

FIGURE 1

1. INTRODUCTION

This instruction sheet (IS) pertains to the removal and replacement of solder tine receptacle contacts used in the AMP MODU MOD IV vertical connectors listed in Figure 1. Read this material thoroughly before starting.

2. DESCRIPTION

Single and double solder tine contacts are retained in MOD IV housings by the two flared sides on the post entry end of the receptacle (see Figure 1). The flared sides keep the contacts seated in the housing and ensure proper placement on the printed circuit (pc) board prior to soldering. The contact will release when sufficient linear force is applied to the solder tine(s).

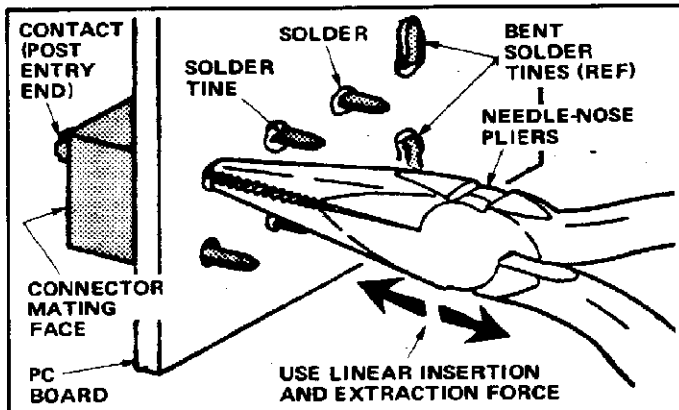


FIGURE 2

3. REMOVING A DAMAGED CONTACT

Contacts can be removed from soldered and unsoldered connectors. The following procedure applies to both types, however, if the connector is NOT secured to the pc board, disregard Step 1.

Proceed as follows:

1. Heat and remove ALL solder securing damaged contact to pc board. If solder tines have been bent, straighten them before attempting removal. See Figure 2.
2. Using a pair of needle-nose pliers, firmly grip solder tine. Apply linear force to the contact and push it *straight* through until the post entry end protrudes from the mating face of the connector. See Figure 2.
3. Grip the post entry end of the contact with the needle-nose pliers and pull it *straight* out of the connector.
4. Discard the contact and replace it with a new one (see chart in Figure 1).

4. REPLACING A CONTACT

Proceed as follows:

1. Align the contact with the mating face of the contact cavity. Make sure the solder tine(s) is oriented the same as all other tines. See Figure 1.
2. Guide the solder tine(s) straight through the contact cavity and — if applicable — through the hole in the pc board.
3. Using needle-nose pliers, firmly grip a solder tine and pull the contact straight into the connector until it bottoms. See Figure 2.
4. Check the connector mating face to be sure the contact is properly seated.
5. If the contact was installed in a soldered connector, solder the tine(s) in place (bend tine(s) if applicable).

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