

**NOTE**

All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of  $\pm 0.13$  [.005] and angles have a tolerance of  $\pm 2^\circ$ . Figures and illustrations are for identification only and are not drawn to scale.

**1. INTRODUCTION**

This specification covers the application requirements of the AMP\* Sonic Welded PCMCIA PC (Printed Circuit) Card Frame Kit Assembly. The assembly consists of a top cover, bottom cover, and a customer supplied pc board.

Basic terms and features of components are provided in Figure 1.

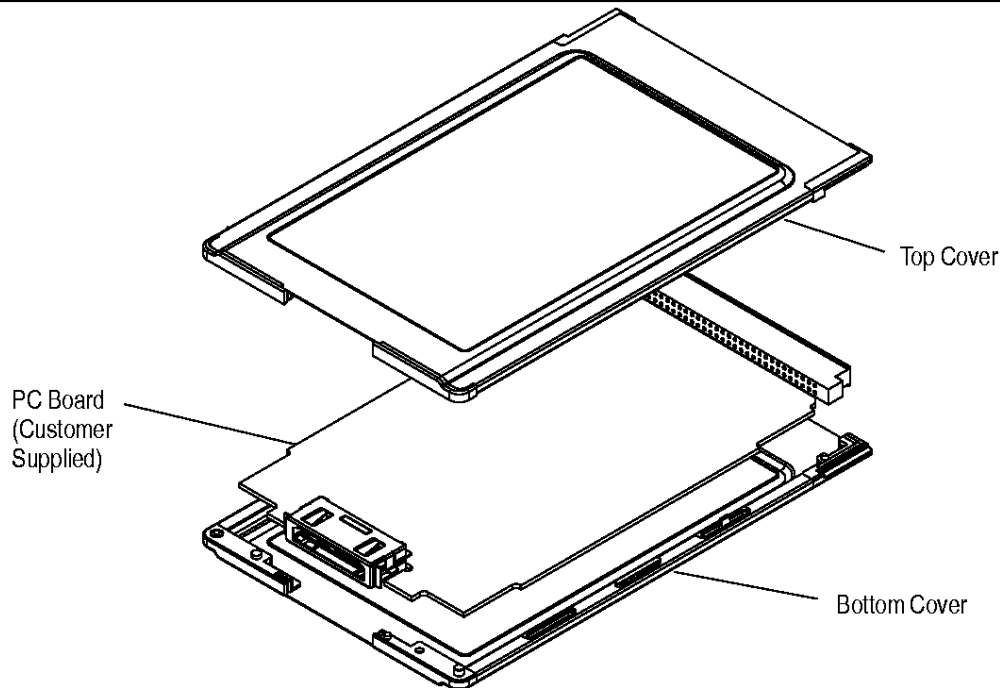


Figure 1

**2. REFERENCE MATERIAL****2.1. Revision Summary**

Per EC 0990-0316-97

- Initial release of application specification

**2.2. Customer Assistance**

Reference Part Number 406062 and Product Code 2281 are representative numbers of the PCMCIA PC Card frame kit product line. Use of these numbers will identify the product line and expedite your inquiries through an AMP service network established to help you obtain product and tooling information. Such information can be obtained through a local AMP Representative (Field Sales Engineer, Field Applications Engineer, etc.) or, after purchase by calling the Tooling Assistance Center or the AMP FAX/Product Information number at the bottom of this page.

**2.3. Drawings**

Customer Drawings for specific products are available from the responsible AMP Engineering department via the service network. The information contained in the Customer Drawings takes priority if there is a conflict with this specification or with any other technical documentation supplied by AMP Incorporated.

**3. REQUIREMENTS**

**3.1. Welder**

The Branson Model 920 IW Welder is recommended for assembling the pc card frame kit assemblies. The welder and accessories can be ordered from the address shown in Figure 2.

