in this instruction sheet are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

2. REQUIREMENTS

2.1. PC Board Support Fixture

A fixture must be used to provide proper support for the pc board and alignment of the seating tool to the contacts, and to protect the pc board and and connector from damage. The pc board support fixture must be designed for the specific needs according to Instruction Sheet 408-6927.

2.2. Application Tooling

Power for seating tools must be provided by a machine capable of exerting 275.8 kPa [40 lb] pressure per contact. SM-3 Bench Machine 814700-2 (409-5626), H-Frame Machine 803880-6 (409-5567) or GREENERD Manual Frame Assemblies 3A or 3B equipped with Counterbalance Kit 58176-1, Ram Adapter Assembly Kit 58177-1 or 58177-2, and Board Support Plate Kit 58175-1 (408-9027) can be used.



GREENERD Frame Assemblies can be purchased from:
 GREENERD Press & Machine Co., Inc.
 41 Crown Street
 Nashua, NH 03061

3. SET UP

When setting up equipment to seat receptacles, pay particular attention to the following:

- The seating tool must be matched to the receptacle
- The seating tool, receptacle, and applicator ram must be properly aligned before cycling the tool



If the tool and receptacle are mismatched or are improperly aligned, damage could occur to the tooling, connector, or both.

Set the seating height to the dimension shown in Figure 2 (the distance from the bottom surface of the ram to the top of the pc board when the ram is DOWN. The applicator *shut height* will equal the seating height PLUS the combined thicknesses of the pc board and pc board support fixture).

4. SEATING (See Figure 2)

1. Position the receptacle onto pc board so that the contacts (and alignment features) are properly aligned to the pc board and support fixture.
2. Place the receptacle onto pc board until the contacts are resting securely on, but have not fully entered, the pc board.
3. Position the seating tool onto the receptacle.
4. Center the seating tool and receptacle under the applicator ram of the tool. Slowly lower the ram until it just meets the seating tool. Verify alignment of the support fixture, pc board, receptacle, and seating tool.



Damage to the pc board, seating tool, or receptacle may occur if seating height is improperly set or if tool is not properly seated in the receptacle before cycling the tool.

5. Cycle the tool to seat the receptacle in the pc board. Then retract the ram, and carefully remove the seating tool. Check to make sure that the receptacle has been properly seated.
6. Repeat Steps 2 through 6 until all receptacles are seated.



For application requirements for the receptacle, refer to Application Specification 114-40029.

5. MAINTENANCE AND INSPECTION

The seating tool is assembled and inspected before shipment. It is recommended that the tool be inspected immediately upon arrival at your facility to ensure that the tool has not been damaged during shipment and that the tool conforms to the dimensions given in Figure 3.

5.1. Daily 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 contaminants with a clean, soft brush or a lint-free cloth. DO NOT use objects that could damage the tool components.
2. Ensure that setscrews are in place and secured.
3. When the tool is not in use, store it in a clean, dry area.

