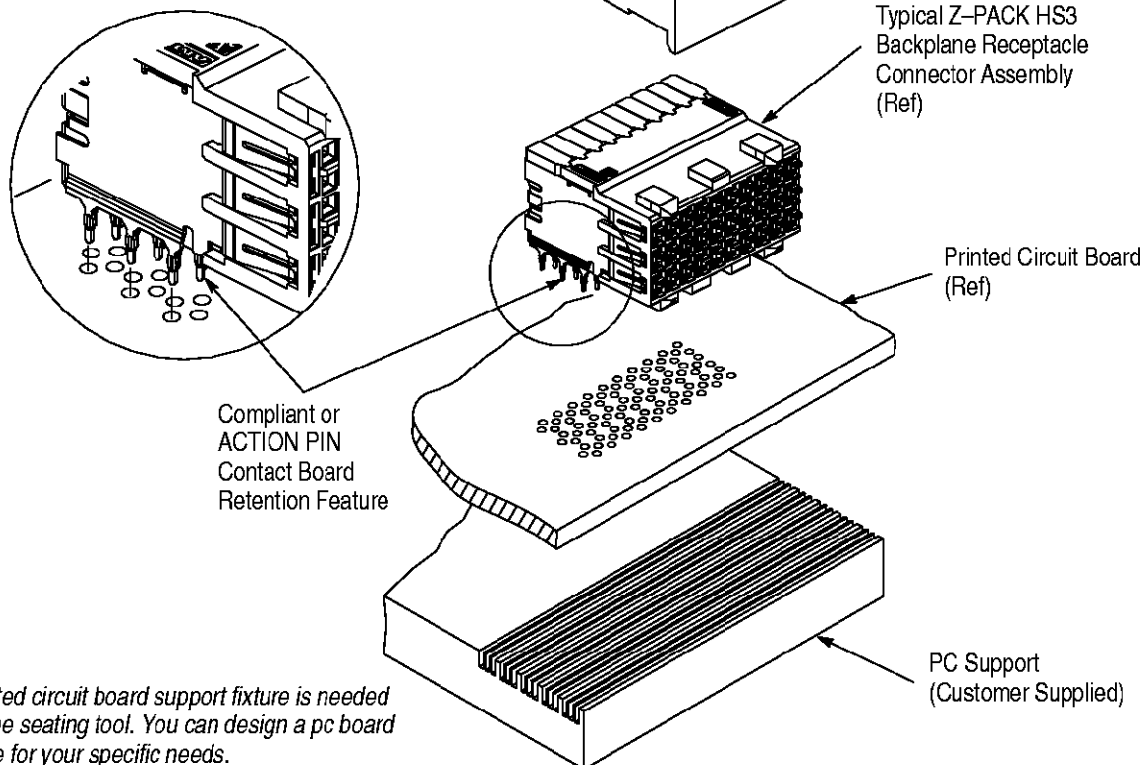


SEATING TOOL	NO. OF ROWS	NO. OF POSITIONS
1338742-1	6	30 and 60
1338742-2	6	120
1338742-3	6	Cut to Length
1338743-1	10	50 and 100
1338743-2	10	200
1338743-3	10	Cut to Length



**NOTE:** A printed circuit board support fixture is needed for use with the seating tool. You can design a pc board support fixture for your specific needs.

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the use and maintenance of AMP\* Seating Tools listed in Figure 1. Tools 1338742-[ ] and 1338743-[ ] are used to seat Z-PACK HS3 Backplane Receptacle Connectors with ACTION PIN contacts. These tools 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 tools and support anvil.

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

## 2. DESCRIPTION

The seating tool is a one-piece design. During seating, the seating tool covers the connector and presses on the top surface of the connector when the applicator ram applies force to the seating tool. The support anvil is positioned into a pc board support fixture to support the pc board.

