

SEATING TOOL NO.	AMP PACE CONNECTOR	
	DUAL POSN	HEIGHT
662860-1	27	19.94 [.785]
662860-2	25	
662860-3	50	

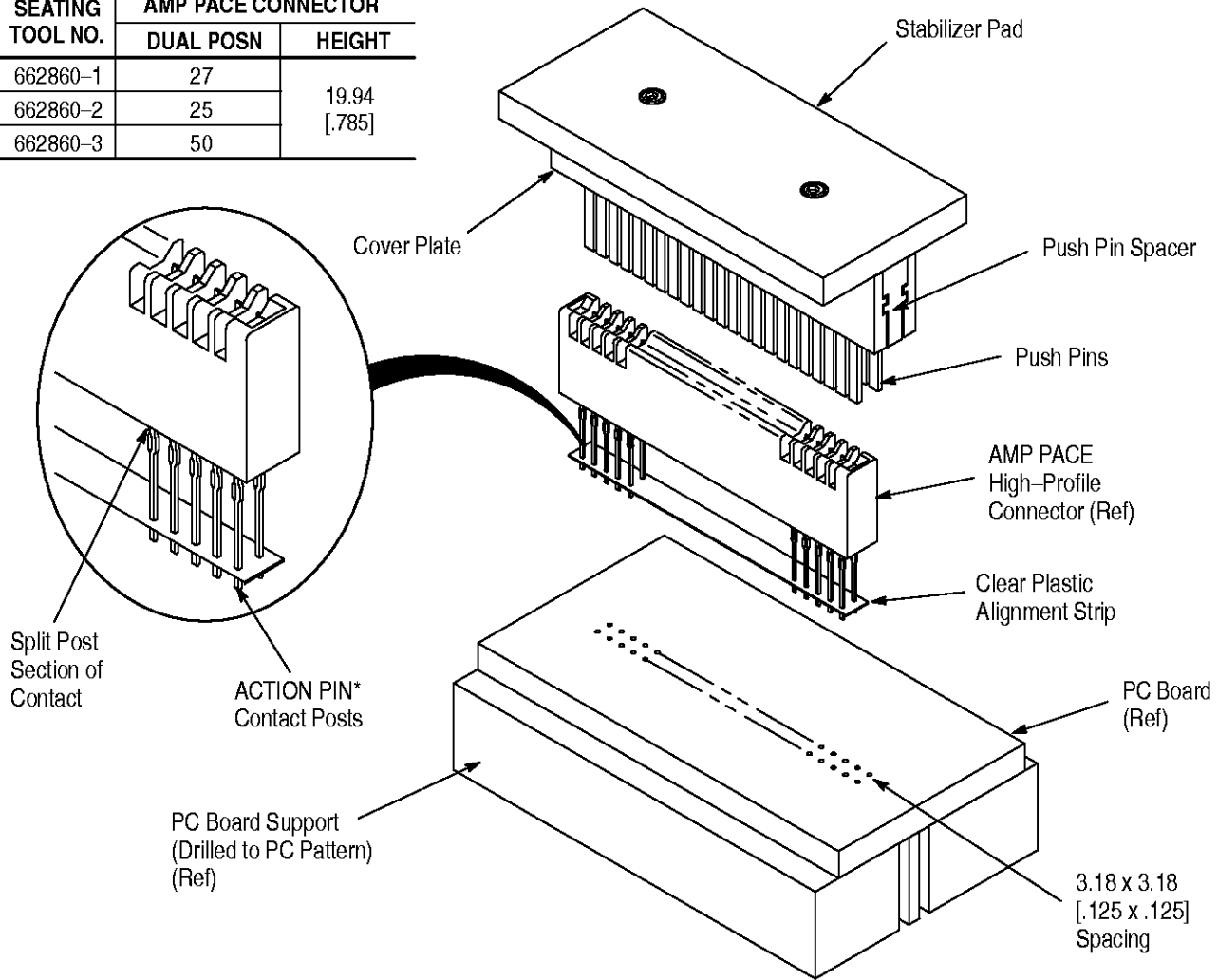


Figure 1

**1. INTRODUCTION**

This instruction sheet covers the use and maintenance of AMP\* Seating Tools 662860-1, -2, and -3. The tools are used to insert AMP PACE high-profile connectors in specific dual-position sizes and heights into printed circuit (pc) boards.

