

**Seating Tool  
58512-[ ]**

No. 6-32 X .19 Lg.  
Socket Setscrews  
2-21012-8 (To Match  
Qty and Size of Blades)

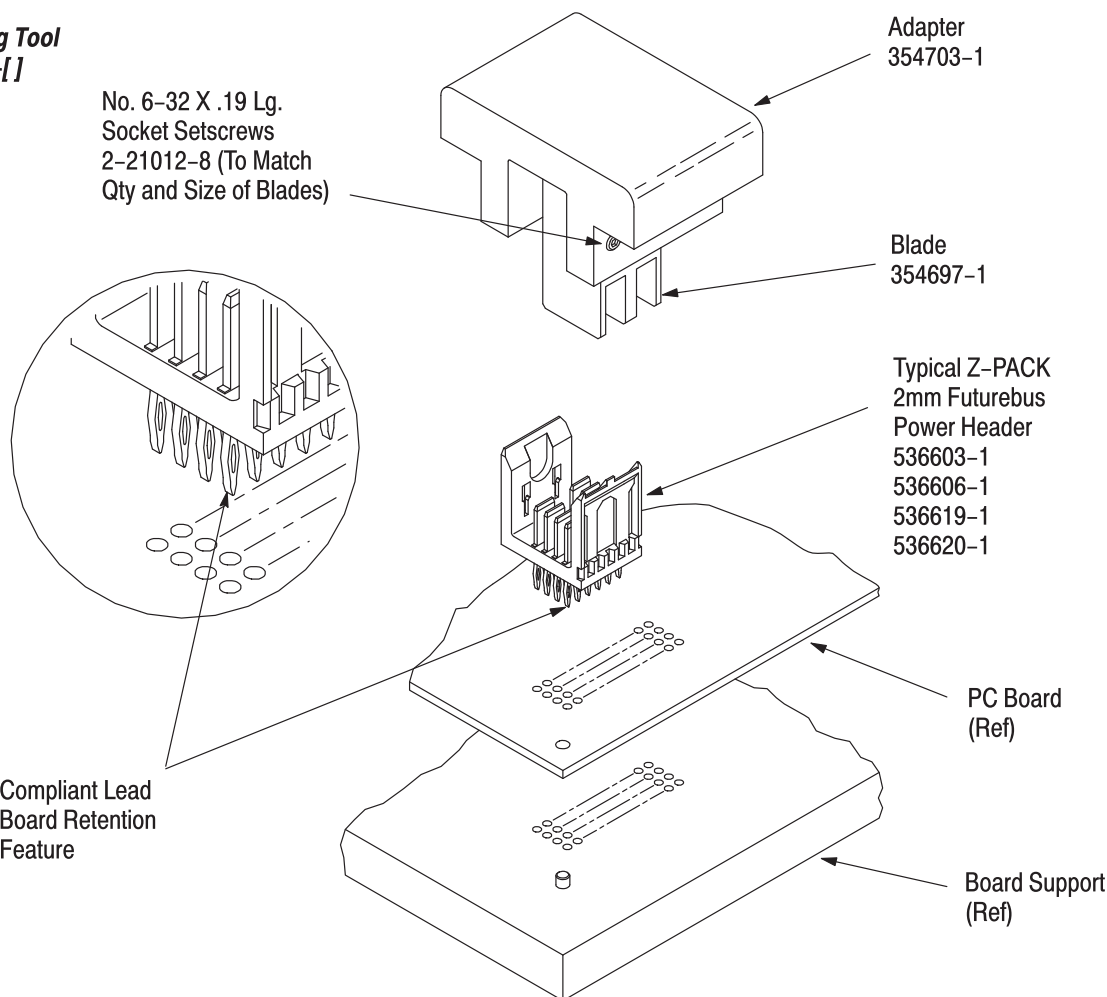


Figure 1

## 1. INTRODUCTION

This instruction sheet covers the use and maintenance of Seating Tools with base part number 58512. These tools are used to seat Z-PACK 2mm Futurebus Power Headers with part numbers 536603, 536606, 536619, and 536620. All these headers contain compliant lead contacts to allow solderless printed circuit (pc) board installation.

