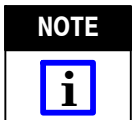


SEATING TOOL ASSEMBLY	USE WITH	ALSO INCLUDED WITH (Instruction Sheet in Parenthesis)
1424686-1	Manual Press 1428138-1	Manual Seating Tool Assembly 1424931-1 Manual Press Included (408-8505)
1424686-2	Pneumatic Press 1428137-1	Pneumatic Seating Tool Assembly 1424930-1 Pneumatic Press Included (408-8504)
1424686-3	Press Other than Manual or Pneumatic	—

Figure 1

## 1. INTRODUCTION

Seating Tool Assemblies 1424686-[ ] are designed to be used to assist in applying PC/104 and PC/104-Plus connectors to printed circuit (pc) boards. The seating tool assembly must be installed onto a press (refer to Figure 1).



*Dimensions on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Figures are not drawn to scale.*

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

## 2. DESCRIPTION

Each seating tool assembly consists of a base, slide plate, and Fixture Board Assembly 1424685-1 (also available separately, refer to 408-8502), and securing

hardware. Assemblies -1 and -2 also contain the appropriate upper (ram) tooling for the press. The base mounts to the press. See Figure 1. The slide plate is detented to ensure proper location of the connector when terminating.

## 3. OPERATION

1. If applying connectors with organizers, loosen the set screws securing the insert plate, and remove the insert plate.
2. Align and adjust the seating tool assembly as described in Section 4, ADJUSTMENTS.
3. If applying connectors with organizers, place the organizer on the fixture board (in place of the insert plate). See Figure 2.
4. Place the pc board on the fixture board assembly, locating it using the guide posts of the fixture board assembly (shown in Figure 2).

**If Applying Connector with Organizer**

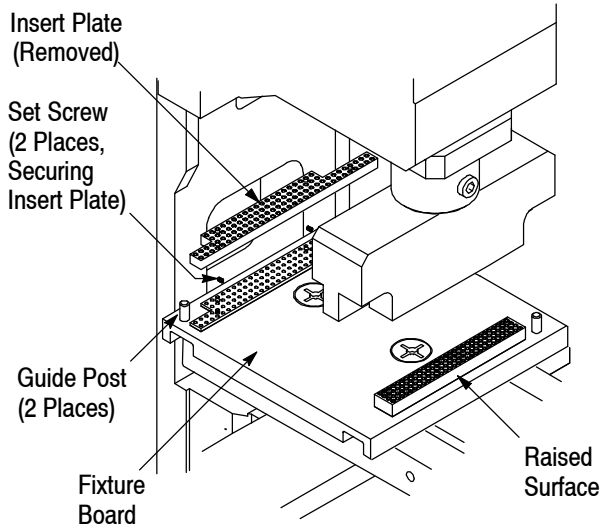


Figure 2

5. Place the connectors on the pc board as shown in Figure 3.
6. Grasp the handle of the slide plate, and move the slide plate back until it stops against the two set screw stops located at the back of the base. Refer to Figure 3.
7. Activate the press according to instructions included with the press to apply the first connector onto the pc board.
8. Slide the slide plate forward to the detented terminating position.
9. Activate the press, and seat the next connector onto the pc board.

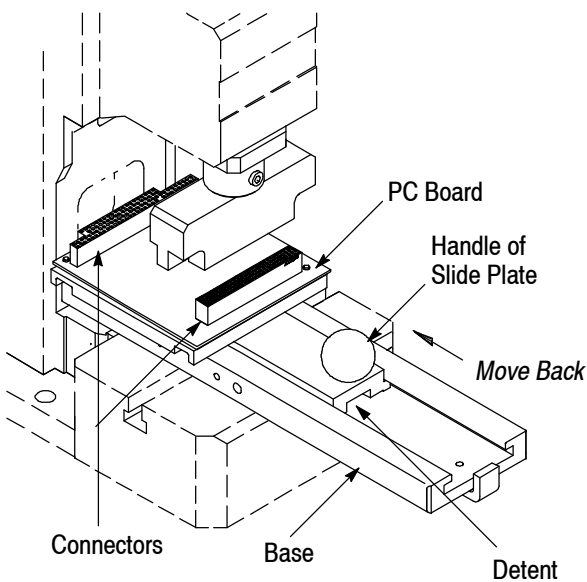


Figure 3

10. Move the slide plate forward (toward the front of the press).
11. Carefully lift the pc board *straight* off of the fixture board.



To avoid bending the contact posts, make sure to carefully lift the pc board straight off of the fixture board.

12. Inspect the applied connectors according to Application Specification 114-13021. If the application is correct, continue applying connectors. If necessary, adjust the shut height according to the instructions included with the press.

**4. ADJUSTMENTS**

The assembly is pre-set and adjustments should not normally be required; however, if adjustments are necessary, proceed with the following.

**4.1. Alignment** (See Figure 4)



For powered presses, make sure to DISCONNECT the power before making adjustments.

1. Loosen the screws securing the slide plate to the base.
2. Align the screws (in the X and Y axis) with the center of the ram.
3. Tighten the screws that were loosened in Step 1.

**4.2. Shut Height and Fine Adjustment**

If shut height or fine adjustment is required, refer to the instructions included with the press.

**5. MAINTENANCE AND INSPECTION**

It is a good policy to periodically inspect and clean the seating tool assembly. Using a clean cloth, wipe dirt and debris from the fixture board assembly. Be sure all hardware is secure.

Occasionally lubricate the slide plate and moving parts with a good grade lubricant.



DO NOT over-lubricate.

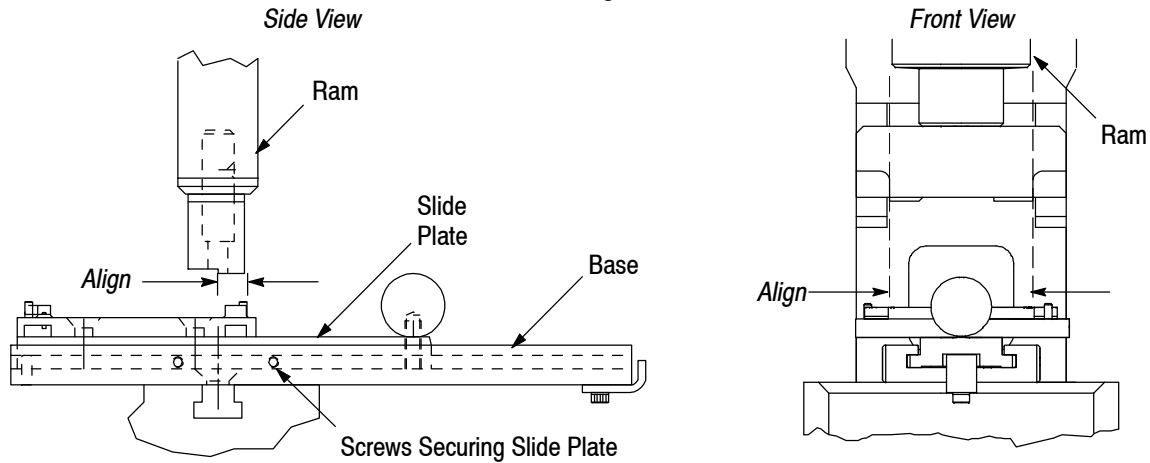
**Alignment**

Figure 4

**6. REPLACEMENT AND REPAIR**

Order seating tool assemblies 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

For customer repair service, call 1-800-526-5136.

**7. REVISION SUMMARY**

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Removed part number for press
- Modified table in Figure 1
- Added Figure 2 and Section 6
- Added Step 12 to Section 3
- Modified Figure 4