APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of the AMP PACE* connector. These requirements are applicable to hand application tooling. For specific part numbers relative to the products covered in this specification see Figure 12.

2. APPLICABLE DOCUMENT

The following document forms a part of this specification to the extent indicated herein.

2.1. AMP Document

IS 3004: AMP PACE Connector Applicators

3. NOMENCLATURE

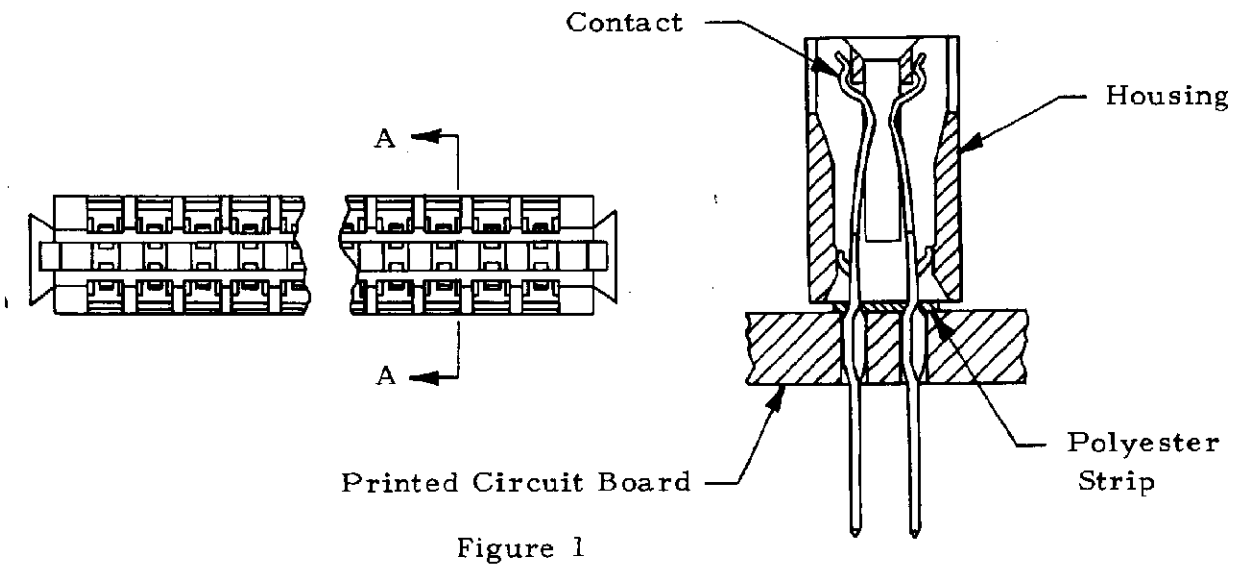

Figure 1

4. REQUIREMENTS

4.1. Printed Circuit Board

A. Thickness shall be .084 minimum.

B. Layout shall be as indicated in Figure 2.

*Trademark of AMP Incorporated.

LTR	REVISION RECORD	APP	DATE
A	Rev Fig 2 & Fig 9	AOL	3/23/83

DR L. L. Fritz 12/16/82
CHK W. R. Spurgeon 12/16/82
APP 12/14/82

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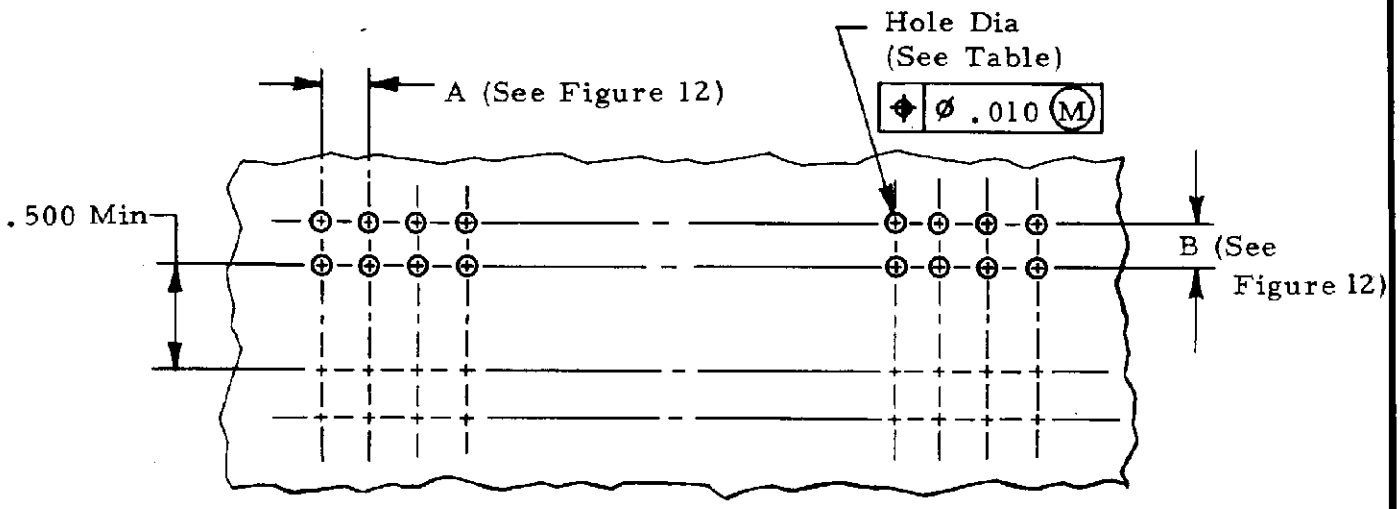

