

REPLACING CONTACTS IN AMP* LOW PROFILE EDGE CONNECTORS



		FLOW SOLDER CONTAC		WITH MOUNTING EARS AND THREADED INSERTS		SOLDER EYELET CONTACT
TYPICAL CONNECTOR VITHOUT MOUNTING EARS		TYPICAL CONNECTO WITH MOU				
ONNECTOR	<u>a</u> fft	CONNECTO				
CONNECTOR VITHOUT MOUNTING EARS		CONNECTO WITH MOU		WITH THREADED INSERTS		
CONNECTOR VITHOUT MOUNTING EARS CONTACT DESIGNATOR	SPACING	CONNECTOR WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS	NTING EARS SCRIPTION WITH	WITH	co	
CONTACT CONTACT DESIGNATOR	••••	CONNECTOR WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673	NTING EARS SCRIPTION WITH MOUNTING EARS	WITH THREADED INSERTS 530685 530686	CO TYPE	ACEMENT INTACT PART NO.
CONTACT DESIGNATOR Flow Solder	sPACING	CONNECTOR WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS	NTING EARS SCRIPTION WITH MOUNTING EARS 530659	WITH THREADED INSERTS 530685	CO TYPE Flow	ACEMENT INTACT PART NO.
CONTACT DESIGNATOR Flow Solder (.140 in. row-	SPACING	CONNECTOR DE WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673 530674	NTING EARS SCRIPTION WITH MOUNTING EARS 530659 530661	WITH THREADED INSERTS 530685 530686	CO TYPE Flow	ACEMENT INTACT PART NO.
CONTACT DESIGNATOR Flow Solder (.140 in. row- to-row spacing)	SPACING .125 in, .156 in.	CONNECTOR DE WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673 530674 530668 530669	NTING EARS SCRIPTION WITH MOUNTING EARS 530659 530661 530657	WITH THREADED INSERTS 530685 530686 530679	CO TYPE Flow	ACEMENT NTACT PART NO. 1-530652-4
CONTACT DESIGNATOR Flow Solder (.140 in. row- to-row spacing) Flow	sPACING	CONNECTOR DE WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673 530674 530668 530669 530671	NTING EARS SCRIPTION WITH MOUNTING EARS 530659 530661 530657 530658	WITH THREADED INSERTS 530685 530686 530679 530680	CO TYPE Flow Solder	ACEMENT NTACT PART NO. 1-530652-4 1-530651-4
CONTACT DESIGNATOR Flow Solder (.140 in. row- to-row spacing) Flow Solder	SPACING .125 in, .156 in.	CONNECTOR DE WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673 530674 530668 530669 530671 530671 530672	NTING EARS SCRIPTION WITH MOUNTING EARS 530659 530661 530657 530658 530662	WITH THREADED INSERTS 530685 530686 530679 530680 530683	CO TYPE Flow Solder Flow	ACEMENT NTACT PART NO. 1-530652-4 1-530651-4
CONTACT DESIGNATOR Flow Solder (.140 in. row- to-row spacing) Flow Solder (.200 in. row-	SPACING .125 in, .156 in.	CONNECTOR DE WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673 530674 530668 530669 530671	NTING EARS SCRIPTION WITH MOUNTING EARS 530659 530661 530657 530658 530662 530662 530663	WITH THREADED INSERTS 530685 530686 530679 530680 530683 530683 530684	CO TYPE Flow Solder Flow Solder	ACEMENT NTACT PART NO. 1-530652-4 1-530651-4
CONTACT DESIGNATOR Flow Solder (.140 in. row- to-row spacing) Flow Solder	SPACING .125 in, .156 in, .125 in,	CONNECTOR DE WITH MOU CONNECTOR DE WITHOUT MOUNTING EARS 530673 530674 530668 530669 530671 530672 530666	NTING EARS SCRIPTION WITH MOUNTING EARS 530659 530661 530657 530658 530662 530662 530663 530655	WITH THREADED INSERTS 530685 530686 530679 530680 530683 530683 530684 530677	CO TYPE Flow Solder Flow Solder Flow	ACEMENT INTACT PART NO.

1. INTRODUCTION

This instruction sheet (IS) covers the removal and replacement of contacts in the AMP Low Profile Edge Connectors listed in Figure 1.

Read this material thoroughly before starting.

2. DESCRIPTION

These connectors consist of low profile housings with factory installed bifurcated spring contacts. The connectors designed for printed circuit (pc) board applications have row-to-row contact centerline spacing of either .140 or .200 in., and flow solder contacts installed. The connectors designed for wiring applications have solder eyelet contacts installed. The base part numbers for all connectors are listed in the chart in Figure 1.

All housings have dual contact positions, with in-row contact centerline spacing of either .125 or .156 in. They are molded with or without mounting ears. Those with mounting ears are available with threaded inserts installed. See Figure 1.

Contacts have a single lance that provides retention inside the housing. Although they have been designed for maximum retention, the contacts can easily be removed and replaced. This includes those that are soldered AND those that are NOT soldered to a pc board.

3. REMOVING A DAMAGED CONTACT (See Figure 2)

The following procedure applies to connectors that are soldered to a pc board as well as those that are NOT . . . simply omit Step 1 when removing a contact from an unsoldered connector.



FIGURE 2

Proceed as follows:

1. Heat and remove ALL solder securing the damaged contact to the pc board. If applicable, remove wire from tail of contact.

2. Insert a pointed tool into the lance recess and depress the lance. Only light force will be required.

3. Push on the tail of the contact to force the contact out through the pc board slot.

4. Pull the contact straight out of the pc board slot and *discard it*.

4. INSTALLING A CONTACT

The following is applicable for connectors that are soldered to a pc board AND those that are NOT.

Proceed as follows:

1. Select the applicable contact using the selection chart in Figure 1.

2. Align the tail of the contact with the contact cavity as indicated in Figure 2. Make sure the spring members are facing the center of the connector.

3. Guide the contact tail into the contact cavity (and if applicable, through the hole in pc board) until the stabilizer STARTS entry, into the connector as indicated in Figure 3. Do NOT fully insert the contact at this point as damage to the spring members could result. 4. Select an .062 in. thick dummy board that is wide enough to cover at least three (3) contact positions. The dummy board must NOT interfer with keying plugs – if necessary – make a cutout in the board. Do NOT remove any keying plugs.

5. Insert the dummy board *straight* into the pc board slot until it bottoms. Make sure the contact does NOT slide into the connector as the dummy board is inserted. Also, make sure the contact spring members are NOT over deflected and deformed during insertion of the board.

6. Using care, push the contact straight into the connector until it bottoms.

7. Remove the dummy board and check to be sure both spring members are seated behind the spring retainer as shown in Figure 3. If NOT, remove and discard the contact. Then replace it with a new one. Do NOT attempt to reset deformed locking lance or spring members.



The contact tail length and the gold plating equal the maximum for contacts used in these connectors. If the tail length is too long – cut off excess with a good pair of diagonal cutters.



FIGURE 3

8. If the contact was removed from a connector that was soldered to a pc board, solder the replacement contact into position using standard soldering techniques.

This completes the removal and replacement of a damaged contact.