

**Seating Tool
1214224-[]**

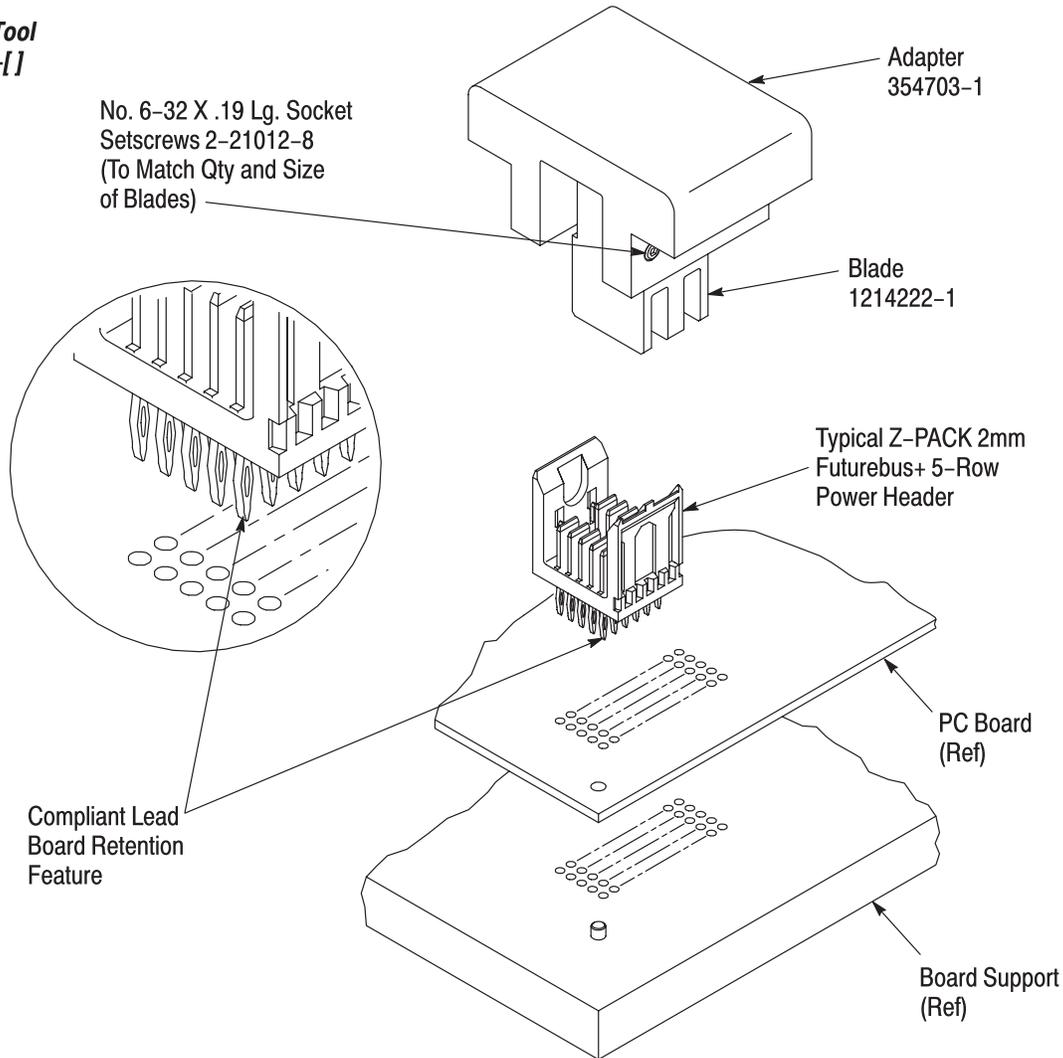


Figure 1

1. INTRODUCTION

This instruction sheet covers the use and maintenance of Seating Tools with base part number 1214224. See Figure 1. These tools are used to seat Z-PACK 2mm Futurebus+ 5-Row Power Headers. All these headers contain compliant lead contacts to allow solderless printed circuit (pc) board installation.

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

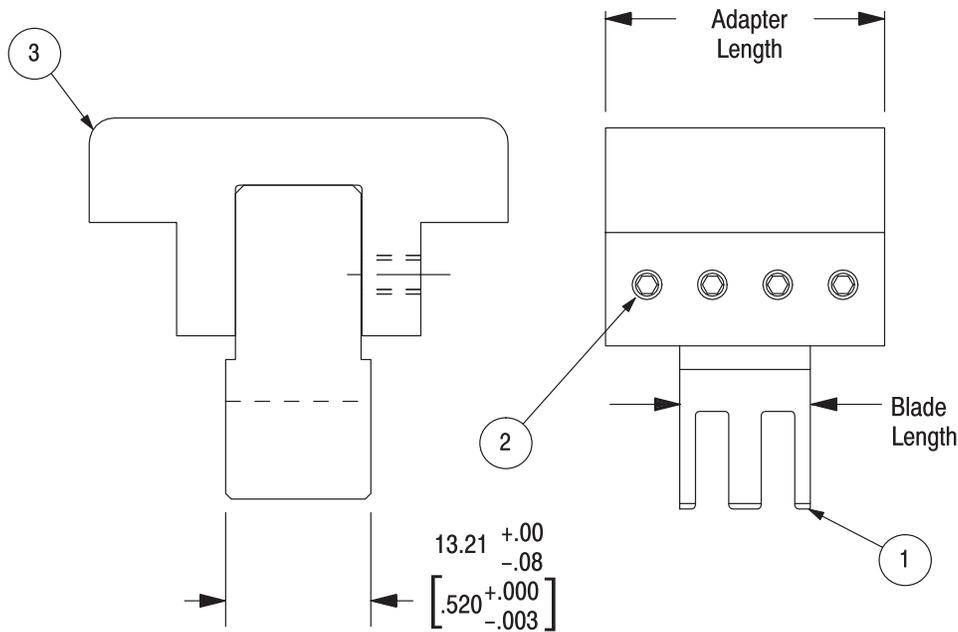
Reasons for reissue are provided in Section 8, REVISION SUMMARY.