Hole Dia ±.0010	Plating Thickness		Hole Diameter		Copper Hardness, Knoop	Pad Diameter, minimum
	Copper	Tin/Lead	After Plating	After Reflow		
.0453(a)	.001-.003	.0003 min	.037-.043	.036-.043	150 max	.062
.0453(a)	Not Plated Thru					.065

(a) Using a 1.15 millimeter diameter drill.

Figure 2

4.2. Connector Insertion

A. Properly locate printed circuit board on insertion fixture.

B. Locate contact posts in proper holes in printed circuit board.

C. Evenly press connector into printed circuit board, using care not to bend any posts, until polyester strip bottoms on ACTION PIN* section of contacts as indicated in Figure 3.

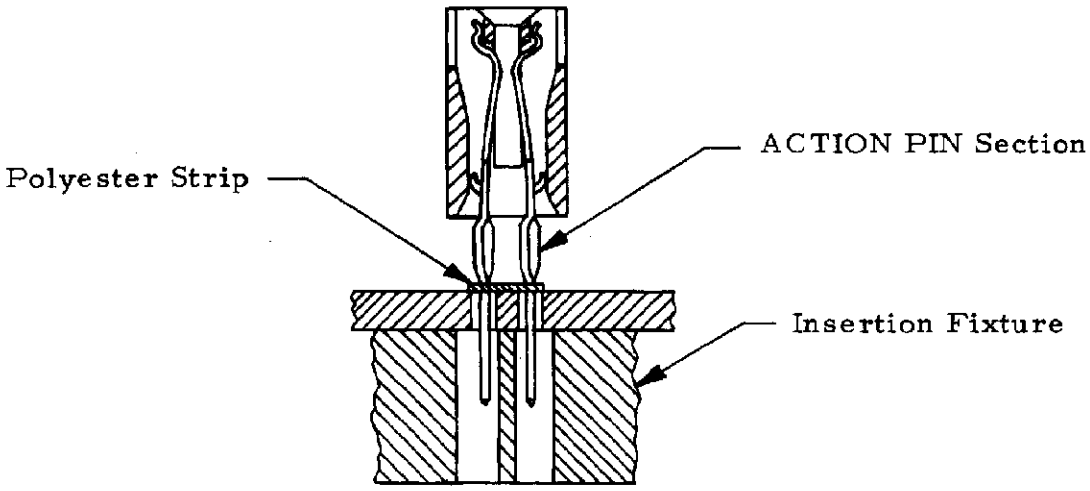

Figure 3

D. Fit locator plate on applicator into card slot of connector, as indicated in Figure 4, and push down on applicator tool enabling push pins to enter the connector. Refer to IS 3004 for applicator components.

