

AMPAMP INCORPORATED
HARRISBURG, PA 17105CUSTOMER HOTLINE
1 800 722-1111AMP* SEATING TOOLS
58171-1 THROUGH -4

FOR EUROCARD ACTION PIN* CONNECTORS

REDUCED FOR PACKAGING

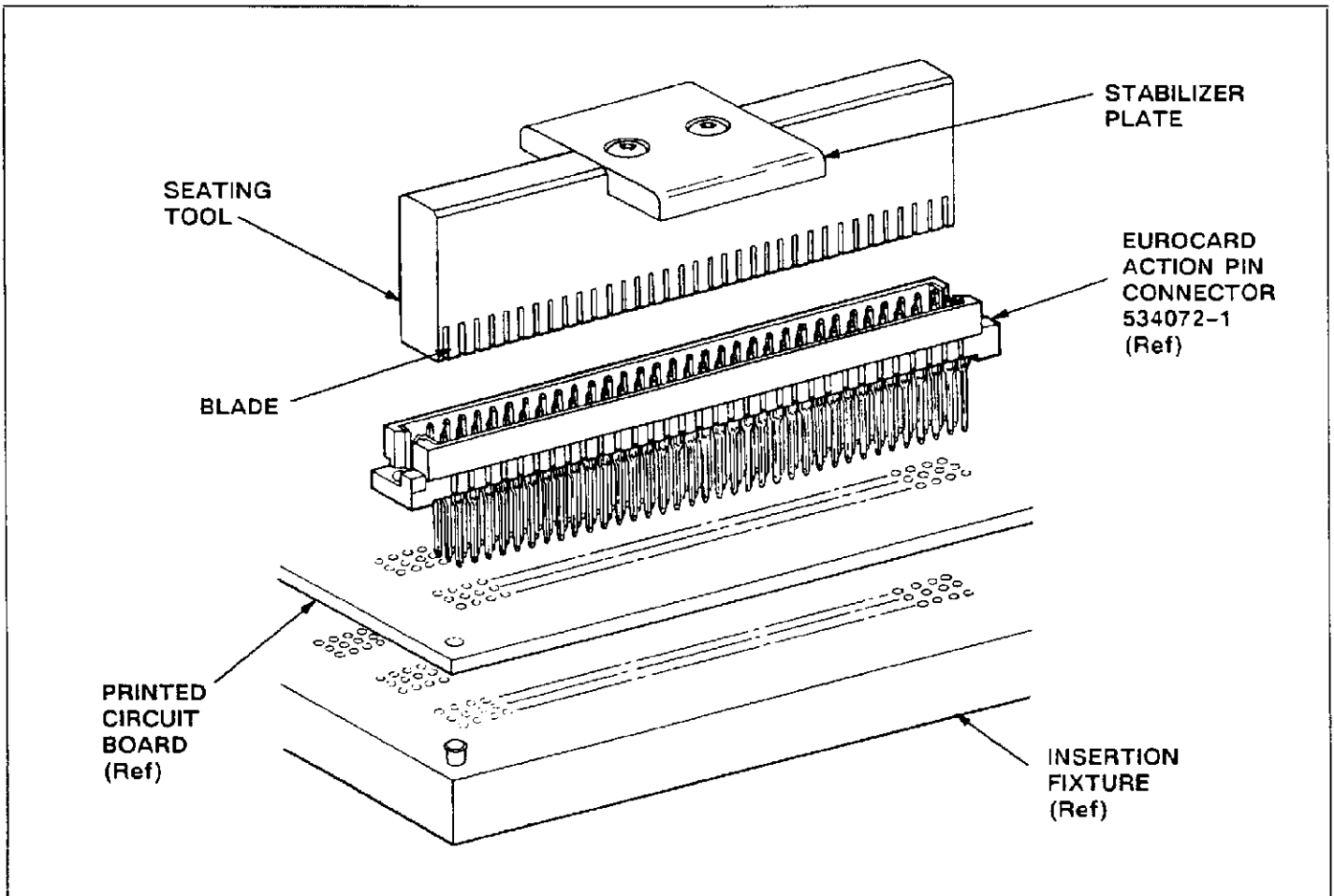
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Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the application and maintenance of AMP Seating Tools 58171-1 through -4. The seating tools are used to seat AMP Eurocard ACTION PIN Connectors into printed circuit (pc) boards. See Figure 1. Read these instructions thoroughly before using the tool.

NOTE

All dimensions on this instruction sheet are in inches.

2. DESCRIPTION (Figure 1)

AMP seating tool 58171 is designed with a stabilizer plate and blade. The stabilizer plate straightens the connector, during cycle of applicator ram, to provide

proper insertion into the pc board. When seating the connector, the blade(s) are positioned over the contact shoulders to prevent damage to the contacts. Each tool is designed with a specific combination of contacts in a row and number of rows in a connector bay. Refer to Figure 2 to determine tool and connector compatibility.

3. SEATING REQUIREMENTS

A. PC Board Support Fixture (Customer Supplied)

A pc board support 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 procedure. Fixtures are not furnished by AMP, and must be supplied by the customer.

