

SEATING TOOL	NO. OF ROWS	NO. OF POSITIONS
91311-1	12	72
91311-2	12	144

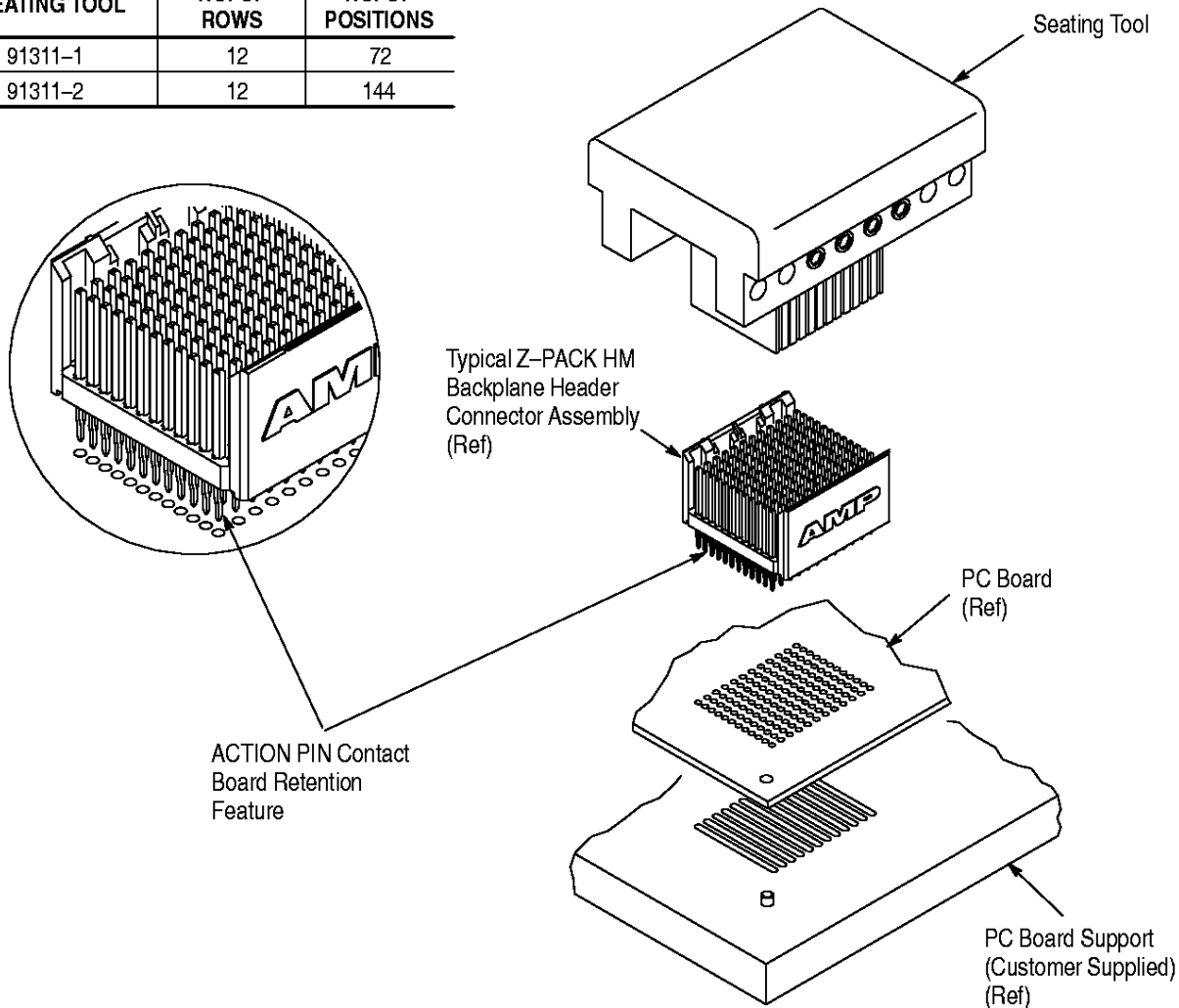


Figure 1

1. INTRODUCTION

This instruction sheet covers the use and maintenance of AMP* Seating Tool 91311-[]. These tools are used to seat Z-PACK HM Backplane Connectors with ACTION PIN contacts to allow solderless printed circuit (pc) board installation.

NOTE

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

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

2. DESCRIPTION

The seating tool is an assembly of plates, bars, and an adapter to seat various sizes of connectors.

Figure 1 matches tool part number to the size header to be seated.

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

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 header pins, and to protect the pc board and header posts from damage. Design a pc board support fixture for your specific needs, using the recommendations in AMP instruction sheet 408-6927.

3.2. Application Tooling

Power for seating tools 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-[] (409-5626).

4. SEATING A PIN HEADER

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 header into pc board so that header posts are properly aligned to the board and board support.
3. Insert header into pc board until the ACTION PIN post sections are resting securely on, but have not fully entered, the board.
4. Position the appropriate seating tool into the header, making sure the tool is bottomed on the housing floor

5. Center seating tool and header under the applicator ram of the power source 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 pc board, 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 applicator ram.

6. Cycle applicator ram according to instructions for your power source. Check assembly for proper seating, using the requirements of the AMP Application Specification.
7. Remove board with seated pin header, or reposition board and support for seating additional headers.

5. TOOL INSPECTION

Each seating tool is assembled and inspected before shipment. AMP recommends that the tool be inspected, using Figure 3, immediately upon its arrival in your plant to assure that it has not been damaged during shipment.