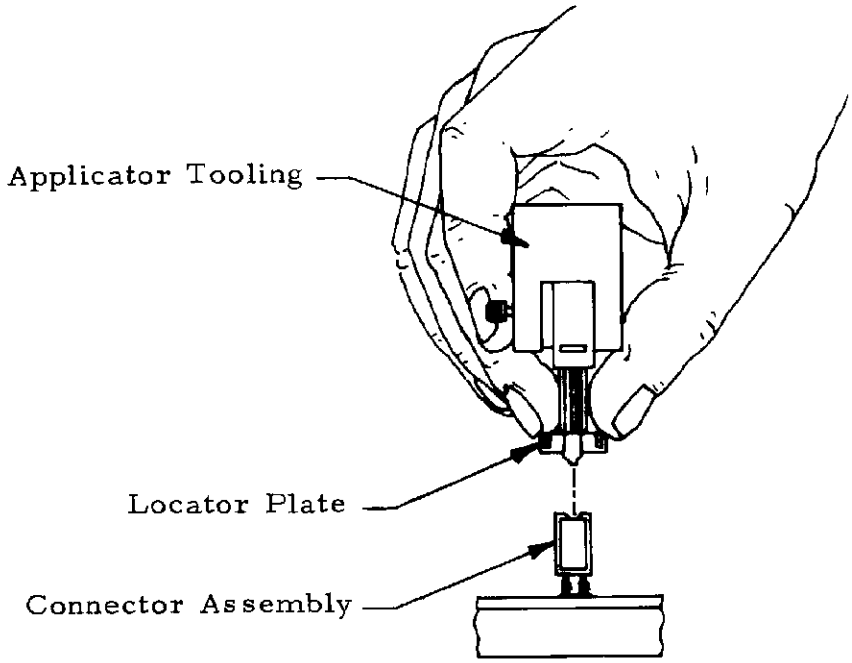

Figure 4

E. Center entire assembly under driving ram of force applicator.

F. Hold applicator, properly aligned on connector, perpendicular to the printed circuit board at all times.

G. Apply force to stabilizer bar of applicator, as indicated in Figure 5, until connector bottoms on the printed circuit board. Force applicator shall be capable of providing a force of 50 pounds per contact.