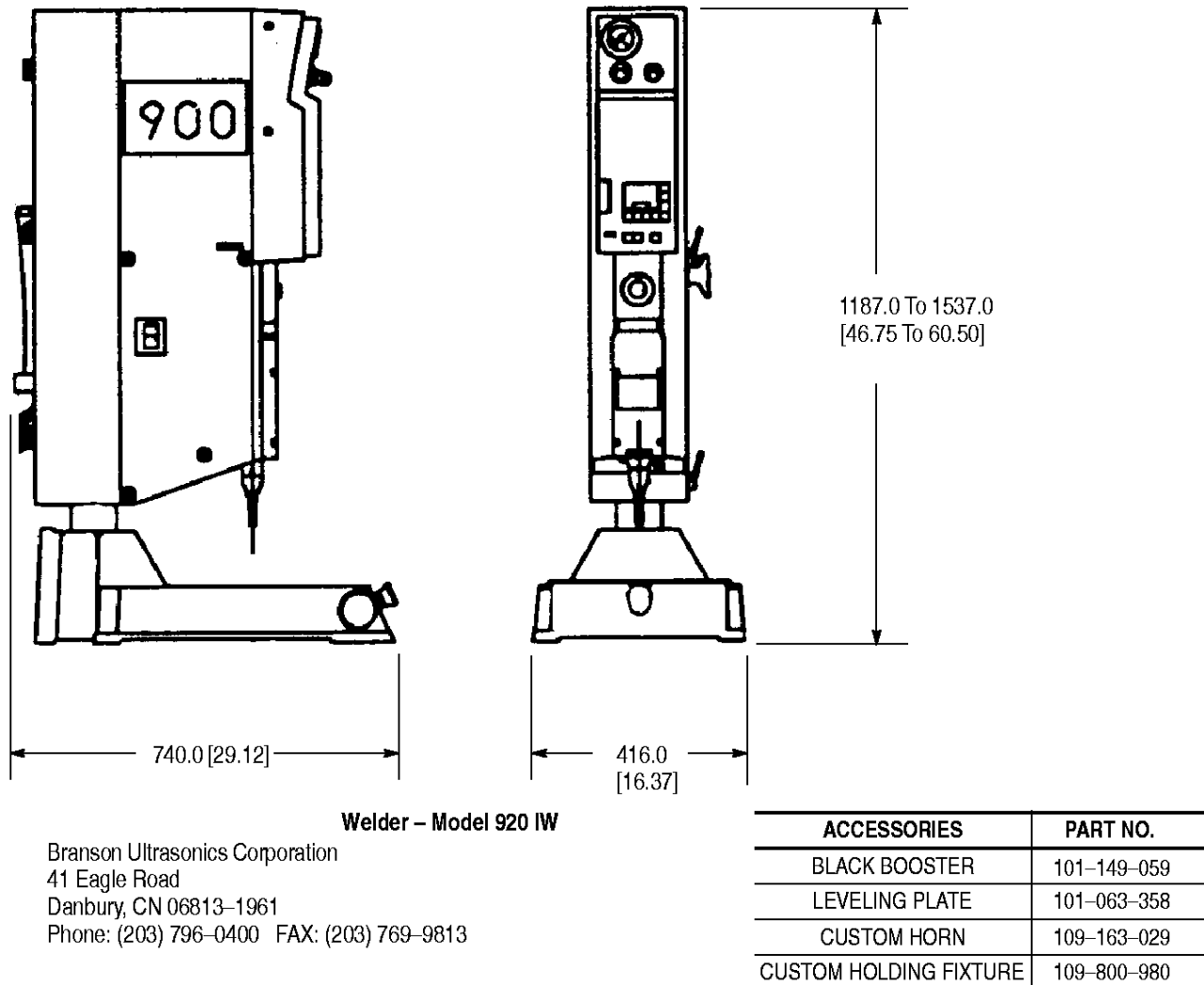


Figure 2

**3.2. Welding Parameters**

After the welder and accessories are assembled, program the following for the pc card:

- Weld Time – 300 milliseconds
- Trigger Pressure – 6
- Air Pressure – 207 kPa [30 psi (pounds per square inch)]
- Hold Time – 1 second
- AB Delay – off
- AB Time – off
- Down Speed – full open

**4. QUALIFYING SUPPORT**

The Sonic Welded PCMCIA PC Card assemblies are not required to be listed or recognized by Underwriters Laboratories Inc. (UL), or the Canadian Standards Association (CSA).

## 5. TOOLING (Figure 3)

Place the pc card assembly into the holding fixture and proceed with the instructions provided with the Branson Model 920 IW Welder.

The welder should be set up per instructions provided with the Branson welder. Once that is complete, go to the operations section of the manual and adjust to parameters as stated. Use Welding Parameters (as stated in Paragraph 3.2.) as a starting point. Vary weld time and air pressure to optimize weld to desired strength.

