

APPLICATION SPECIFICATION

1. SCOPE

1.1. Content

This specification covers the requirements for application of the AMPMODU* 2-piece double row header assembly. These requirements are applicable to hand application tooling. For specific part numbers relative to the products covered in this specification, see Figure 12.

1.2. Reference Specification

For applicable performance requirements, see AMP Specification 108-25017.

2. NOMENCLATURE

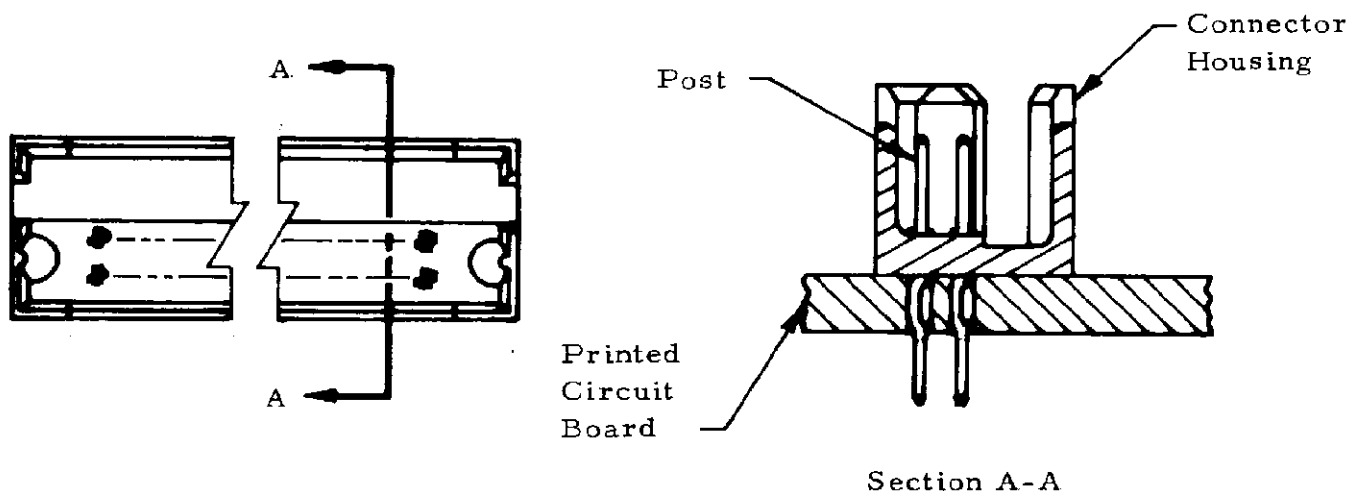


Figure 1

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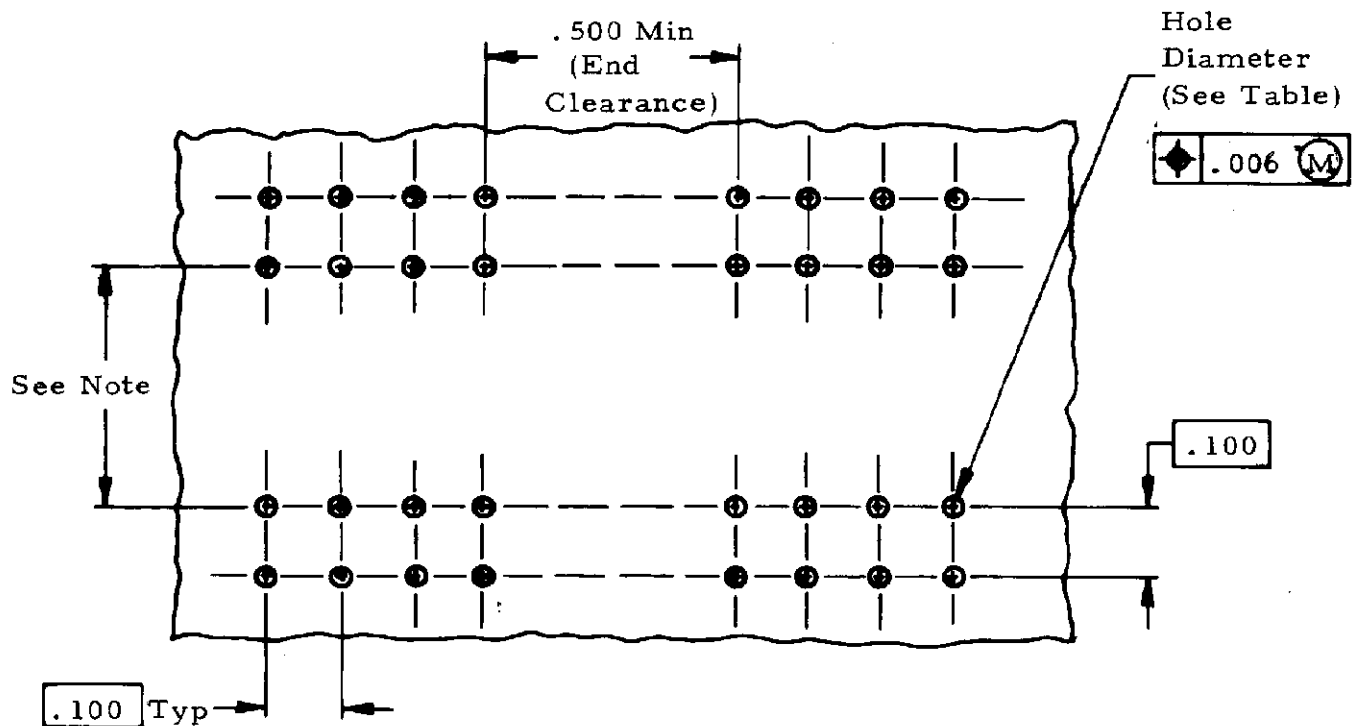
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C	DIST 09	O	Release per ECN AB-1351	APP	DATE	DR	AMP INCORPORATED Harrisburg, Pa. 17105		
						CHK	LOC	NO	REV
						AMP	B	114-9009	0
						TITLE HEADER ASSEMBLY, 2-PIECE DOUBLE ROW, AMPMODU			

3. REQUIREMENTS

3.1. Printed Circuit Board

- A. Thickness shall be .084 minimum.
- B. Layout shall be as indicated in Figure 2.



Note: Minimum side to side clearance for applicator tooling shall be .530 for housing constraints and single insertion and 1.200 for multiple insertion.

Hole Dia ±.0010	Plating Thickness		Hole Diameter		Copper Hardness, Knoop	Pad Dia (Min)
	Copper	Tin/Lead	After Plating	After Reflow		
.0452 (a)	.001-.003	.0003 Min	.037-.043	.036-.043	150 Max	.062
.0452 (a)	Not Plated Thru					.065

(a) Using a 1.15 mm diameter drill.

Figure 2

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3.2. Connector Insertion

- A. Properly locate printed circuit board on insertion fixture.
- B. Locate contact posts in proper holes of printed circuit board.
- C. Evenly press connector into printed circuit board by hand, taking care not to bend any posts, until ACTION PIN* contact section bottoms on printed circuit board as indicated in Figure 3.