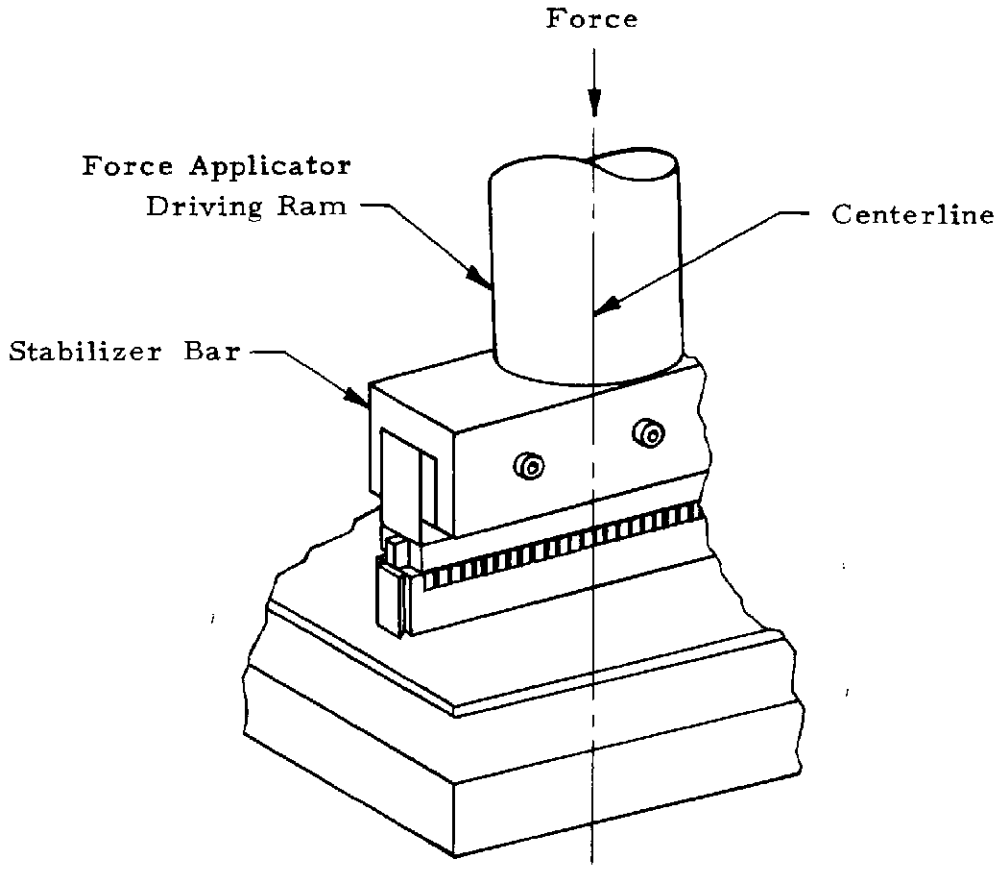

Figure 5

H. Release force on driving ram when connector is bottomed on printed circuit board.

I. Carefully remove applicator by lifting straight up.

J. Connector shall meet the requirements of Figure 6 after insertion.

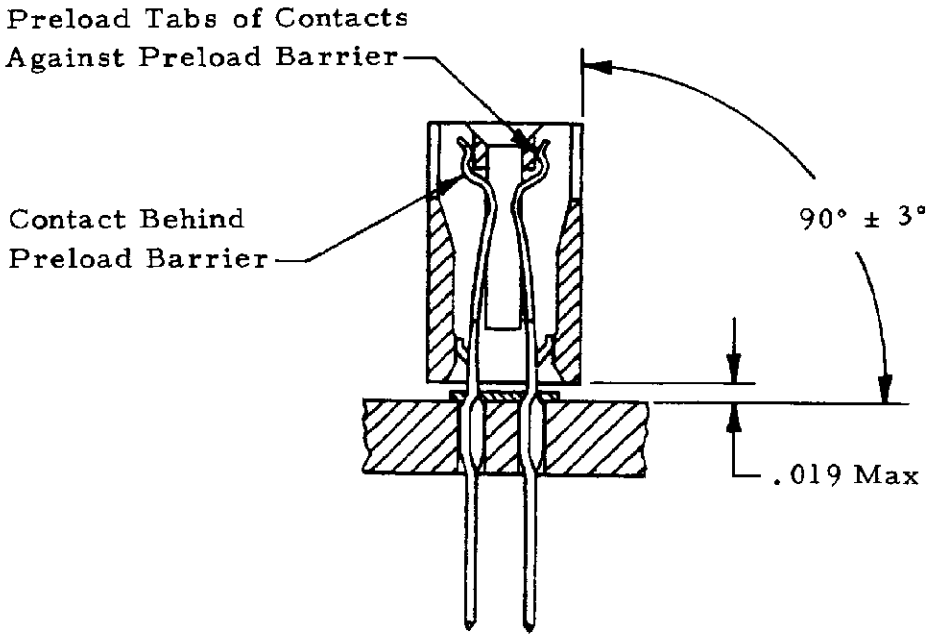

Figure 6

4.3. Individual Contact Replacement

A. Removal

Individual damaged contacts can be replaced using handle PN 380392-8 with ACTION PIN contact removal tip PN 265964-1.

(1) Insert a printed circuit board into connector slot as indicated in Figure 7.

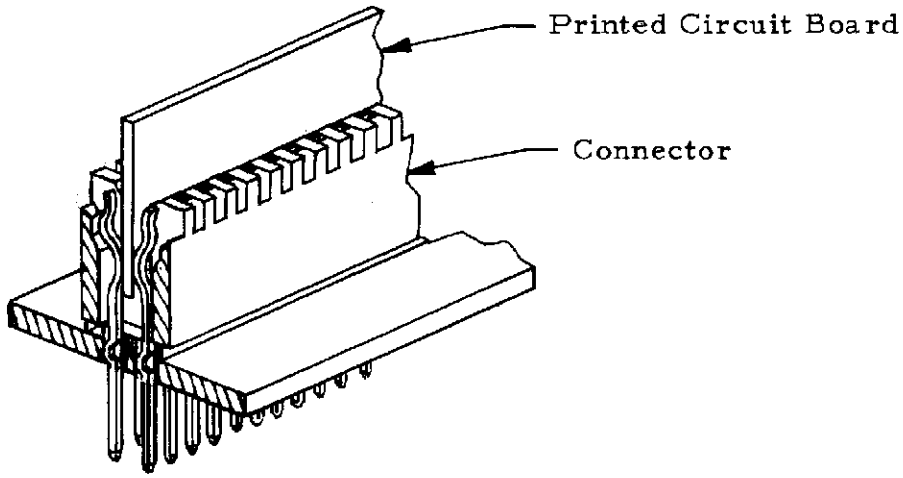

Figure 7

(2) Place ACTION PIN contact removal tip on handle.

(3) Fit ACTION PIN contact removal tip over post section of damaged contact and push on handle until contact snaps free as indicated in Figure 8.