CONNECTORS					SEATING TOOLS		
BASE PART NUMBER		NO. OF ROWS	NO. OF BAYS	NO. OF PINS/ROW/BAY	TOTAL NO. OF PINS	NO. OF TOOLS	PART NO.
531781-1	533765-5	3	1	32	96	1	58171-1
532524-1	533786-1	↓	↓	↓	↓	↓	↓
532525-1	533794-1	↓	↓	↓	↓	↓	↓
533204-1	534072-1	↓	↓	↓	↓	↓	↓
533204-2	534075-1	↓	↓	↓	↓	↓	↓
533204-3	534075-2	↓	↓	↓	↓	↓	↓
533204-4	534086-1	↓	↓	↓	↓	↓	↓
533204-6	534088-1	↓	↓	↓	↓	↓	↓
533216-1	534621-1	↓	↓	↓	↓	↓	↓
533756-1	534896-1	↓	↓	↓	↓	↓	↓
533756-2	535019-1	↓	↓	↓	↓	↓	↓
533756-4		↓	↓	↓	↓	↓	↓
533756-5		↓	↓	↓	↓	↓	↓
533786-1		↓	↓	↓	↓	↓	↓
532545-1	533215-1	3	1	16	48	1	58171-2
532545-2	533215-2	↓	↓	↓	↓	↓	↓
534053-1	534057-1	3	1	40	120	1	58171-3
534056-1	534059-1	↓	↓	↓	↓	↓	↓
534053-2	534057-2	3	1	50	150	1	58171-4
534056-2	534059-2	↓	↓	↓	↓	↓	↓

• DASH NUMBER APPLICABLE TO ALL TOOLING Fig. 2

B. Application Tooling

The connectors can be seated with an application unit capable of supplying a downward pressure of 40 lb/contact. AMP 10/20-Ton "H" Frame Assembly 803880-6 is capable of seating up to 1000 contacts, while AMP SM-3 Frame Assembly 814700-[] can seat up to 150 contacts. For operating and setup procedures of the frame assemblies, refer to CM 5567 (10/20-Ton "H" frame assembly), and CM 5626 (SM-3 frame assembly).

C. Seating Height (Figure 3)

The seating height—distance from the bottom surface of applicator ram (fully down) to the top of the pc board—must be set at 1.50 in. before starting seating procedure.

NOTE

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

4. SEATING PROCEDURE

1. Place pc board on support fixture. Align board holes with the fixture holes or slots.
2. Insert connector contacts into the board until compliant pin sections of the post start to enter pc board holes.
3. Position proper seating tool into connector.
4. Center seating tool and connector under the applicator ram. Lower the ram slowly and verify alignment of tool to the connector.

CAUTION

To prevent damage to the tool, connector, or both, make sure the connector and tool are compatible with each other and aligned properly in the frame assembly.

5. Cycle frame assembly to seat connector into the pc board.
6. Remove seating tool and pc board from the support fixture.

This completes the seating procedure.

