

Figure 1

1. INTRODUCTION

AMP* Seating Tools 1214215-1 and 356381-1 and Board Support Anvil 356382-1 are used to seat AMP FB (Futurebus+) Coaxial Connectors 415303-1. The connectors contain compliant lead contacts to allow solderless printed circuit (pc) board installation. See Figure 1.

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

NOTE

All dimensions on this document are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 8, REVISION SUMMARY.

2. DESCRIPTION

During seating, the seating tool covers the connector and presses on the top surface of the connector when the applicator ram applies force to the seating tool. The board support anvil is positioned into a pc board support fixture to support the pc board.

NOTE

Seating Tool 1214215-1 is used for seating connectors loaded with contacts in the bottom row only.

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 tool to the connector pins, and to protect the pc board and connector contacts from damage. AMP PC Board Support Fixture 679980-[] is available and recommended for use with this seating tool and board support anvil. For proper selection and detailed information, refer to instruction sheet 408-4038.

NOTE

As an alternative, you can design a pc board support fixture for your specific needs, using the recommendations in 408-6927.

3.2. Application Tooling

Power for seating tool must be provided by a machine capable of supplying a downward force of 89 Newtons (N) [20 lb] per contact. You may use AMP 10/20-Ton "H"-Frame Assembly 803880-6 (Customer Manual 409-5567 provides instructions) or AMP SM-3 Frame Assembly 814700-2 (409-5626).

2. Position board support anvil, grooved side up, into the pc board support fixture and center under the applicator ram of the power source. Position pc board over board support anvil.

3. Position connector into pc board so that connector contacts are properly aligned to the pc board and the board support anvil. See Figure 2.

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

5. Position the seating tool onto the connector.

6. Center 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, seating tool, and board support anvil.

CAUTION

Damage to the pc board, tool, or connector may occur if seating height is improperly set, if pc board is not properly positioned over the board support anvil, or if tool is not properly seated on the connector before cycling the applicator ram.