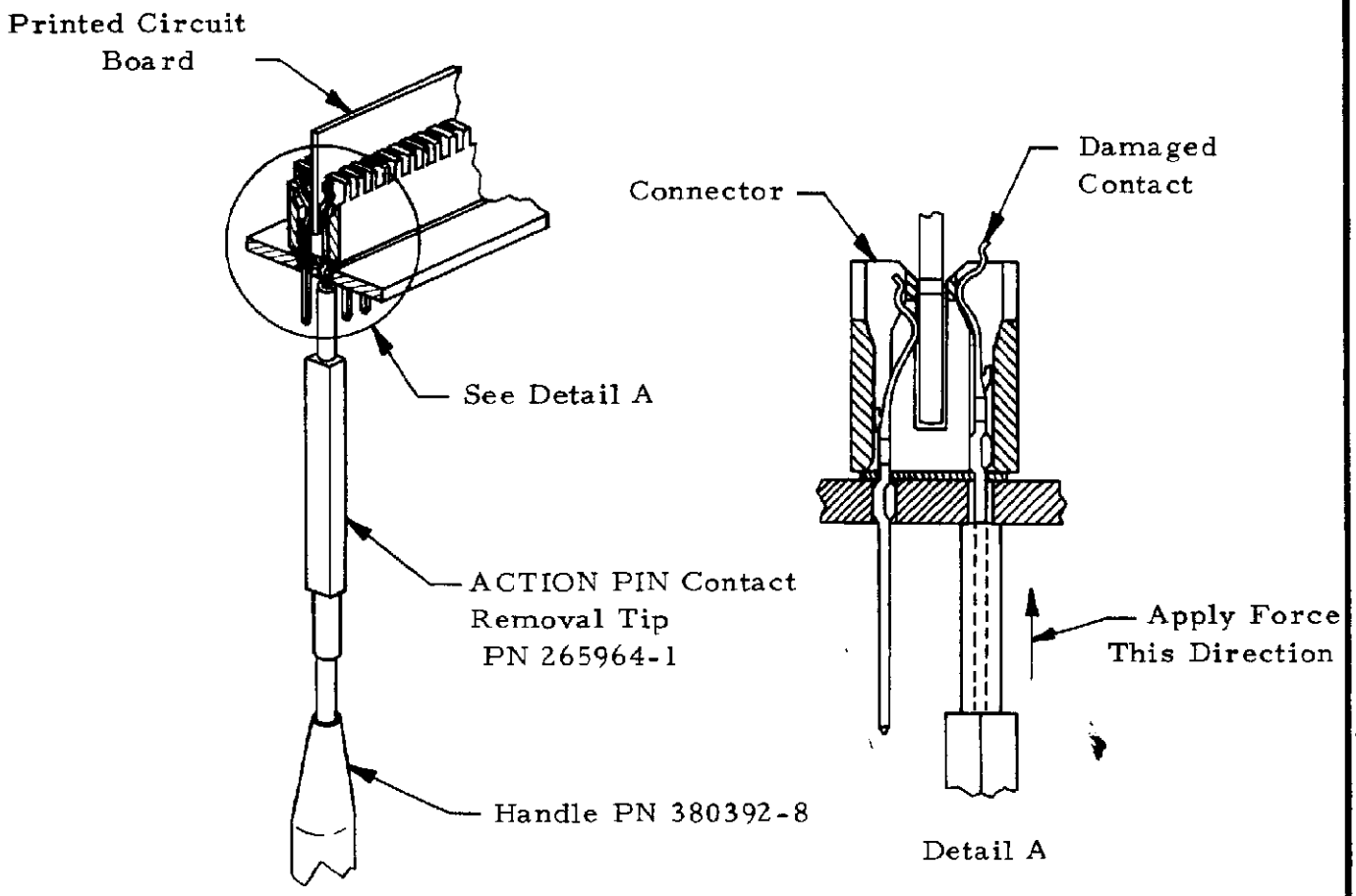

Figure 8

(4) Lift damaged contact from housing.

(5) Remove printed circuit board from connector slot.

B. Insertion

Individual contacts shall be inserted in connector using the applicable insertion tooling indicated in Figure 9.

Insertion Tool Part Number	Description (a)	Applicable Instruction Sheet
266220-1	.100 x .200	IS 2933
266220-2	.125 x .125 Low Profile	IS 2933
	.125 x .250	IS 2933
	.156 x .200	IS 2933
266220-3	.100 x .100	

(a) For special applications consult AMP Engineering.

