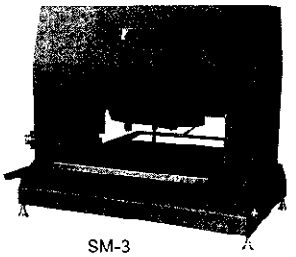
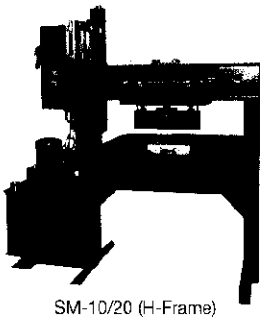
Connector Insertion Tooling *U.S.A.*



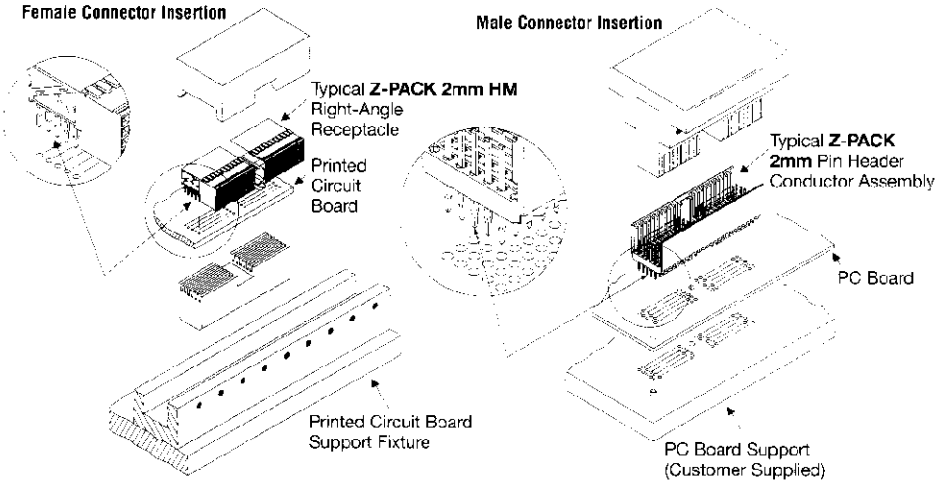
Manual Arbor Frame



SM-3



SM-10/20 (H-Frame)



Application Tooling and Instruction Sheets
'Flat Rock' tooling is used for most connectors in the AMP **Z-PACK 2mm HM** range. Upper tooling part numbers and instruction sheets detailing assembly methods are listed below:

Low and High Volume Tooling	Tool Part Number	Instruction Sheet
A type vertical male connectors	90753-1	408-9912
B22 type vertical male connectors	90755-2	408-9914
B19 type vertical male connectors	90755-3	408-9914
Receptacle connectors (except TDM J4)	122582-1	408-4382 and 408-4383
*Receptacle connectors TDM J4	91316-1	408-4216
Anvil for Feed-to vertical males/receptacles	122561-1	408-4216
Board support	679980-1,-2	408-4038

Alternatively, customers may provide their own support which locates the board and has sufficient thickness to provide clearance for connector tails to pass through.

Pneumatic and Hydraulic 'Flat Rock' Seating Machines.
These machines are used with the tooling below, and allow the fitting of multiple connectors per cycle, up to the limit of the machine capacity. They can be used with a variety of AMP connectors.

SM-3 Machine Part No. 814700-2
This air-powered bench machine has a capacity of 26 700 N (6000 lb), which is adequate for individual Z-PACK modules. This unit has a pressure response mode and a board sensor mode which compensate for variations in board thicknesses. Cycle time is approximately 4 seconds. It can accommodate pc boards up to 20 [508] wide.

SM-10/20 Machine Part No. 803880-6
Electric hydraulically-powered machine has a selectable [178 000N (40000 lb) or 89 000N (20000 lb)] force capability. It can accommodate pc boards up to 28 [711] wide. Consult AMP for further details.

Manual Arbor Frame Part No. 58024-1
This low cost AMP frame is bench tool suitable for a wide range of connector application tooling. Consult AMP for further details. (Instruction Sheet 408-6923)

Application Tooling
AMP offers low cost application tooling suitable for high and low volume production for A,B and C modules. Instruction sheets shown against the appropriate connector description are available from the AMP FAX System. They show the required tooling part numbers and method.

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