

Figure 1

cad

## 1. INTRODUCTION

This instruction sheet covers the use and maintenance of AMP Seating Tools with base part number 90687. The tools seat AMP Micro-Strip Pin Headers to printed circuit (pc) boards. These headers contain ACTION PIN contacts for solderless pc board retention.

### NOTE

All dimensions on this document are in metric units [with U.S. customary units in brackets].

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

## 2. DESCRIPTION

The seating tool assembly consist of an adaptor and

one or more blades held to the adapter by setscrews, as shown in Figure 1.

During seating, the tool blade sits inside the header housing and engages both the contact shoulders and the housing floor, preventing contacts from pushing out of the housing.

Power for the seating tools must be provided by a machine capable of supplying a downward force of 133 N [30 lbs.] per contact. For best results, use AMP 10/20 Ton "H"-Frame Power Unit Machine 803880-6 (AMP Customer Manual 409-5567 provides instructions) or AMP SM-3 Machine 814700 (409-5626). 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 of instruction sheet 408-6927.

## VIEW AFTER SEATING

NOTE: Not to Scale

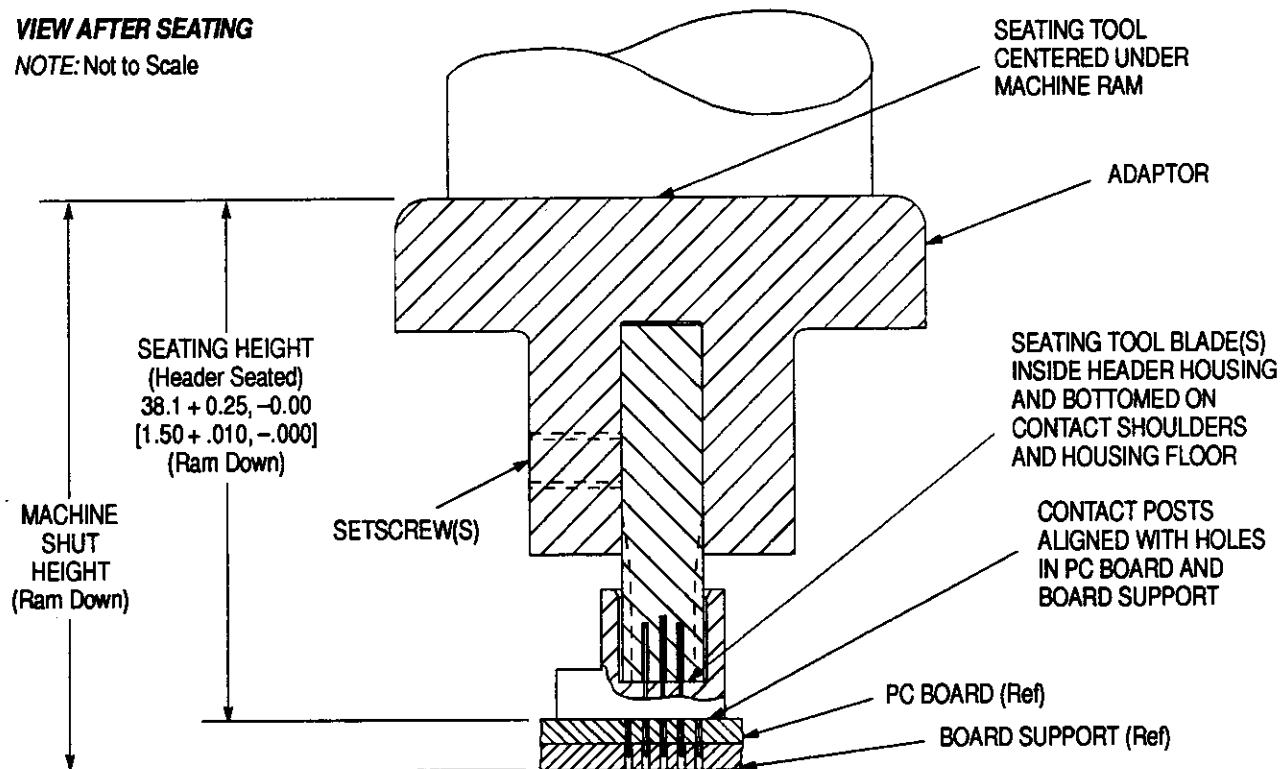


Figure 2

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## 3. SEATING PIN HEADER

1. Set seating height to the dimension shown in Figure 2. (Machine shut height will equal seating height **plus** the combined thickness of the pc board and board support).
2. Position header into pc board so that header posts are properly aligned to the board and board support.
3. Insert header into pc board until compliant sections of ACTION PIN posts are resting securely on the board.
4. Position appropriate seating tool blades into header modules (polarized design fits one way only), making sure blades are bottomed on housing floor.
5. Place appropriate adaptor over blade sections and tighten all setscrews needed to hold the blades firmly in the adaptor.
6. Center seating tool, header, pc board, and board support under the ram of the machine 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.

**CAUTION**

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

7. Cycle ram according to instructions for the machine. Check assembly for proper seating,

using the requirements of AMP Application Specification 114-25036.

8. Remove board and seated pin header, or reposition board and board support for seating of additional headers.

## 4. MAINTAINING THE SEATING TOOL

Inspect the tool when you receive it and at regular intervals. When not in use, store it in a clean, dry area.

## 5. REPLACEMENT AND REPAIR

The parts listed in Figure 1 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 also 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