Figure 9

(1) Select insertion tool part number from Figure 9 based on product description.
(2) Select replacement contact strip part number from Figure 12 based on product description and remove a single contact.
(3) Position contact in insertion tool such that tip of tool is bottomed against push shoulder of contact.
(4) Fit contact into connector housing and through hole in printed circuit board as indicated in Figure 10.

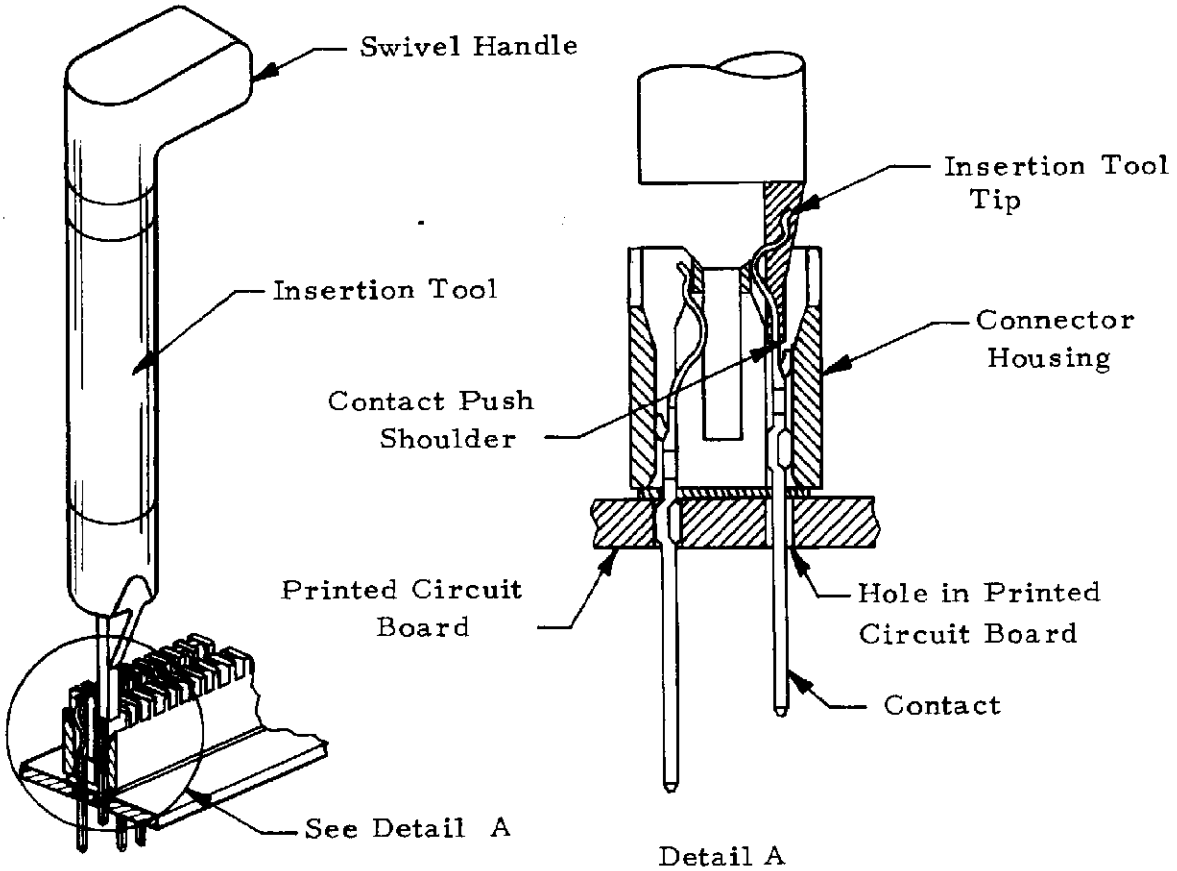

Figure 10

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(4) Apply force to end of insertion tool until tool bottoms on top of connector housing as indicated in Figure 11. Swivel handle of tool may be positioned to facilitate force application.

(5) Remove insertion tool from connector housing.

(6) Replacement contacts shall meet the requirements specified in Figure 6.