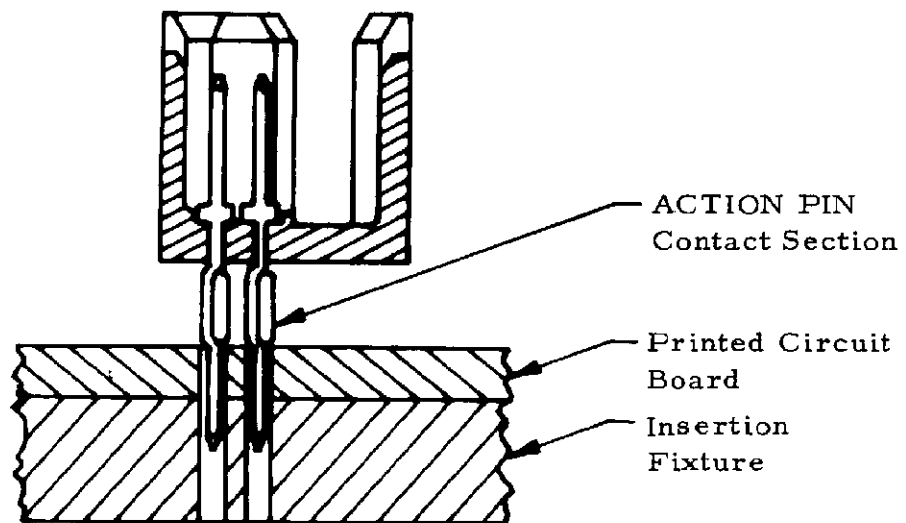
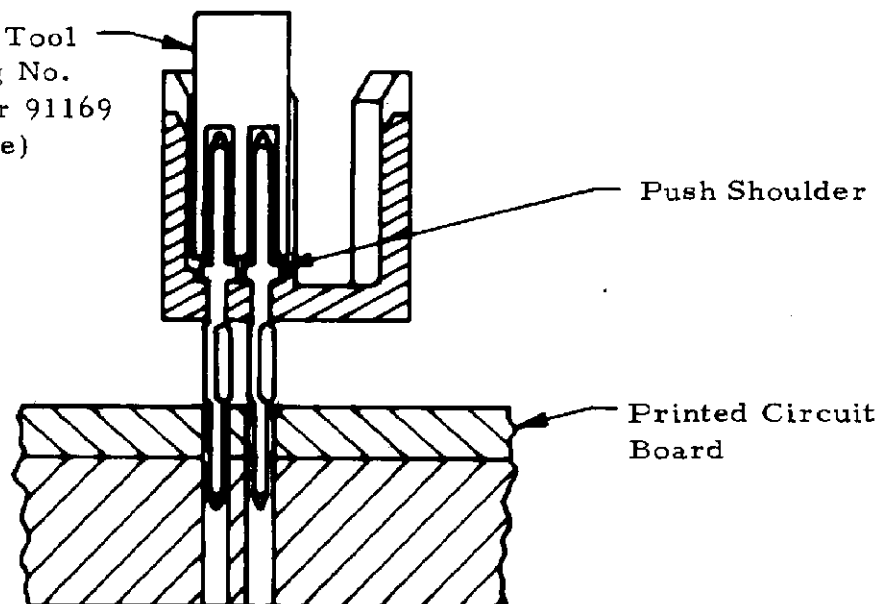


Figure 3

- D. Locate connector seating tool over connector posts and push down on tool by hand until tool bottoms on post shoulders as indicated in Figure 4.

Seating Tool
Drawing No.
91170 or 91169
(See note)



Note: For specific dash number consult appropriate AMP Drawing.

Figure 4

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- E. Center entire assembly under driving ram of force applicator PN 814700-1 or PN 803880-6.
- F. Apply force to seating tool as indicated in Figure 5 until connector bottoms on printed circuit board. Care shall be taken not to overseat housing on printed circuit board as this may reduce mating post height.