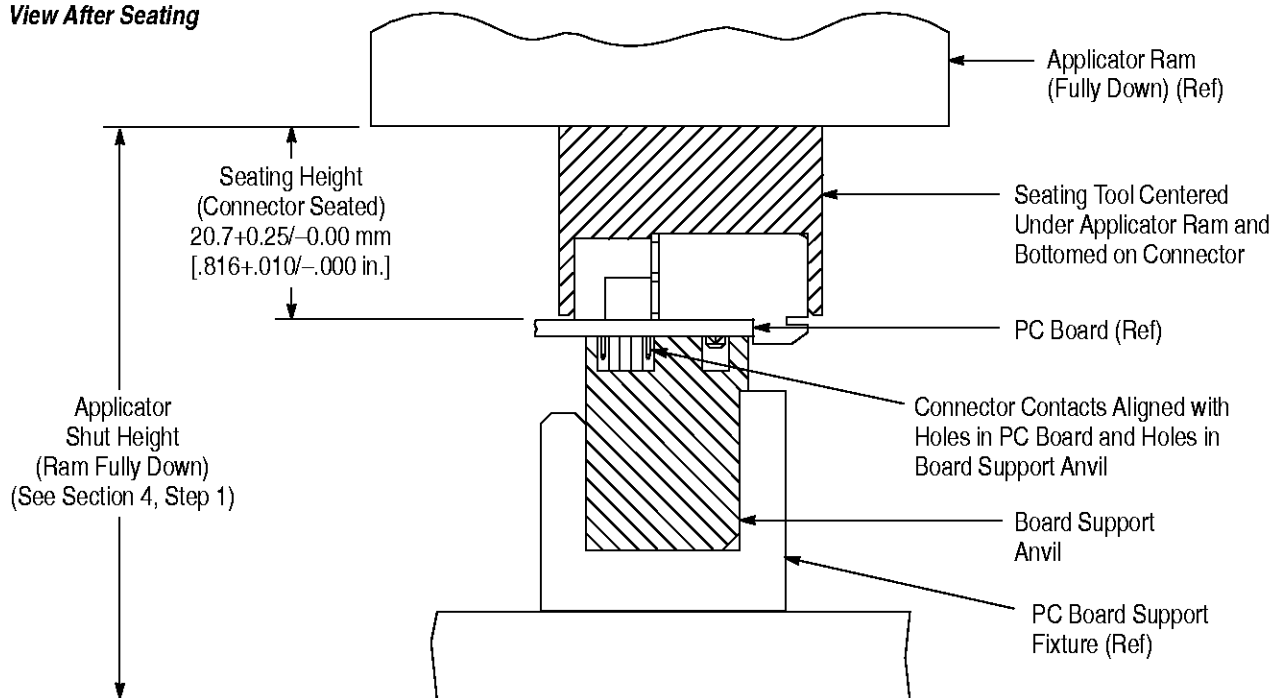
4. SEATING

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).

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

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

View After Seating



Note: Not to Scale

Figure 2

5. TOOL INSPECTION

The seating tool and board support anvil are inspected before shipment. It is recommended that the tool and anvil be inspected, using Figure 3, immediately upon its arrival at your facility 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 and anvil. 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 anvil.
2. When the tool or anvil are not in use, store them in a clean, dry area.

7. ORDERING INFORMATION AND REPAIR

Order additional tools and anvils 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 (038-035)
AMP INCORPORATED
PO BOX 3608
HARRISBURG PA 17105-3608

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

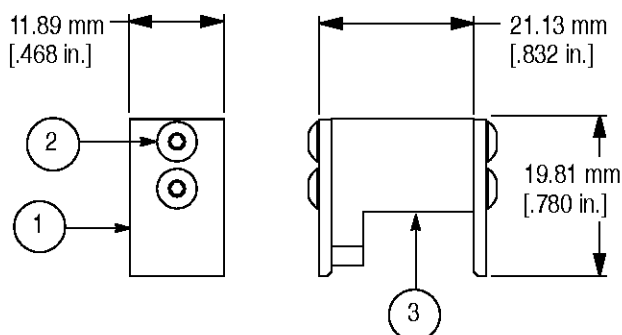
CUSTOMER REPAIR (01-12)
AMP INCORPORATED
1523 NORTH 4TH STREET
HARRISBURG PA 17102-1604

8. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0183-98 include:

- Added Seating Tool 1214215-1

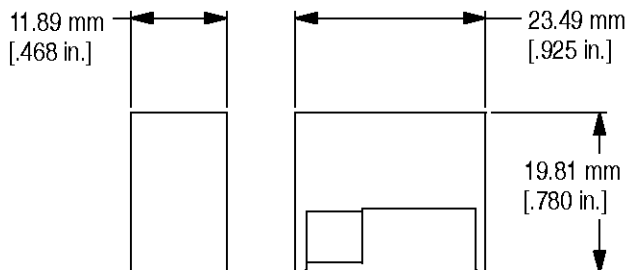
Seating Tool 1214215-1



REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER TOOL
1	1214217-1	PLATE, End	2
2	1-21002-3	SCREW, 4-40 X .25 L	4
3	1214216-1	BODY, Mini Coax	1

Seating Tool 356381-1



Board Support Anvil 356382-1

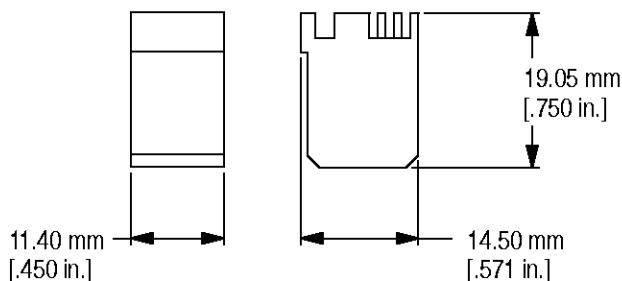


Figure 3