

Figure 1

**1. INTRODUCTION**

This instruction sheet covers the use and maintenance of AMP\* Seating Tool 904800-1. The tool is used to seat Z-PACK 2mm HM Type N 6-position connectors. The connectors contain compliant lead contacts to allow solderless printed circuit (pc) board installation. See Figure 1.

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

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

**2. DESCRIPTION**

The seating tool consists of an adapter, two blades, and six push pins.

During seating, the tool blades engage the connector housing and the push pins enter the connector contacts to prevent the contacts from being pushed out of the housing.

### 3. REQUIREMENTS

#### 3.1. PC Board Support Fixture

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

#### 3.2. Application Tooling

Power for seating must be provided by a machine capable of supplying a downward force of 400 Newtons (N) [90 lb] per contact. You may use 10/20-Ton "H" Frame Assembly 803880-6 (Customer Manual 409-5567 provides instructions) or SM-3 Frame Assembly 814700-2 (409-5626).

### 4. SEATING

1. Set seating height to the dimension shown in Figure 2 (applicator *shut height* will equal the seating height PLUS the combined thicknesses of the pc board and pc board support).
2. Position the compliant posts of the contacts over the holes in the pc board and board support.

3. Insert the connector contacts into the pc board until the compliant lead section of the contacts are resting securely on, but have not fully entered, the pc board.

4. Position the seating tool into the connector housing, making sure that the tool is bottomed on the housing floor.

5. Center the seating tool and connector under the applicator ram of the power source; slowly lower ram until it just meets the seating tool. Verify the alignment of the board support, pc board, connector, and seating tool.

#### CAUTION

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

6. Cycle applicator ram according to instructions for the power source. Check assembly for proper seating using the requirements in Figure 2.