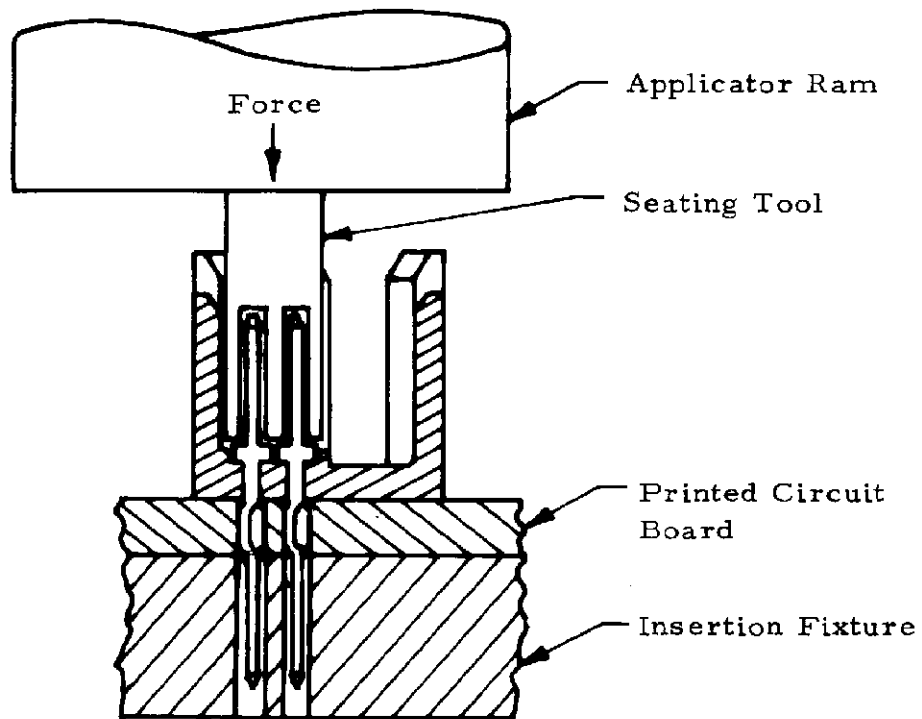


Figure 5

- G. Release force on driving ram when connector bottoms on printed circuit board.
- H. Carefully remove seating tool by lifting straight up.
- I. Connector shall meet the requirements of Para 4.1. and 4.2. after insertion.

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4. INSERTION REQUIREMENTS

4.1. Post

A. Post true position shall be as indicated in Figure 6 after insertion.

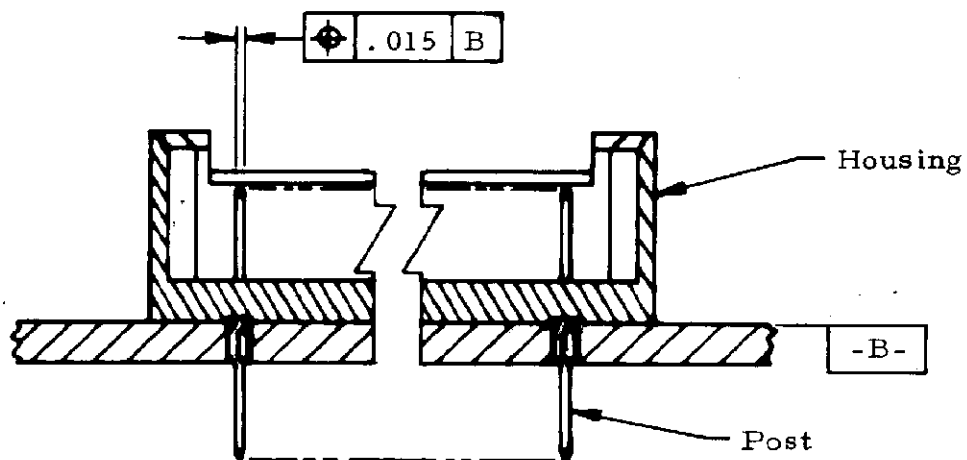


Figure 6

B. Mating post height shall be as indicated in Figure 7 after insertion.

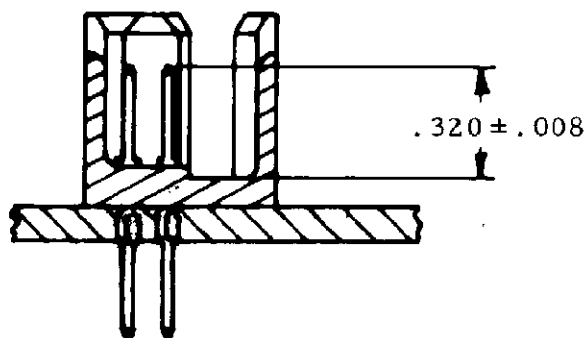


Figure 7

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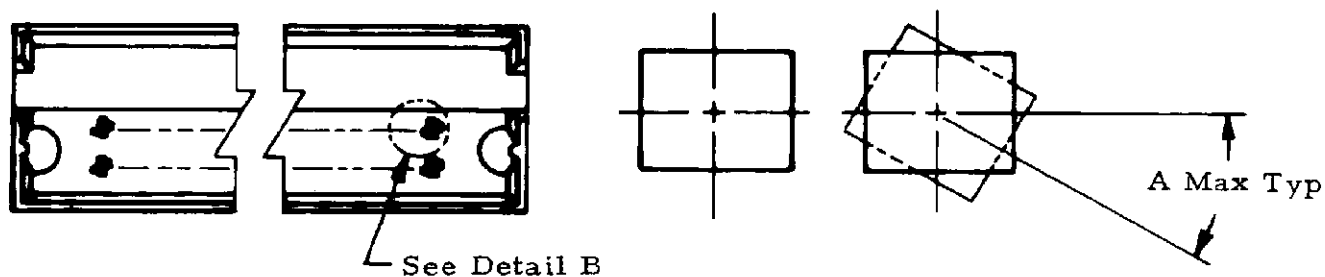
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C. Post rotation shall be as indicated in Figure 8 after insertion.