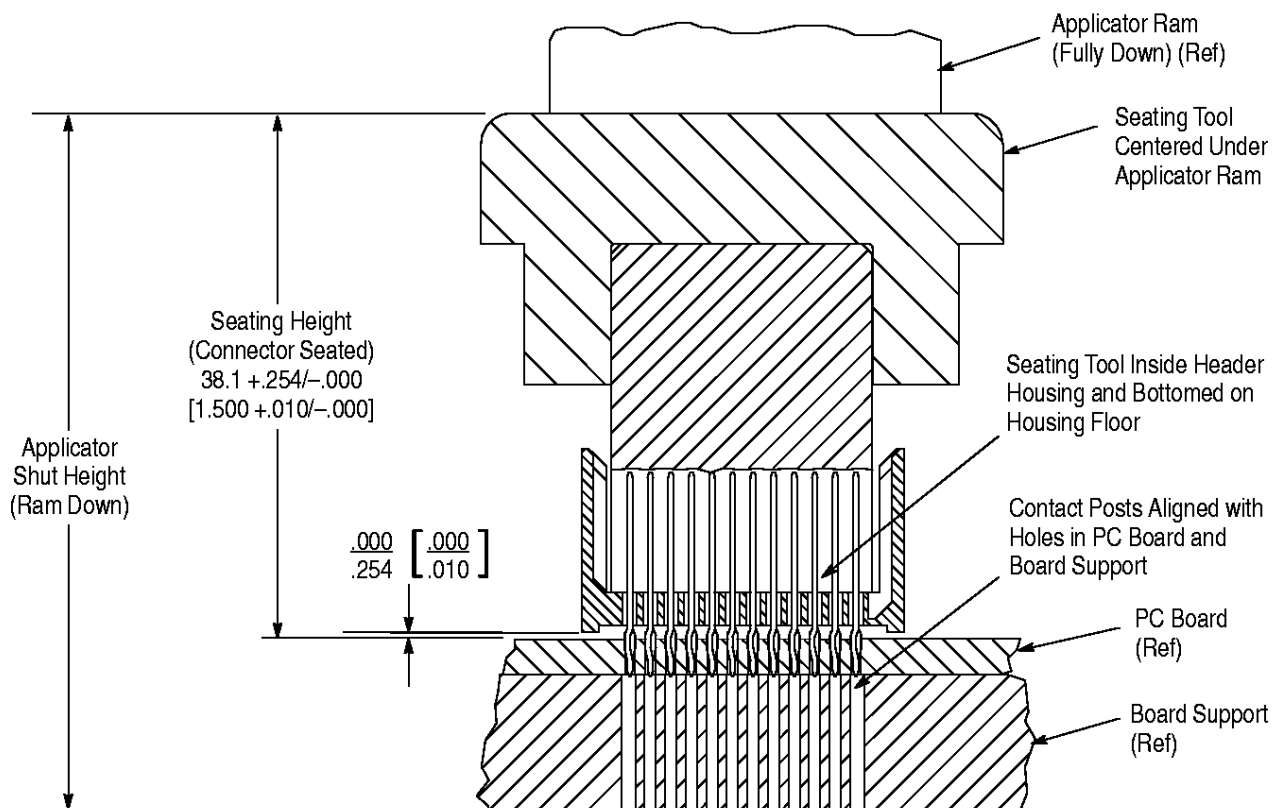
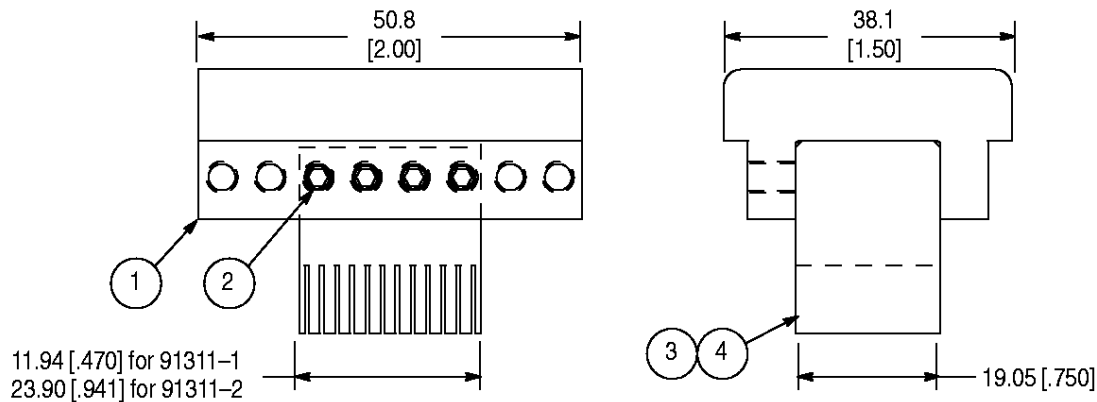


Figure 2

Seating Tool 91311-[]



ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY PER TOOLING ASSEMBLY	
			91311-1	91311-2
1	1320190-1	Adapter	1	1
2	2-21012-8	Screw, Set	2	4
3	1320191-1	12 Row Signal Pin Bar	1	—
4	1320191-2	12 Row Signal Pin Bar	—	1

Figure 3

6. MAINTENANCE/INSPECTION

6.1. Daily 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.

6.2. Periodic Inspection

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.

7. REPLACEMENT AND REPAIR

The parts listed in Figure 3 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

8. REVISION SUMMARY

Per EC 0990-0408-99

- Initial release of instruction sheet