

Application Tooling

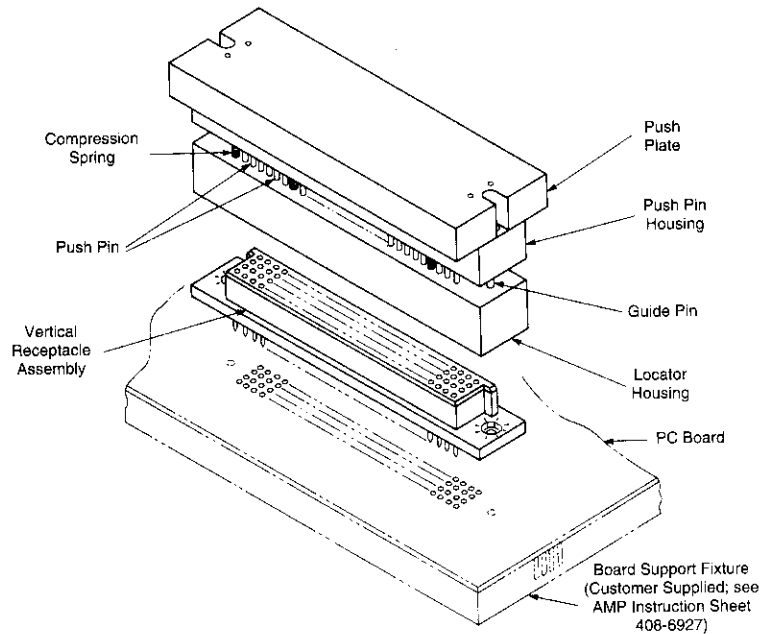
Receptacle assemblies with ACTION PIN contacts allow high speed, solderless backplane construction through reliable press-fit application. Press fitting connectors to printed circuit boards requires special seating tools which transfer application force directly to the contacts.

Each spring-loaded seating tool features a push plate, push pin housing, and locator housing. The push plate provides the bearing surface for the application tooling which forces the ACTION PIN posts into the PC board. The push pin housing holds the same number of push pins as the connector size (no. of contact positions). The locator housing fits over the connector body to align the components for proper seating. Compression springs (approximately one for every seven contacts) and guide pins (one at each end) provide tool alignment and stability.

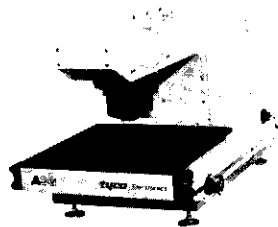
Board support fixtures are used to support PC boards or backplanes while connectors are being assembled to the boards or backplanes. AMP Instruction Sheet 408-6927 provides recommendations for manufacturing board support fixtures.

Force applied to the tool to seat the connectors can be provided by the AMP seating machines shown below, or by commercially available hand-operated arbor presses such as Greenard 3A or 3B. Refer to Instruction Sheet 408-9027 for use of AMP adapter kits with these presses.

For tooling information, contact Technical Support.

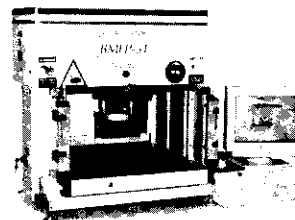


Receptacle Assembly Configuration			Seating Tool Numbers
No. of Rows	No. of Pins/Row	Total No. of Pins	
Four (without Guide Holes)	25	100	58279-2
	30	120	58279-4
	32	128	58279-8
	35	140	58279-9
	45	180	58279-5
	60	240	58279-3
	65	260	58279-7
	67	268	58279-1
Three (without Guide Holes)	75	300	58279-6
	32	96	58277-2
	33	99	58277-3
	50	150	58277-4
Two (without Guide Holes)	67	201	58277-1
	15	30	58280-4
	28	56	58280-1
	35	70	58280-6
	60	120	58280-5
	67	134	58280-2
	70	140	58280-3



MANTA Servo Electric Press

Electric Servo Press created to satisfy the increasing need for a "Low Cost" method of controlled connector pressing into today's complex circuit boards. The MANTA can precisely control force and speed of each pressing cycle. Quality feedback is accessible in the form of SPC analysis, display, and reports. The "C-Frame" design, with a 12-inch throat depth, accommodates a wide range of smaller printed circuit boards.



BMEP-3T/5T Bench Top Electric Servo Press (3 or 5 ton)

PC-controlled, cost effective bench mounted machine for semi-automatic pressing of ACTION PIN (Compliant Pin, Pressfit) connectors into printed circuit boards. The pressing force is delivered by an all-electric servomotor, providing precise control of force, speed, and seating height. A touch screen monitor provides a user-friendly interface and a bar code scanner provides PCB serial number input for product tracking.