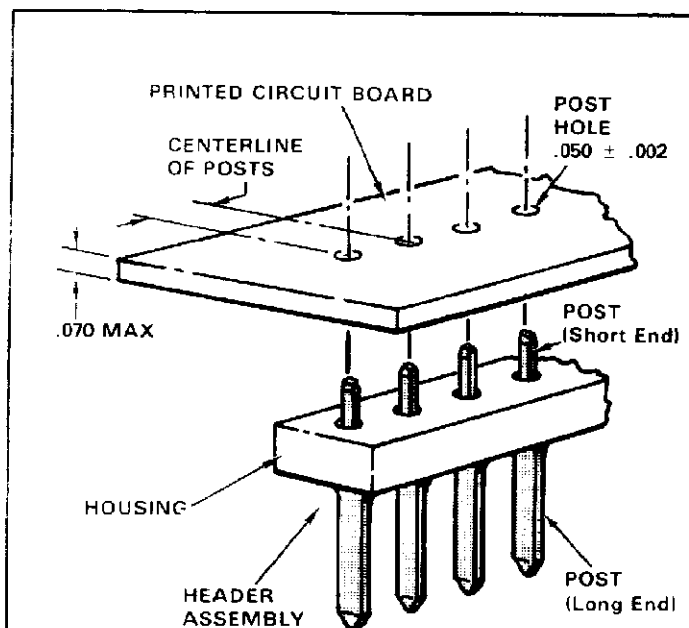




HEADER ASSEMBLIES				
POST CENTERLINE SPACING				
.156	.200	.250	.312	
85829	87262	86416	87064	86137
85830	87247	87183		86199
85839	87283	87397		86247
85840	87403			86359
85875	87633			87852
85923	87761			
86207	87762			
86469	87808			
87113	87943			
87119	87956			
87160				

Fig. 1

1. INTRODUCTION

This instruction sheet covers the recommended procedures for clinching AMPMODU Header Assemblies (with MOD I posts) onto printed circuit (pc) boards. The assemblies listed in Figure 1 are designed for machine clinching in production line applications or for manual clinching in low volume applications. Read this material thoroughly before clinching header assemblies onto pc boards.

NOTE

All dimensions presented on this instruction sheet are in inches, unless otherwise stated.

2. DESCRIPTION (see Figure 1)

Header assemblies are available with various numbers of in-line post positions, various post lengths, and various post center-to-center spacing dimensions.

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Each header assembly consists of a housing preloaded with .031 x .062-in. posts.

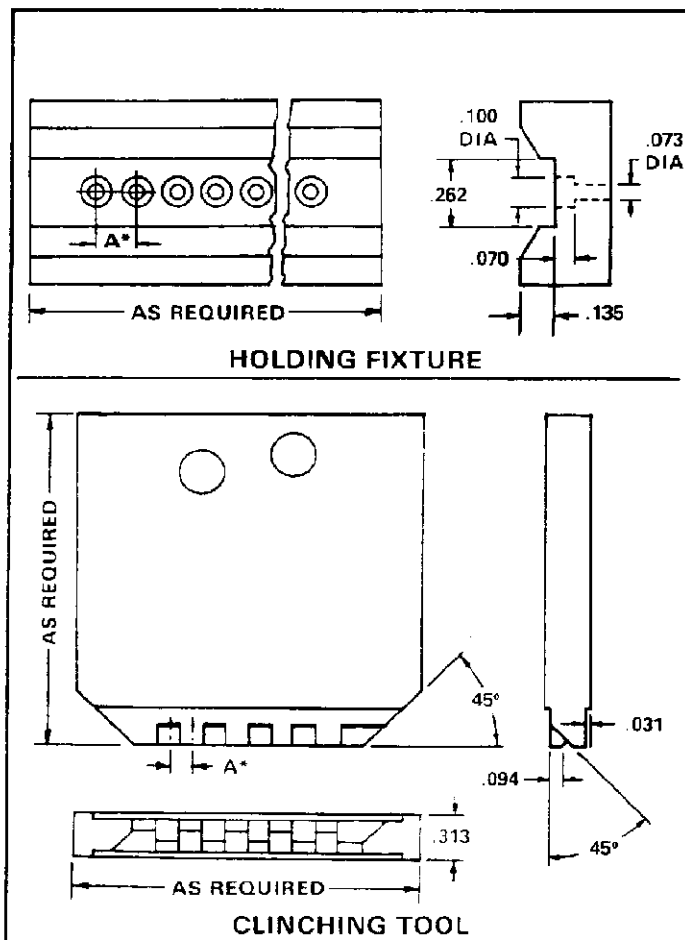
3. PRINTED CIRCUIT BOARD LAYOUT

Determine the post centerline spacing and number of post positions in the header assembly to be mounted. Prepare the pc board using the dimensions provided in Figure 1.

