

Fig. 1

91-468

## 1. INTRODUCTION

This instruction sheet (IS) covers use and maintenance of AMP Seating Tools with base part number 768211. These tools are used to seat AMP Eurocard Pin Header Assemblies with the following base part numbers:

PIN HEADERS (By Seating Tool Part Number)			
768211-1 (48-Pos)	768211-2 (96-Pos)	768211-3 (120-Pos)	768211-4 (150-Pos)
650917	650889	650920	650923
650918	650909	650921	650924
650931	650912		
650932	650930		

All these headers contain ACTION PIN contacts to allow solderless pc board installation.

### NOTE

All dimensions are in millimeters [followed by inches in brackets].

Read these instructions completely and understand them before using the seating tool.

## 2. DESCRIPTION (Figure 1)

Each seating tool is made up of a body, a pin guide, a mount to hold the pin guide, and a plate to stabilize the tool under the pressure of the machine. Component base part numbers are shown in Figure 1; dash numbers directly match the seating tool dash numbers.

The tool sits inside the header housing with the pin guide engaging the pins, preventing pins from pushing out of the housing during header seating.

Power for seating tools must be provided by a machine capable of supplying a downward force of 40 pounds per contact. For best results, use AMP 10/20-Ton "H"-Frame Assembly 803880-6 (CM 5567 provides instructions) or AMP SM-3 Frame Assembly 814700 (CM 5626).

A pc board support must be used to provide proper alignment of the tool to the header pins, and to protect the pc board and header posts from damage. You will need to design a support for your specific needs using the recommendations in IS 6927.

**3. SEATING A PIN HEADER**

1. Set seating height to the dimension shown in Figure 2. (Machine shut height will equal the seating height plus the combined thicknesses of the pc board and board support.)
2. Position pc board on board support so that it is secure and will receive the header posts.
3. Insert header into pc board until ACTION PIN sections of posts begin to enter holes in board.
4. Position the appropriate seating tool into the header, making sure that the pins are firmly engaged by the cavities in the pin guide.
5. Center seating tool and header under the applicator ram of the power source you have chosen; slowly lower ram until it just meets the seating tool. Verify the alignment of the board support, pc board, header, and seating tool.

6. Cycle applicator ram according to instructions for your power source. Remove board and seated pin header, or reposition board and support for seating of additional headers.

**4. MAINTAINING THE SEATING TOOL**

Inspect the tool when you receive it and occasionally thereafter. When not in use, store it in a clean, dry area.

It is advisable to keep an inventory of replacement parts in stock to avoid long periods of down-time. To replace parts from inventory, or if parts are lost or damaged, refer to Figure 1 for the correct part numbers, and order replacements from:

CUSTOMER SERVICE (38-35)  
 AMP INCORPORATED  
 PO BOX 3608  
 HARRISBURG PA 17105-3608

When necessary, the entire tool may be returned for evaluation and repair, with a written description of the problem, to:

CUSTOMER REPAIR (01-12)  
 AMP INCORPORATED  
 1523 NORTH 4TH STREET  
 HARRISBURG PA 17102-1604

**CAUTION**

*Damage to the tool or header may occur if the wrong size tool is used, if seating height is improperly set, or if the tool is not properly seated in the header before cycling the applicator ram.*

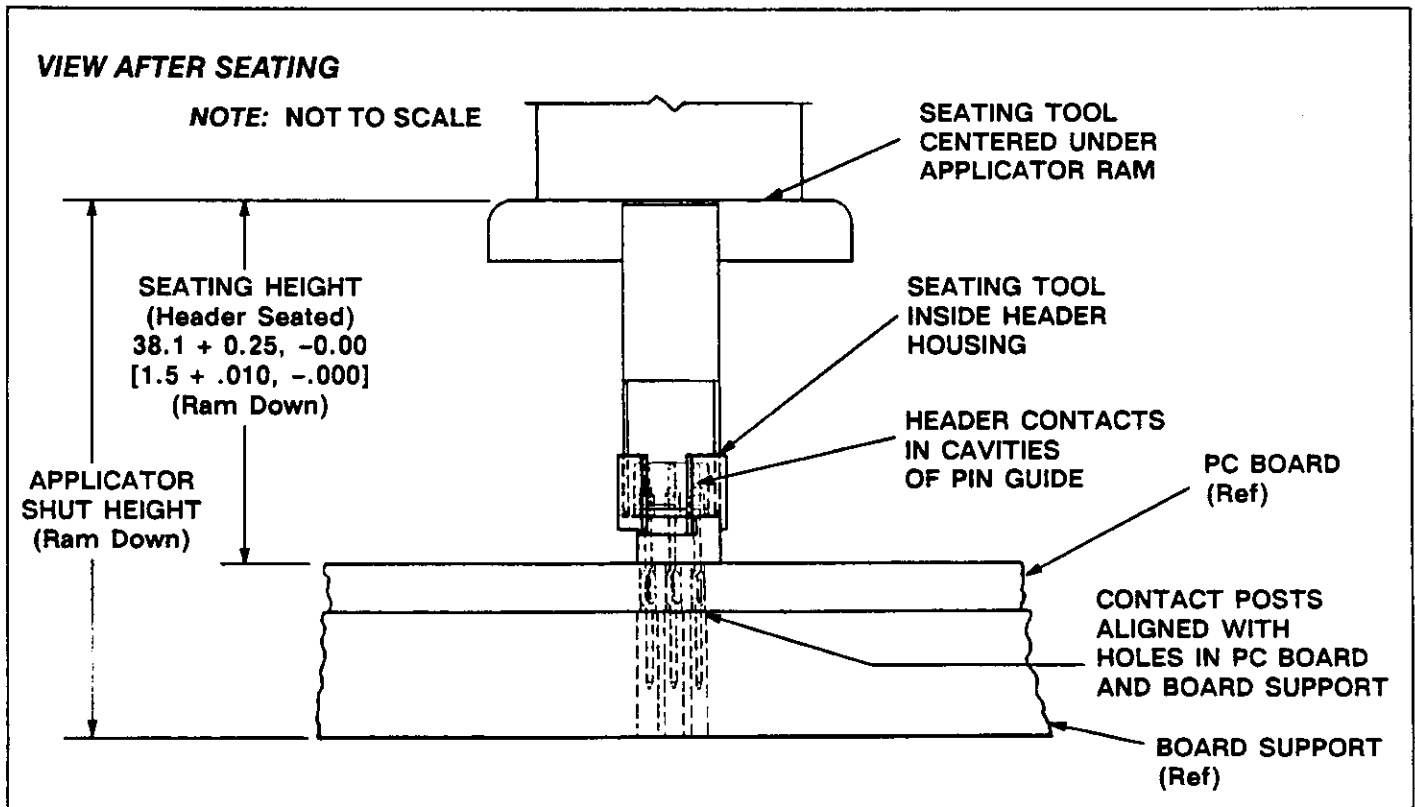


Fig. 2