**NOTE** *Dimensions on this sheet are in metric units [with U.S. customary units in brackets]. Figures and illustrations are for identification only and are not drawn to scale.*

Read these instructions and understand them before using the seating tools.

**2. DESCRIPTION** (Figure 1)

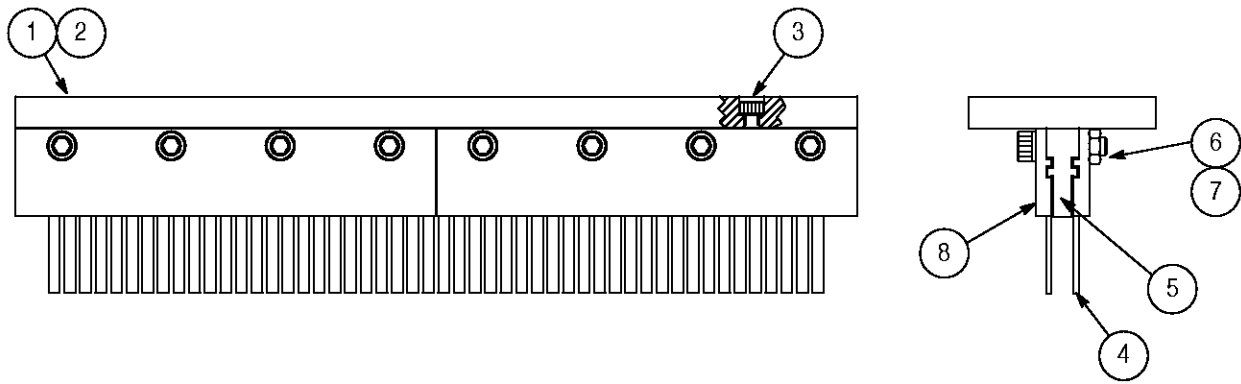
The seating tools are designed for insertion of AMP PACE high profile connectors with ACTION PIN

contacts into drilled pc boards. Each tool features a push pin spacer(s) with cover plates which provides secure mounting and alignment of the push pins. The tools are assembled with screws which secure the cover plates to the push pin spacer. The table in Figure 2 matches tool part number to the number of dual positions.

**3. REQUIREMENTS**

**3.1. PC Board Support Fixture (Customer Supplied)**

A pc board support must be used to provide proper support for the pc board and alignment of the tool to the contact pins, and to protect the pc board and contact posts from damage. You will need to design a board support fixture for your specific needs, using the recommendations in instruction sheet 408-6927.



ITEM	PART NUMBER	DESCRIPTION	TOOL / NUMBER OF DUAL POSITIONS		
			662860-1 / 27	662860-2 / 25	662860-3 / 50
1	662862-1	PAD, Stabilizer	1	1	—
2	662862-2	PAD, Stabilizer	—	—	1
3	1-21000-3	SCR., SHC 4-40 x .25 Lg.	2	2	4
4	312027-2	PIN, Push	54	50	100
5	662859-1	SPACER, Push Pin	1	1	2
6	2-21000-1	SCR., SHC 6-32 x .62 Lg.	4	4	8
7	21018-5	NUT, Hex 6-32	4	4	8
8	662861-1	PLATE, Cover	2	2	4

Figure 2

**3.2. Application Tooling**

The connectors can be seated with an application unit capable of supplying a downward force of 180 Newtons (N) [40 lb] per contact post. AMP 10/20-Ton “H” Frame Assembly 803880-6 is capable of seating force up to 178,000 N [40,000 lbs], while AMP SM-3 Frame Assembly 814700-2 provides up to 27,000 N [6000 lbs]. For operating and setup procedure of the frame assemblies, refer to customer manual 409-5567 (10/20-Ton “H” Frame Assembly) and/or 409-5626 (SM-3 Frame Assembly).

**3.3. Alignment Strip**

The connector’s contact tips are held in alignment by a clear plastic strip. The strip also aids in the correct insertion of contacts into their corresponding holes in the pc board, and should *not* be removed during or after seating the connector.

**4. SEATING AMP PACE HIGH-PROFILE CONNECTORS**

1. Set seating height to the dimension shown in Figure 3. (Applicator shut height will equal the seating height PLUS the combined thicknesses of the pc board and pc board support.)