Detail B

Post Type	A
Mating Post	2°
Wire Wrap Post	5°
Non-Wire Wrap Post	10°

Figure 8

4.2. Connectors

Connectors shall meet the requirements of Figure 9 after insertion.

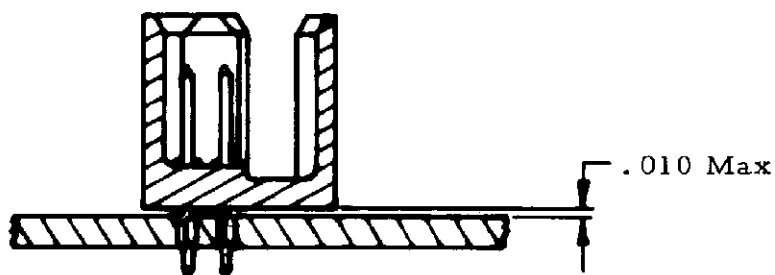


Figure 9

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4.3. Individual Contact Replacement

Individual damaged contacts can be removed using pin replacement tool PN 380392-8 with wrap type tail removal tip PN 265964-1 or short post removal tip PN 126961-2.

- A. Screw removal tip into pin replacement tool.
- B. Fit removal tip over damaged ACTION PIN contact, making sure pin replacement tool is perpendicular to printed circuit board, and push on tool until contact snaps free as indicated in Figure 10.