**NOTE**

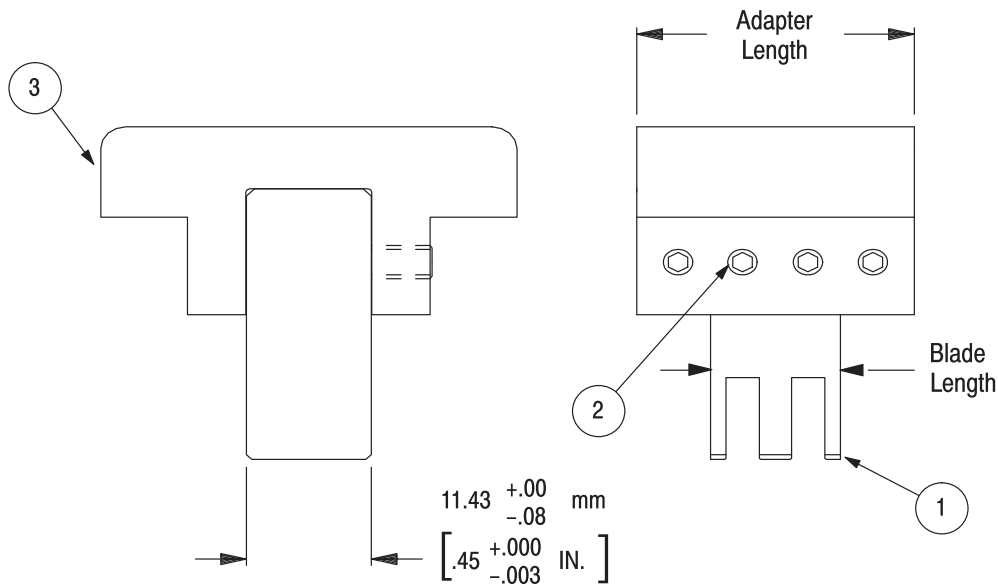

*All dimensions on this document are in metric units [with U.S. customary units in brackets].*

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

## 2. DESCRIPTION

Each seating tool is an assembly of one or more blades 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			8	16
ITEM	DESCRIPTION	LENGTH $\begin{smallmatrix} +.00 \\ -.10 \end{smallmatrix}$ mm $\left[ \begin{smallmatrix} +.000 \\ -.004 \end{smallmatrix} \text{ IN.} \right]$	TOOL 58512-1	TOOL 58512-2
1	BLADE 354697-1	11.89 mm [.468 IN.]	1	2
2	SCREW 2-21012-8	SIZE 6-32 x .19 IN. LG	4	4
3	ADAPTER 354703-1	25.40 mm [1.000 IN.]	1	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. Call the Tooling Assistance Center at 1-800-722-1111 for recommendations.

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 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.

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

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

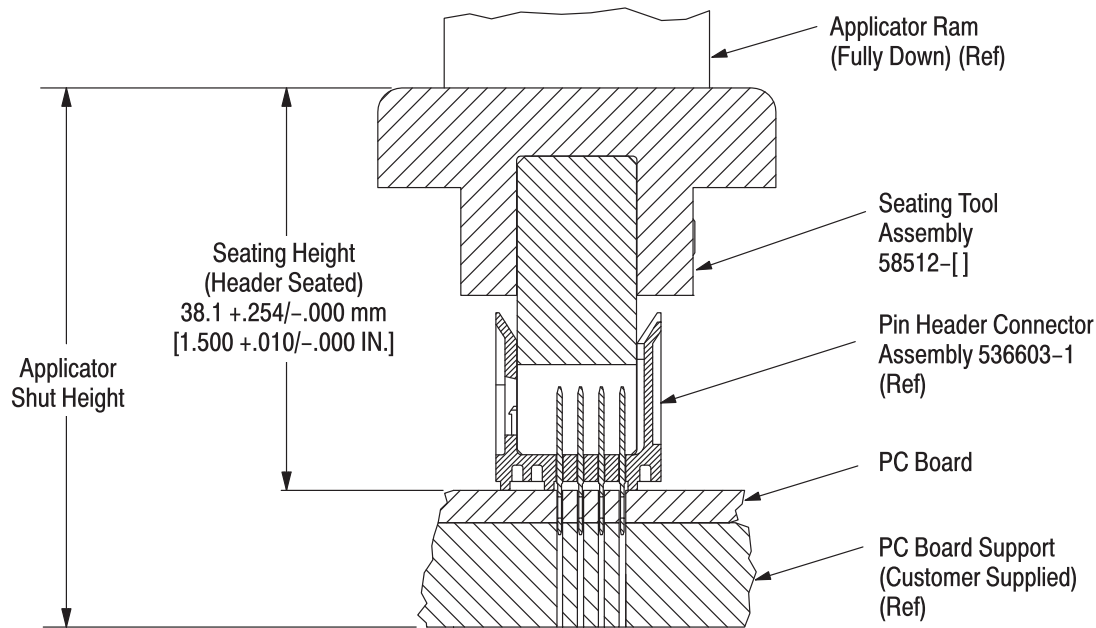


Figure 3

## 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 2 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 (038-035)  
TYCO ELECTRONICS CORPORATION  
P. O. BOX 3608  
HARRISBURG, PA 17105-3608

For customer repair service, call 1-800-526-5136.

## 8. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements.
- Removed tool repair address in favor of phone contact information for repair service.
- Changed tooling recommendation information in Paragraph 3.2.
- Changed replacement part reference in Section 7 from Figure 1 to Figure 2.