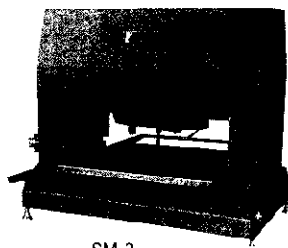


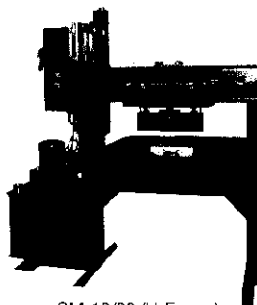
**Connector Insertion Tooling U.S.A.**



Manual Arbor Frame

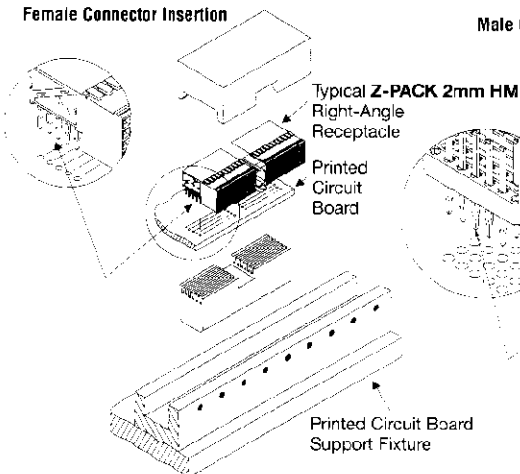


SM-3

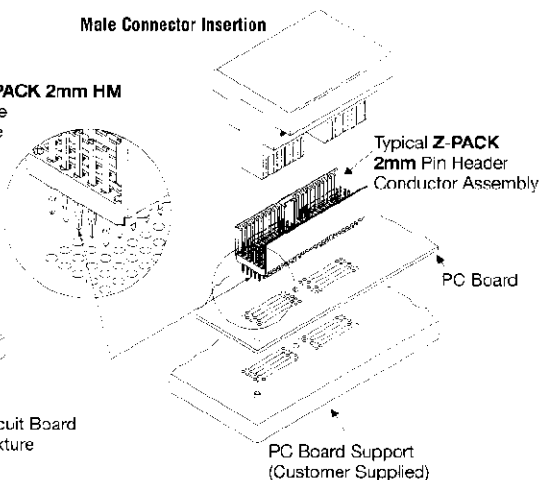


SM-10/20 (H-Frame)

**Female Connector Insertion**



**Male Connector Insertion**



**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.