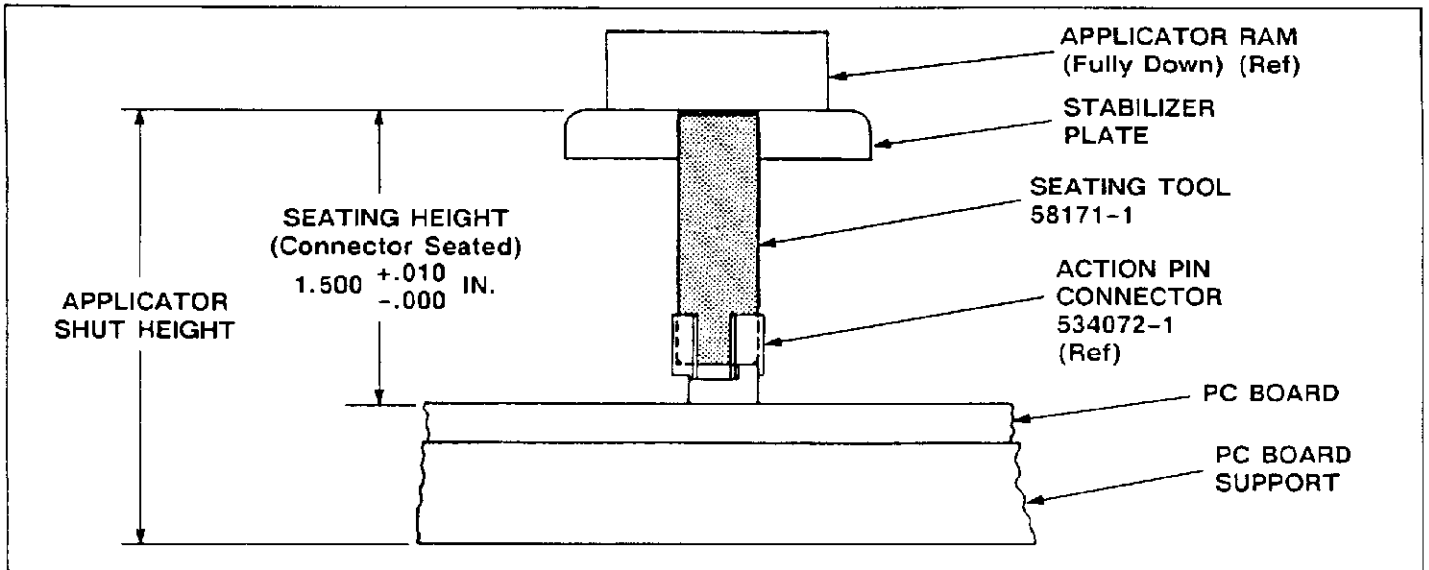


Fig. 3

5. TOOL INSPECTION

AMP Seating Tools are assembled and inspected before shipment. It is recommended that the tool(s) be inspected immediately upon arrival at your facility to ensure that the tools have not been damaged during shipment, and that the tools conform to the dimensions provided in Figure 4.

Additional tools can be purchased by contacting:

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

or a wholly-owned subsidiary of AMP Incorporated.

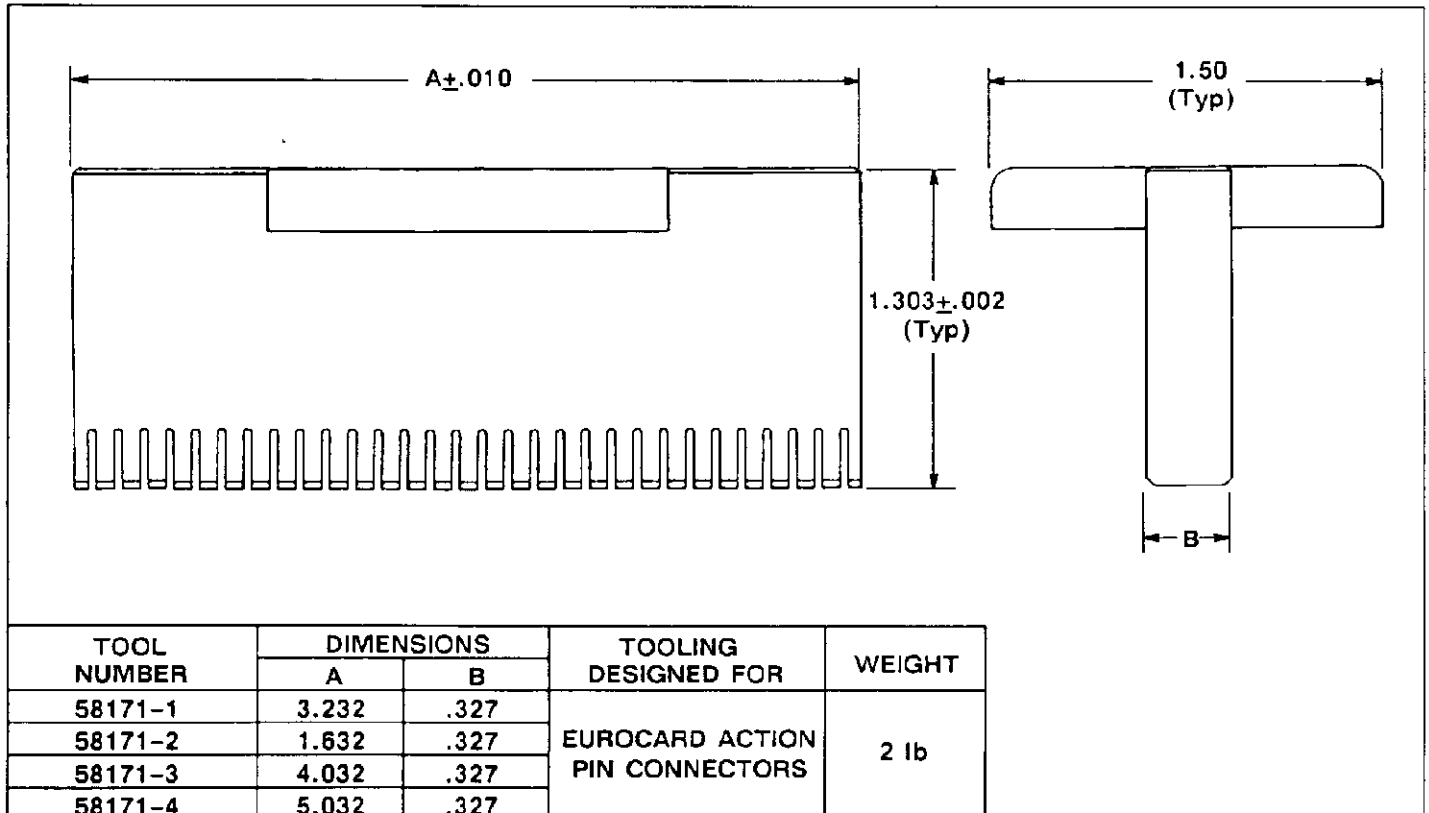


Fig. 4