NOTE *All dimensions in this document are in millimeters [with inches in brackets]. Figures and Illustrations are for reference only and are not drawn to scale.*

2. DESCRIPTION

Each seating tool is an assembly of one *blade* to one *adapter*. The table in Figure 2 matches tool part number to the size header to be seated. The adapter straightens the connector during cycle of applicator ram, to provide proper insertion into the pc board. When seating the connector, the blades are positioned over the contact shoulders to prevent damage to the contacts. Each tool is designed with a specific combination of contacts in a row and number of rows in a connector.

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



NUMBER OF POWER CONTACTS			10
ITEM	DESCRIPTION	LENGTH +0.00/-0.10 [+.000/-0.004]	QTY PER TOOL 1214224-1
1	BLADE 1214222-1	11.89 [.468]	1
2	SCREW 2-21012-8	SIZE 6-32 X .19 IN LG	4
3	ADAPTER 354703-1	25.4 [1.000]	1

Figure 2

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. You will need to design a board support fixture for your specific needs, using the recommendations in Instruction Sheet 408-6927.

3.2. Application Tooling

The connectors can be seated with an application unit capable of supplying a downward force of 102 Newtons (N) [23 lb] per contact. The 10/20-Ton “H” Frame Assembly 803880-6 is capable of seating up to 1740 contacts, while the SM-3 Frame Assembly 814700-[] can seat up to 261 contacts. For operating and setup procedure of the frame assemblies, refer to Customer Manual 409-5567 (10/20-Ton “H” frame Assembly) and/or 409-5626 (SM-3 frame assembly).

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 post compliant sections are resting securely on, but have not fully entered, the board.
4. Position appropriate seating tool into header, making sure tool is bottomed on 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.



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.

4. SEATING A PIN HEADER

1. Set seating height to the dimension shown in Figure 3. (Applicator shut height will equal the

6. Cycle applicator ram according to instruction for your power source. Check assembly for proper seating, using the requirements of Tyco Electronics Application Specifications.

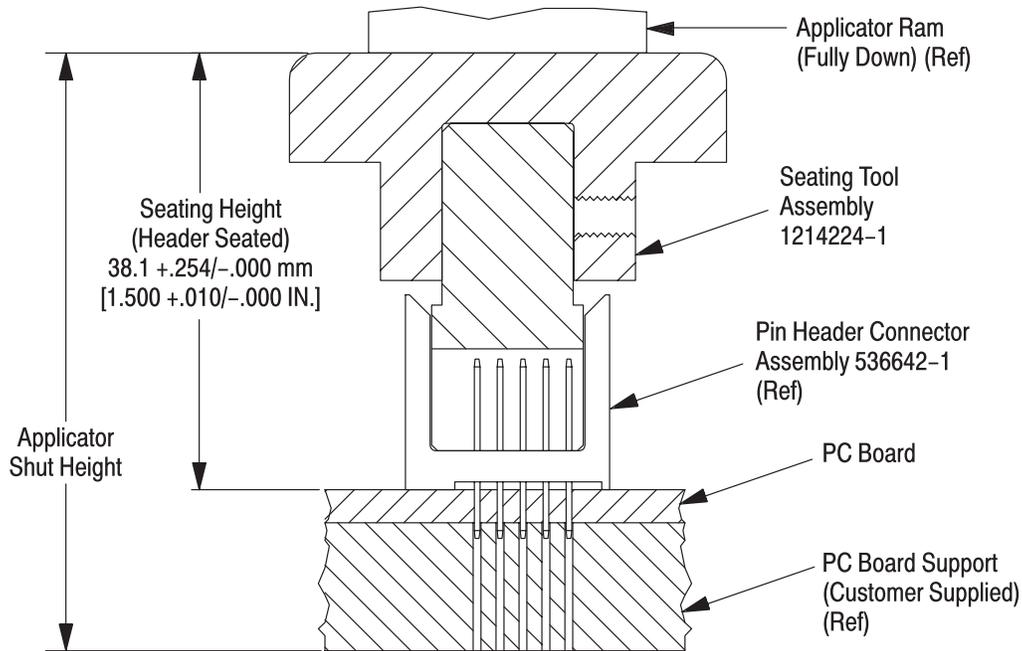


Figure 3

7. Remove board and seated pin header, or reposition board and support for seating of additional headers.

5. TOOL INSPECTION

Each seating tool is assembled and inspected before shipment. Tyco Electronics recommends that the tool be inspected immediately upon its arrival in your plant to ensure that it has not been damaged during shipment.

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 clean 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 1 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 Tyco Electronics 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)
 TYCO ELECTRONICS CORPORATION
 P. O. BOX 3608
 HARRISBURG, PA 17105-3608

Tools may be returned to Tyco Electronics for evaluation and repair. Contact the Tooling Assistance Center number at the bottom of page 1.

8. REVISION SUMMARY

- Updated document to corporate requirements
- New format