5.2. Periodic Inspection

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

Note: Not to Scale

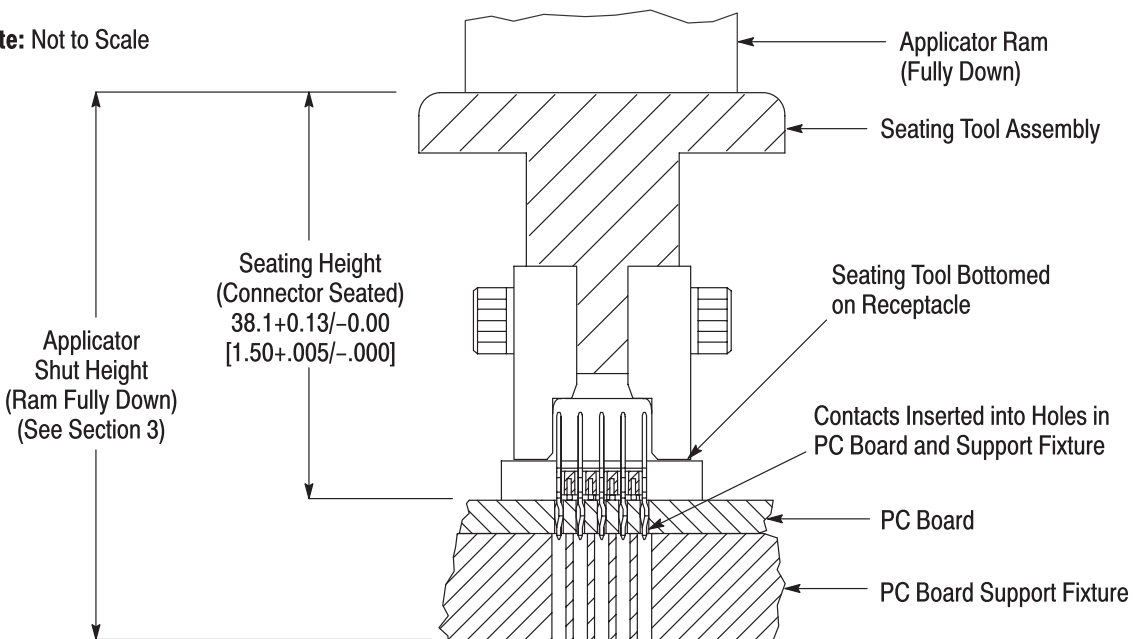


Figure 2

6. REPLACEMENT AND REPAIR

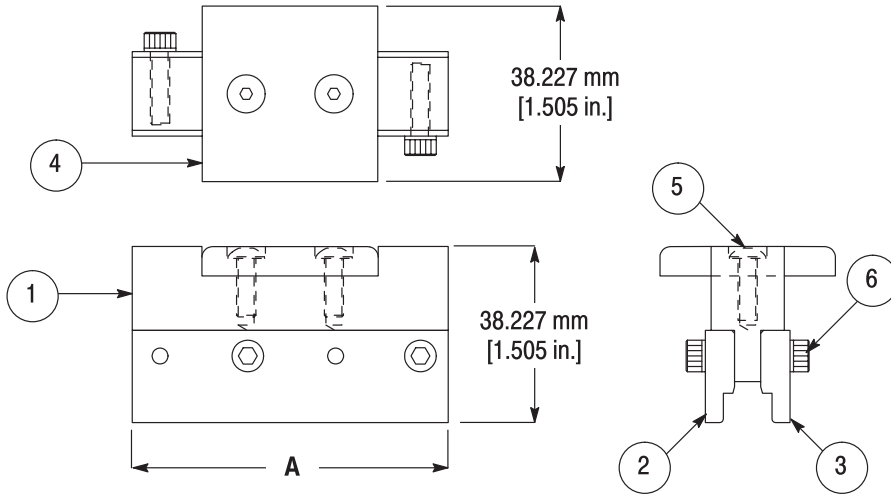
Customer-replaceable parts are listed in Figure 3. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Order replacement parts through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
 TYCO ELECTRONICS CORPORATION
 PO BOX 3608
 HARRISBURG PA 17105-3608

7. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements
- Removed obsolete seating tools
- Removed tool repair address



TOOL	DIMENSION A
-1	17.78 [.700]
-2	21.59 [.850]
-5	36.83 [1.45]
-7	48.26 [1.90]
-9	68.58 [2.70]
-10	81.28 [3.20]

REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER TOOL			
			-1, -2	-5	-7	-9, -10
1	856091-●	PUSH BAR	1	1	1	1
2	856088-●	SIDE PLATE, Left	1	2	1	2
3	856089-●	SIDE PLATE, Right	1	1	1	1
4	314202-●	PLATE	1	1	1	1
5	2-21000-2	SCREW, Button Head Cap, 8-32×UNC×.50 in. L	2	2	2	2
6	2-21000-6	SCREW, Button Head Cap, 8-32×UNC×.625 in. L	1	2	3	4

● Dash number corresponds with the dash number of the seating tool; for example, Tool 856371-1 is (part number)-1.

Figure 3