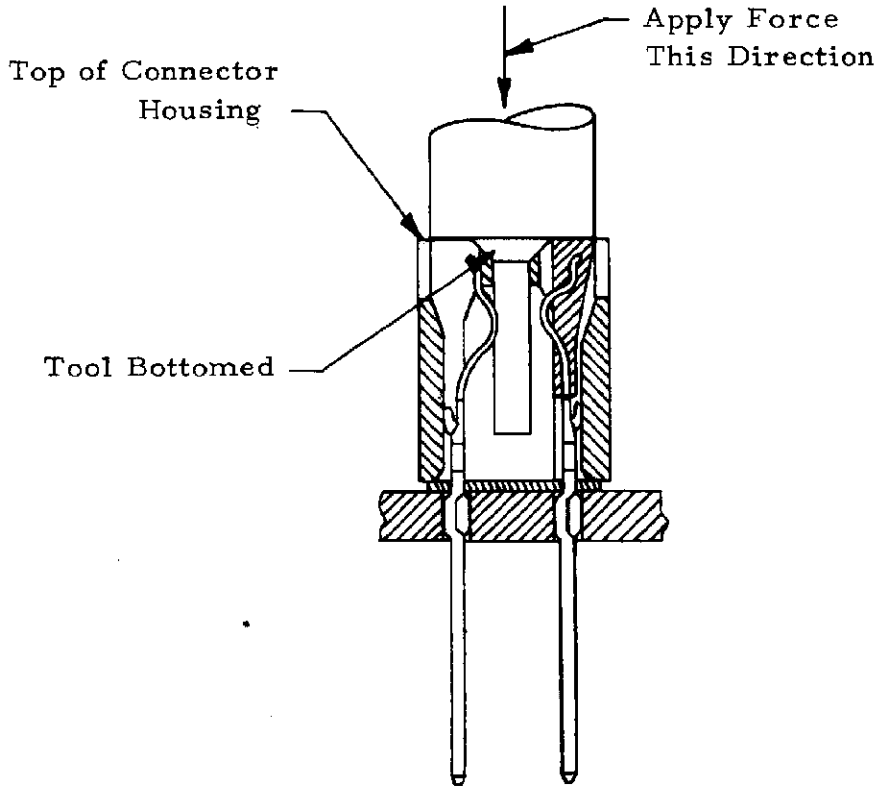

Figure 11

Part Numbers			Description	A Nom(b)	B Nom(b)
Connector Assembly(a)	Replacement Contact Strip	Applicator			
119236 119237 119412 119413 119698 119701	119711-1	266269	.100 x .100	.100	.100
119238 119239 119414 119415	119711-5				
119474	119711-3				
119476	119711-2				
119674	119711-6				
119534	119711-4 & -9				
119451	119711-7				
119702	119711-1 & -4				
119705	119711-1 & -5				
119706	119711-1 & -8				
119215 119216 119379 119469	119715-1	266270	.100 x .200	.100	.200
119535		266362-1			
119163 119167 119214 119468	119715-2	266270			
119576		266351-1(30 pos) 266337-1(44 pos)			
119682	119715-3	266270			
119620		266351-1			
119530		266362-1			
119485		266270			
119478		266270			

Figure 12 (cont)

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Part Numbers			Description	A Nom(b)	B Nom(b)
Connector Assembly(a)	Replacement Contact Strip	Applicator			
119493 119497 119560 119575	119715-4	266270	.100 x .200	.100	.200
119621 119676 119677		266337-1			
119384	119715-5				
119553	119715-5				
119277 119278 119417 119418	119716-1	266271	.125 x .125 Low Profile	.125	.125
119606 119607 119612 119613	119716-2				
119604 119605 119610 119611	119716-3				
119608 119609 119614 119615	119716-4				
119199 119200 119420 119421	119712-2	266272	.125 x .250	.125	.250
119665		266280			
119201 119202 119422 119423	119712-1	266272			
119453	119712-3				
119505	119712-4				
119666	119712-4	266280			
119480	119712-5	266272			

Figure 12 (cont)

Part Numbers			Description	A Nom(b)	B Nom(b)
Connector Assembly(a)	Replacement Contact Strip	Applicator			
119253 119254 119445 119446	119713-2	266273	.156 x .200	.156	.200
119255 119256 119457 119458	119713-1				
119644	119713-1 & 119714-1				
119563	119713-3				
119568 119569	119713-3 & 119714-2				
119527	119713-5				
119680	119713-5				
119462-1 119462-2 119552-1 119552-2	119722-1 119722-2 119722-1 119722-2	266322	.125 x .125 High Profile	.125	.125
119486	119284-2	266274			

(a) For special applications consult AMP Engineering.
(b) See Figure 2.

Figure 12 (end)