## 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 receptacle pins, and to protect the pc board and connector contacts from damage. This pc board support is needed for use with this seating tool and

anvil. Design a pc board support fixture for your specific needs, using the recommendations in 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 SM-3 Frame Assembly 814700-[ ] (409-5626).

## 4. SEATING

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 support.)

2. Position support anvil, grooved side up, into the pc board support fixture and center it under the applicator ram of the power source. Position pc board with connector over support anvil.

3. Position the connector onto the pc board so that the contacts are properly aligned to the pc board and pc support. See Figure 2.

4. Insert the connector into the pc board until the ACTION PIN section of the contacts are resting securely on, but have not fully entered, the pc board.

5. Position the seating tool onto the connector with the angle positioned as shown in Figure 2.

6. 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, connector, and seating tool.

### CAUTION

*Damage to the pc board, seating tool, or connector may occur if seating height is improperly set, if pc board is not properly positioned over the support anvil, or if seating tool is not properly seated on the connector before cycling the applicator ram.*

7. Cycle applicator ram according to instructions for your power source. Check assembly for proper seating, using the requirements of the Application Specification.

8. Remove board with seated connector, or reposition board and board support for seating additional connectors.

### View After Seating

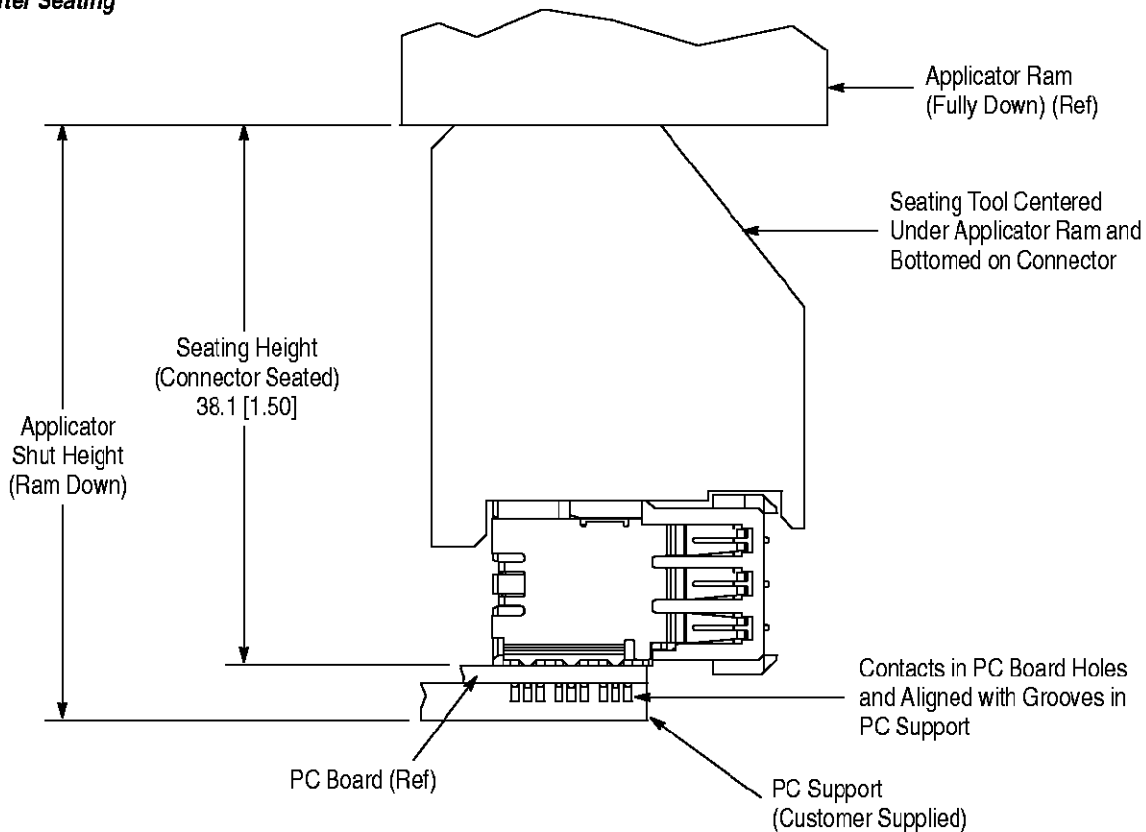


Figure 2

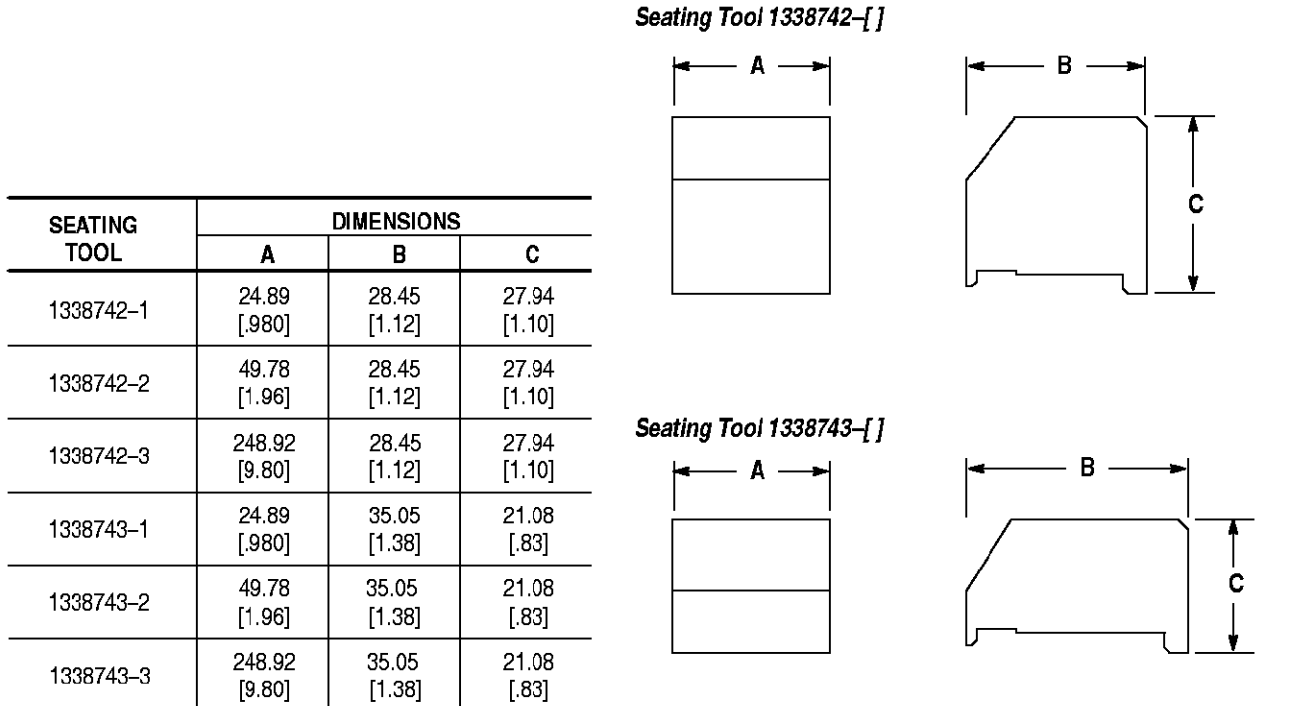


Figure 3

**5. TOOL INSPECTION**

It is recommended that the tool be inspected, using Figure 3, 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 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**

Order replacement seating tools through your Tyco 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

For seating tool repair service, please contact a representative at 1-800-526-5136.

**8. REVISION SUMMARY**

Per EC 0990-1207-00:

- Updated document to corporate requirements
- Added angle to seating tool for orientation in all Figures
- Added new information to Paragraph 4.5