

HEADER ASSEMBLIES	
102897	102899
102898	103035

Fig. 1

**1. INTRODUCTION**

This instruction sheet (IS) covers the use of AMP Seating Tool 91171-1 which is used to install AMPMODU ACTION PIN Header Assemblies listed in Figure 1 into printed circuit (pc) boards. Read these instructions thoroughly before using the tool.

**NOTE** All dimensions on this instruction sheet are in inches.

**2. DESCRIPTION (Figure 1)**

The seating tool features a slotted tip which fits over the header assembly during termination. An adapter, located on top of the seating tool, is used to push the

seating tool to terminate the contacts into the pc board.

The seating tool is used with an arbor frame assembly capable of exerting a force of 50 lb per contact. An anvil (customer-supplied) must also be used during termination. The anvil in Figure 1 is shown for reference only. Anvils are designed for use with the particular pc board and header assembly to protect the contact posts during the insertion process.

**NOTE** The shut height, which is the distance between the ram of the frame assembly and the top of the pc board when the ram is fully bottomed, should be set to 1.5 in.

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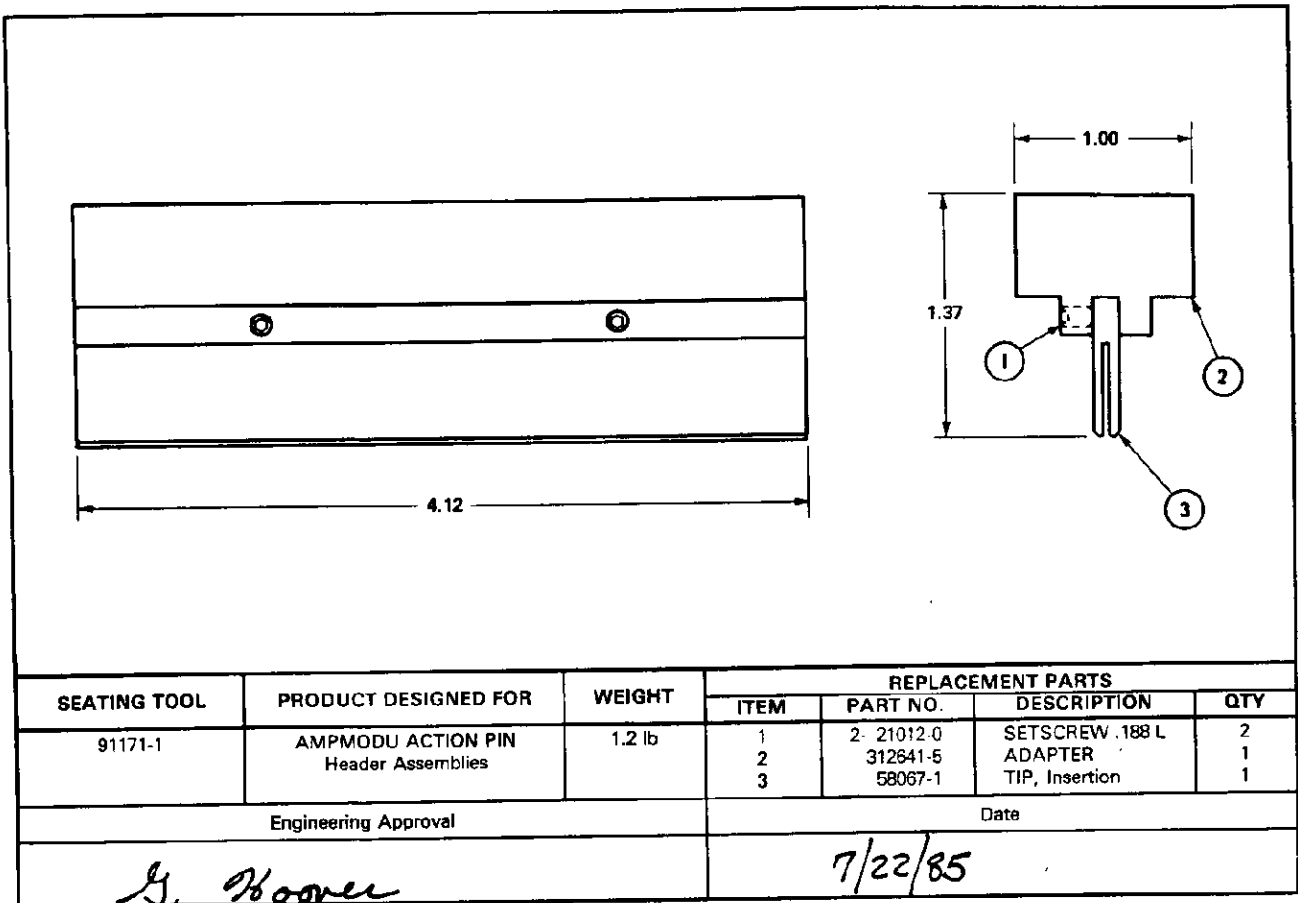


Fig. 2

**3. TERMINATING PROCEDURE (Figure 1)**

1. Start contact posts into pc board.
2. Place seating tool over top of contacts in header assembly.
3. Position pc board assembly on anvil so that the row of board holes and contacts align with slot of anvil. Make sure header assembly and seating tool are centered under the ram of the frame assembly.
4. Lower handle of frame assembly and apply pressure until seating tool FULLY seats header assembly onto pc board, then raise handle.
5. Carefully remove pc board from anvil, and

remove seating tool from header assembly.

**4. TOOL CERTIFICATION**

AMP Seating Tool 91171-1 should be certified with the information provided in Figure 2. The tool should be inspected immediately upon its arrival at your facility to be sure it has not been damaged in transit, and at regularly scheduled intervals to be sure it remains functional.

Additional tools can be purchased from:

AMP Incorporated  
 P.O. Box 3608  
 Harrisburg, PA 17105