7. Remove pc board with seated connector, or reposition board and board support for seating additional connectors.

#### View After Seating

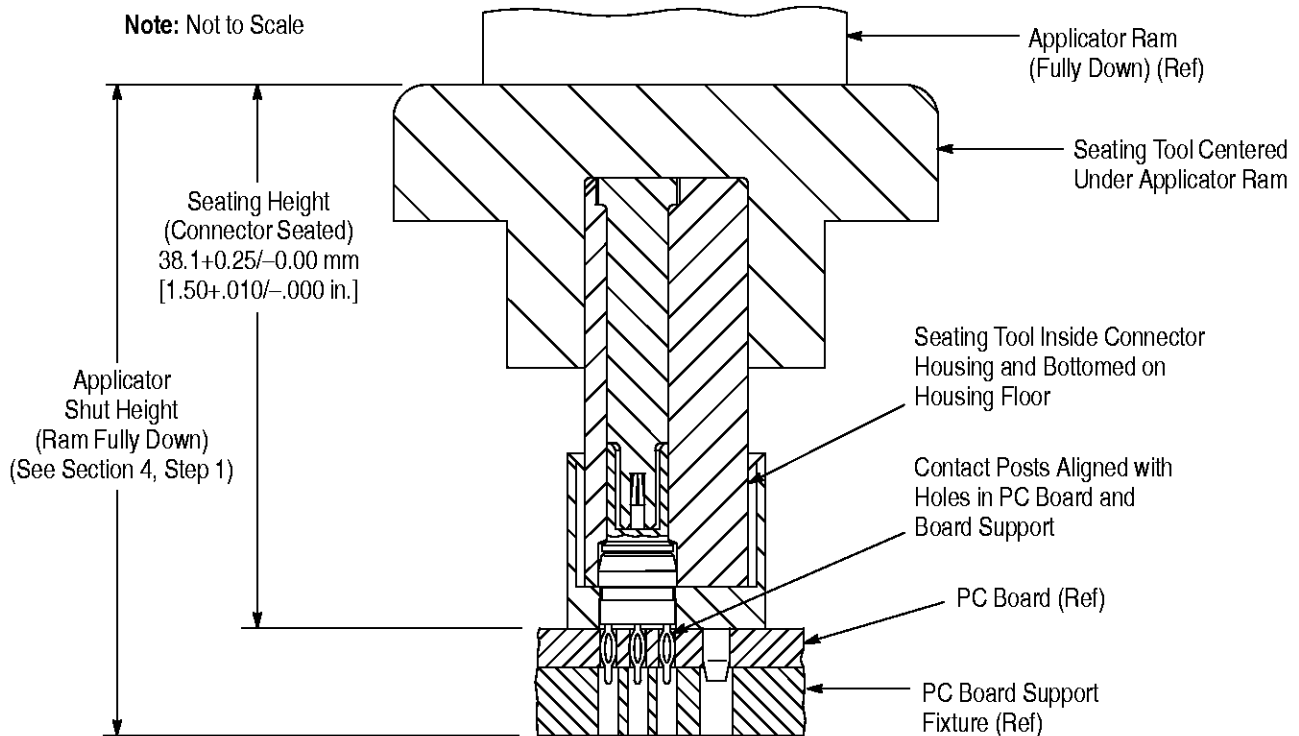


Figure 2

**5. TOOL INSPECTION**

The seating tool is assembled and inspected before shipment. It is recommended that the tool be inspected, using Figure 3, immediately upon its arrival at your facility to ensure that they have 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 them in a clean, dry area.

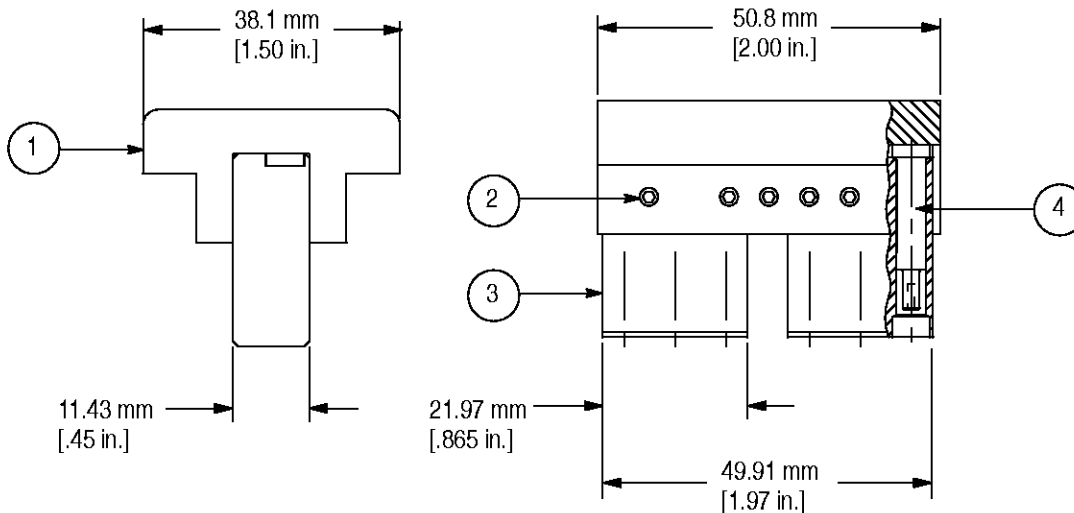
**7. ORDERING INFORMATION AND REPAIR**

Customer-replaceable parts are provided in Figure 3. A complete inventory should 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 717-986-7605 or write to:

CUSTOMER SERVICE (038-035)  
AMP INCORPORATED  
PO BOX 3608  
HARRISBURG PA 17105-3608

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

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



**REPLACEABLE PARTS**

ITEM	PART NUMBER	DESCRIPTION	QTY PER TOOL
1	354698-1	ADAPTER, 50.8+0.00/-0.10 mm [2.00+.000/-0.004 in.] L	1
2	2-21012-8	SCREW, 6-32 x .19 in. L	5
3	904801-1	BLADE, 21.97+0.00/-0.10 mm [.865+.000/-0.004 in.] L	2
4	904802-1	PUSH PIN, 24.59+0.00/-0.10 mm [.968+.000/-0.004 in.] L	6

Figure 3