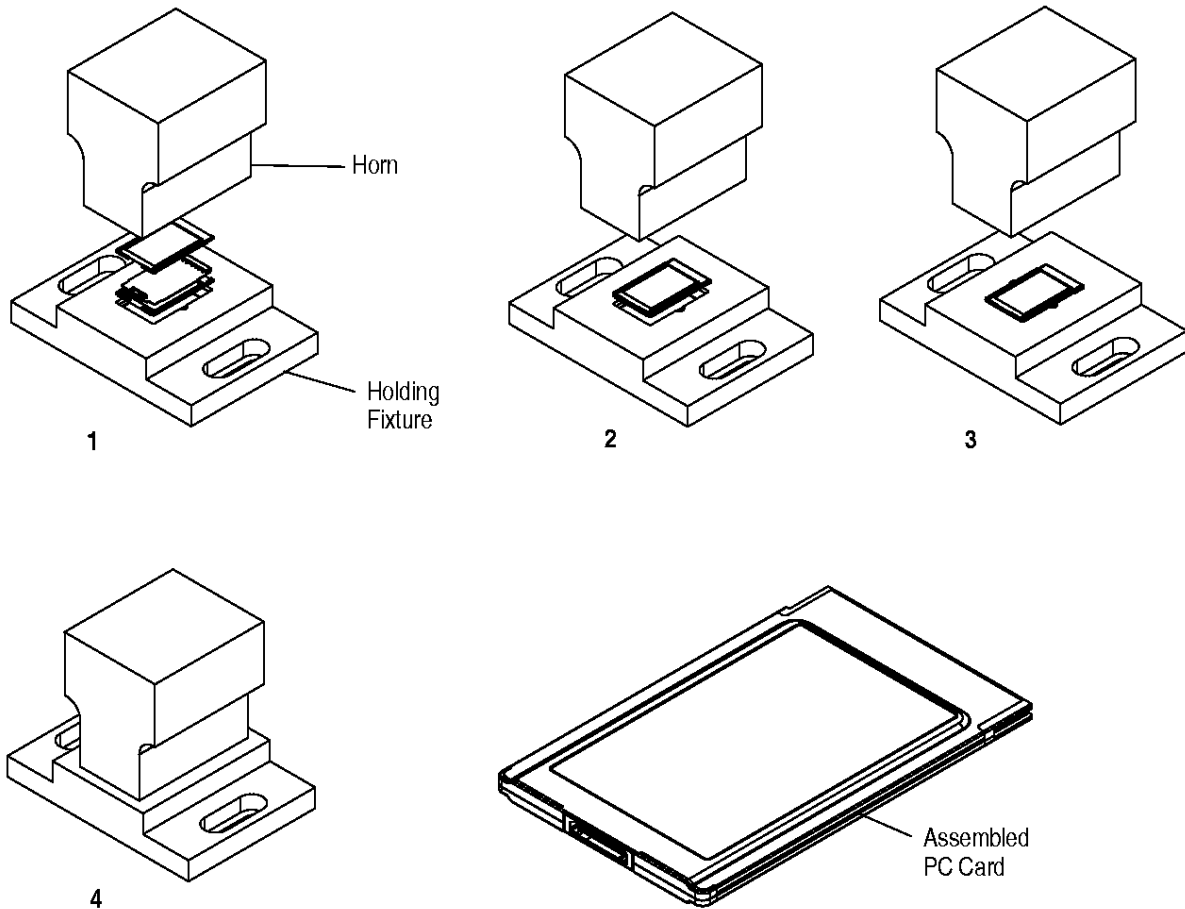
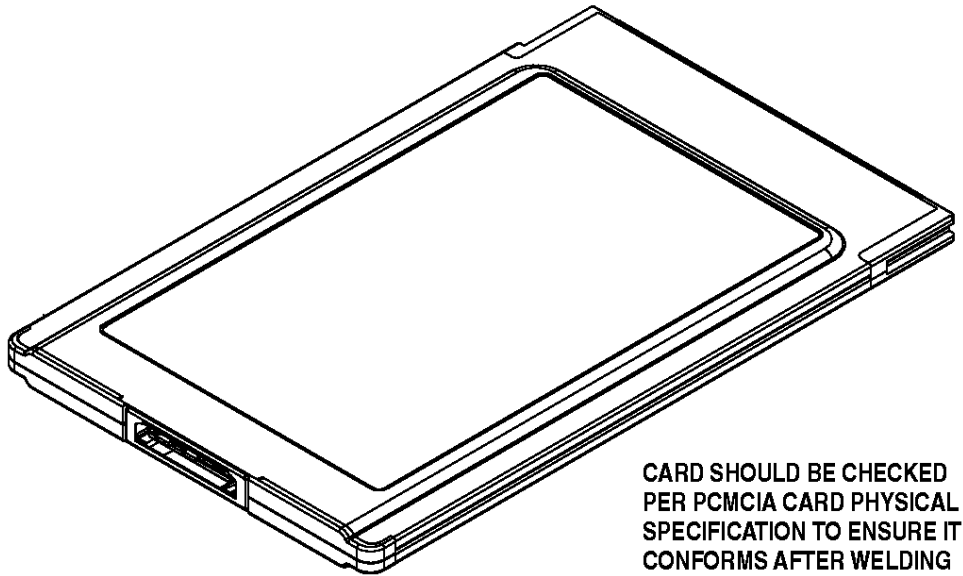


Figure 3

**6. VISUAL AID**

The following illustration will assist production personnel to check for properly applied product.



**FIGURE 4. VISUAL AID**