

SEATING TOOLS WITH BASE PART NUMBER 91268	-1	-2	-3	-4	-5	-6	-7	-8	-9	-10	-11	-12	-13
CONNECTOR - NUMBER OF POSITIONS	10	14	16	20	24	26	30	34	40	44	50	60	64

Figure 1

**1. INTRODUCTION**

This instruction sheet covers the use of AMP\* Seating Tools 91268-1 through -13 listed in Figure 1 which are used to install AMP-LATCH\* Universal Header ACTION PIN\* connectors into printed circuit (pc) boards. Read these instructions thoroughly before inserting the connectors.

**NOTE** All dimensions are in mm [with inches in brackets].

Reasons for reissue are provided in Section 5, REVISION SUMMARY.

**2. DESCRIPTION**

The seating tools are available in 13 different lengths. They are used with AMP SM-3 Bench Machine 814700-2, AMP H-Frame Machine 803880-6, or a 3-ton manual applicator.

**NOTE**

A suitable three-ton manual arbor frame can be purchased from the following vendors.

Greenerd Press & Machine Co., Inc.  
 41 Crown Street  
 Nashua, NH 03061

or

Dake Corporation  
 390 Robbins Road  
 Grand Haven, MI 49417

**NOTE**

An adapter kit for use with the Greenerd Frame Assembly can be purchased from AMP Incorporated. Refer to AMP instruction sheet 408-9027. The adapter kit contains Counterbalance Kit 58176-1, Board Support Plate Kit 58175-1, and Ram Adapter Kits 58177-1 and -2.

**3. SEATING PROCEDURE** (Figure 1)

**CAUTION** A 19.1-mm [1.75-in.] thick board support (customer supplied) must be used to protect contact posts during the seating procedure.

A pc board support must be used to provide proper support for the pc board, to aid alignment of the tool to the header pins, and to protect the pc board and header posts from damage. It will be necessary to design a board support fixture for your specific needs following the recommendations in instruction sheet 408-6927.

**NOTE** Adjust applicator to correct shut height (38.1 ± .05 mm [1.50 ± .002 in.]). The shut height dimension is the distance between the bottom surface of the ram and the top surface of the pc board on the anvil, with the ram cylinder fully extended.

**DANGER** If using power unit, make sure power switch is OFF before starting.

1. Place pc board support into position under ram of manual arbor frame assembly or power unit (Figure 1 shows the recommended tooling).
2. Position pc board onto support fixture.
3. Insert seating tool into header.
4. Manually align and start contact posts of header into holes of pc board.

5. If using power unit, turn unit ON and cycle to seat the connector on the pc board. If using manual arbor frame assembly, seat connector by actuating the handle.

6. Remove pc board from board support fixture.
7. Remove seating tool from header and repeat necessary steps until all connectors are seated.

**4. TOOL INSPECTION** (Figure 2)

The seating tools listed in this instruction sheet should be inspected using the information provided in Figure 2. It is recommended that you inspect the tools immediately upon their arrival in your factory, and at regularly scheduled intervals to ensure that they have not been damaged.

Additional tools can be purchased 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

**5. REVISION SUMMARY**

Since the previous release, this document was changed to reflect dimensional changes in the seating tools, per EC 0990-0158-96.

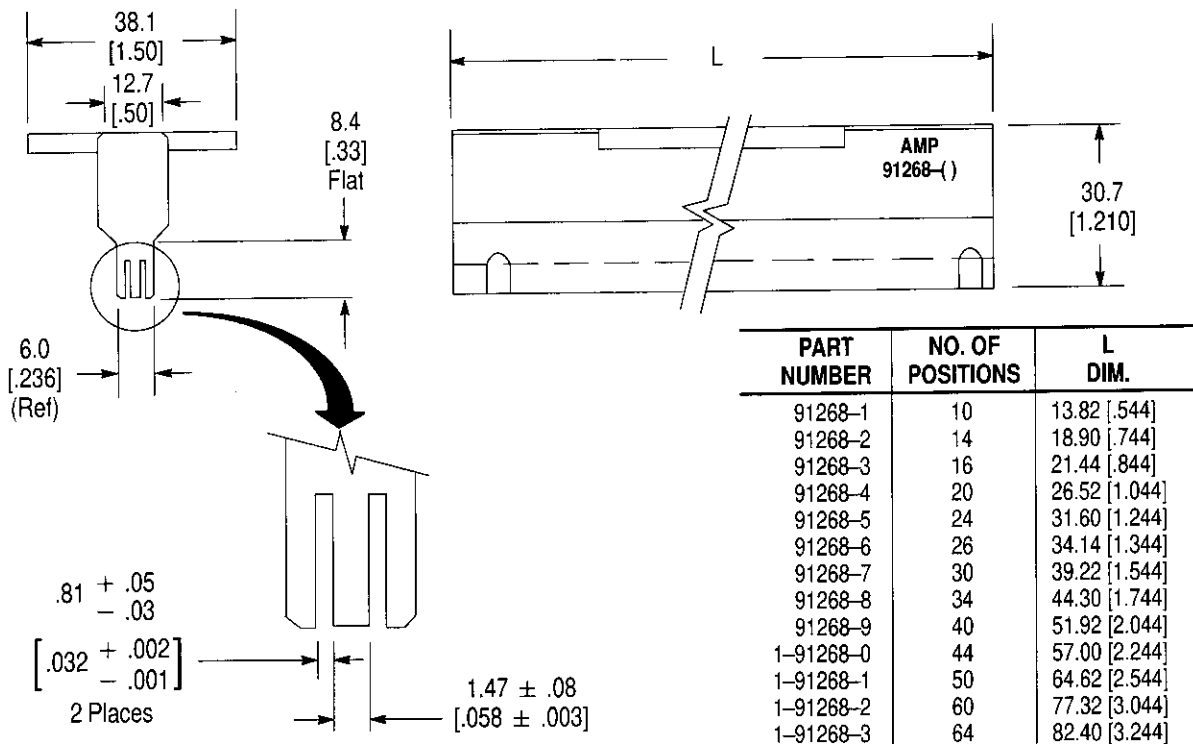


Figure 2