2. Select the correct tool for seating the connector on the pc board. Make sure that the size (number of dual positions) of the connector is compatible with the tool.

**CAUTION**

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

3. Make certain that board hole pattern will accept the connector.

4. Place an appropriate board support (Figure 1) under the pc board to provide support for the board and to protect the contact posts during insertion.

5. Insert the contact posts into the pc board until the plastic strip bottoms on the split post section of the contacts.

6. Seat tooling on connector, ensuring that push pins are properly aligned with the contacts and are fully depressed into the housing.

7. *Slowly* lower the ram to verify that the connector is aligned with the tooling. The push pins will push the contact posts into the board to the correct depth.

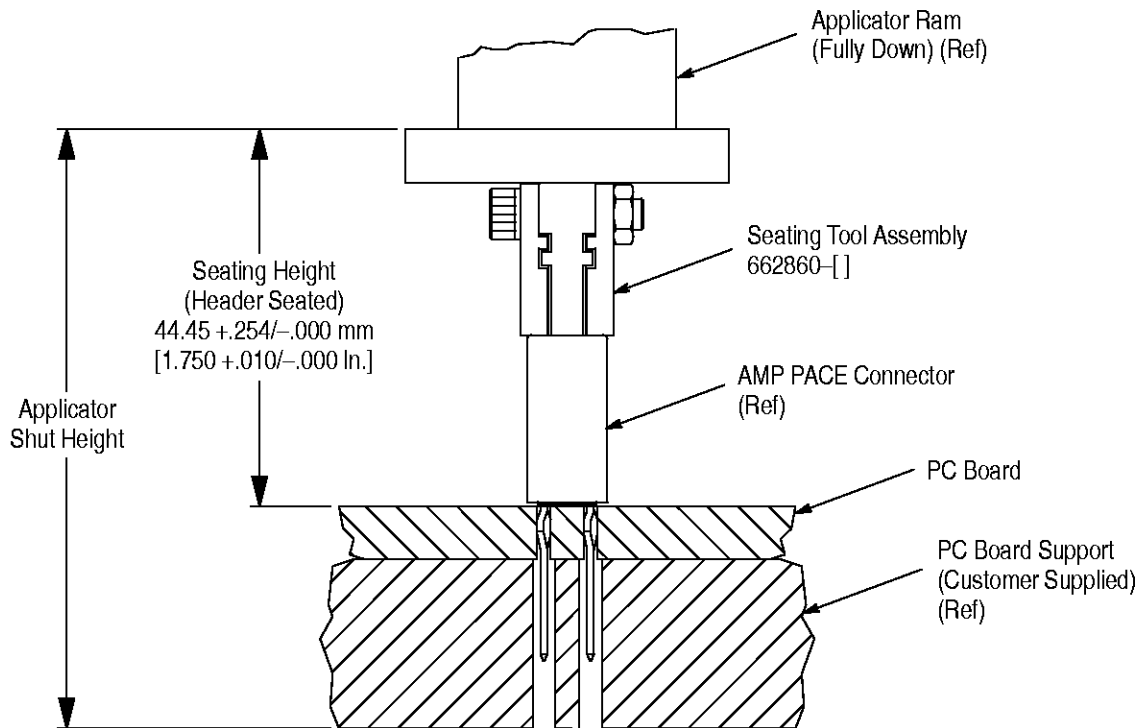


Figure 3

8. Apply force to the ram to seat the connector.
9. Retract the machine ram.
10. Repeat Steps 5 through 9 until all connectors are seated on the board.

## 5. TOOL INSPECTION

The seating tool is assembled and inspected before shipment. It is recommended that the tool be inspected immediately upon its arrival at your plant to ensure that it has not been damaged during shipment.

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

## 6. 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 other contaminants with a clean, soft brush, or lint-free cloth. Do NOT

use objects that could damage the tool or any of its components.

2. Ensure that the screws are in place and secured.

3. When the tool is not in use, store it in a clean, dry area.

## 7. REPLACEMENT AND REPAIR

The parts listed in Figure 2 are customer-replaceable. A complete inventory can be stocked and controlled to prevent lost time when replacement of parts is necessary. Order replacement parts through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (38-35)  
AMP INCORPORATED  
P.O. BOX 3608  
HARRISBURG, PA 17105-3608

Tools may be returned to AMP for evaluation and repair. For repairs, send tool, with a written description of the problem, to:

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