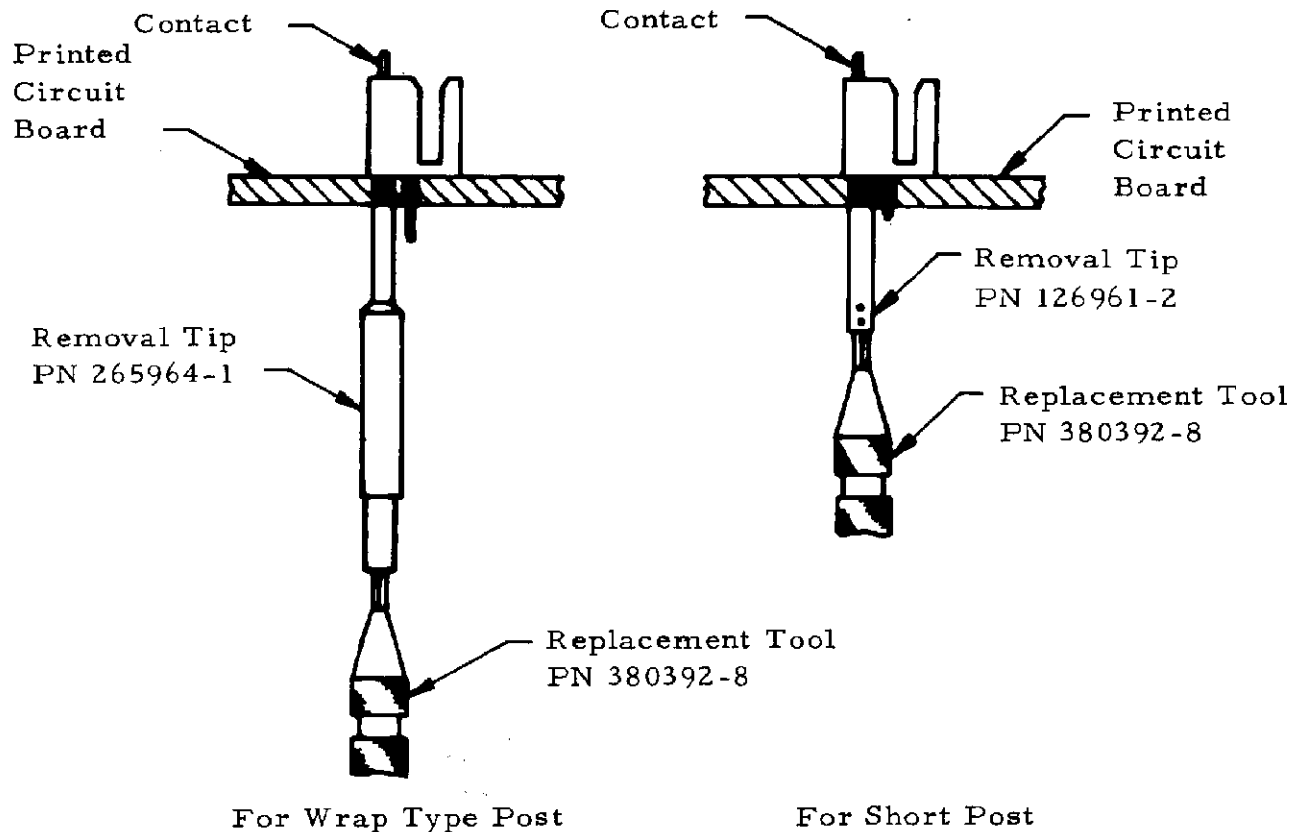


Figure 10

- C. Lift damaged contact from housing with a pair of needle nose pliers.
- D. Discard extracted contact.

4.4. Insertion

Individual contacts, regardless of type, shall be inserted using pin replacement tool PN 380392-8 with replacement tip PN 126961-1.

- A. Select ACTION PIN replacement contact from Figure 12.

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- B. Place new ACTION PIN contact into header assembly and through corresponding hole in printed circuit board making sure push shoulders of pin point to sides of header.
- C. Place tool with tip over pin in header.
- D. Keeping tool perpendicular, apply force on end of tool until contact shoulders bottom on connector housing as indicated in Figure 11.

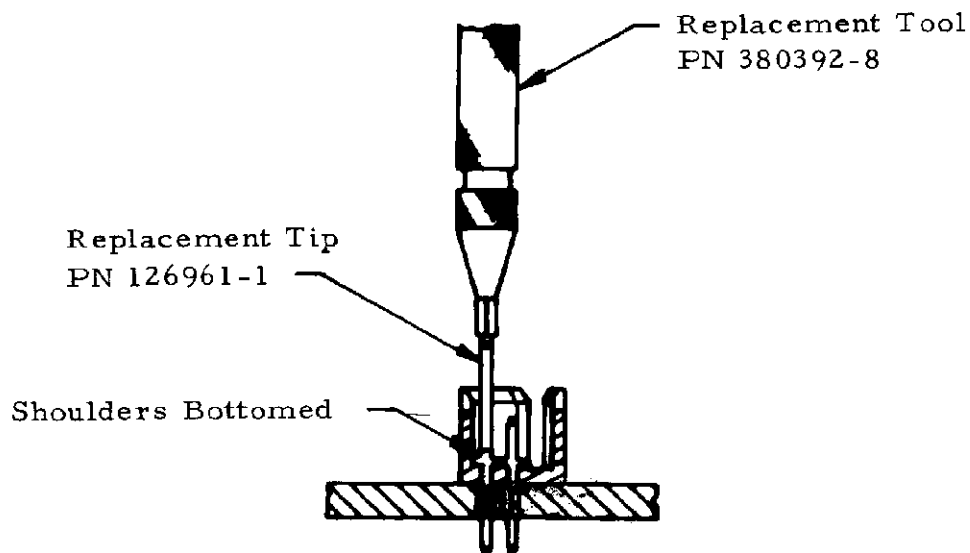


Figure 11

- E. Remove tool from connector housing.
- F. Replacement contacts shall meet the requirements specified in Para 4.1.

Assembly Part Number	Replacement Contact
102666	102824-3
102690	1-102824-0
102691	102824-2
102777	102824-7
103291	102824-9
532950	102824-1

Figure 12

Part Numbers

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