4. CLINCHING PROCEDURES

A. Machine Clinching

A standard arbor press, a holding fixture, and a clinching tool are required to perform production line applications. The holding fixture supports the header assembly and pc board in the press base. The clinching tool bends the post to retain the header assembly on the pc board. Refer to the recommended dimensions provided in Figure 2 for construction of a holding fixture and a clinching tool.



* DETERMINED BY POST CENTERLINE SPACING - SEE CHART IN FIGURE 1.

Fig. 2

Refer to Figure 3 and proceed as follows:

1. Secure clinching tool to press ram.
2. Position holding fixture on press base. Make certain holding fixture holes are centered under clinching tool surfaces.
3. Insert header assembly posts (long ends) into holding fixture holes. Bottom housing on fixture.
4. Align pc board holes with posts (short ends). Press board down on posts until it seats on fixture.

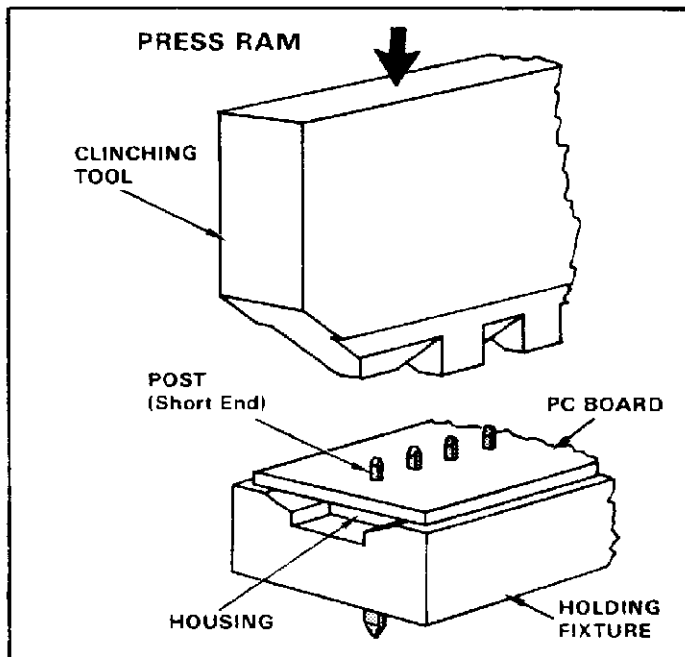


Fig. 3

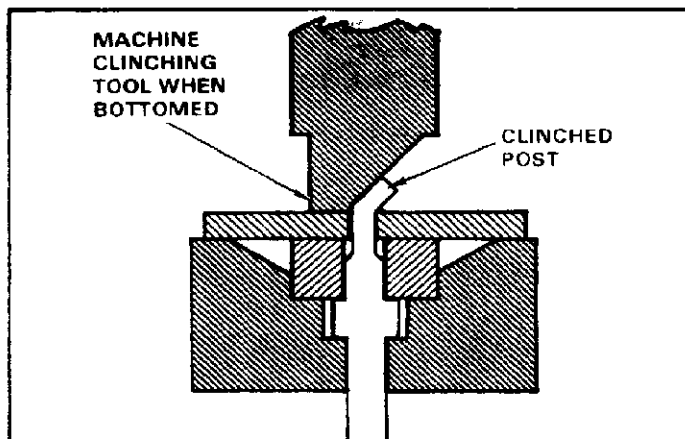


Fig. 4

5. Actuate press until clinching tool bottoms on pc board. Release pressure and remove clinched assembly from holding fixture. Check to be sure all posts are properly clinched (see Figure 4).
6. After all posts are clinched, they should be soldered to the pc board.

B. Manual Clinching

A support fixture and a common screwdriver are required to perform low volume applications. Make sure support fixture height is greater than post length.

Refer to Figure 5 and proceed as follows:

1. Insert header assembly posts (long ends) between support fixture and allow housing to rest on fixture.
2. Align pc board holes with posts (short ends). Press board down on posts until it bottoms on housing.
3. Position screwdriver tip at an angle between two posts. Keeping blade parallel to pc board, raise screwdriver slightly above board. Rotate screwdriver until posts are clinched.
4. Repeat Step 3 until all posts are clinched.

NOTE

The direction of bend must be alternated so that posts will retain pc board.

5. After all posts are clinched, they should be soldered to the pc board.

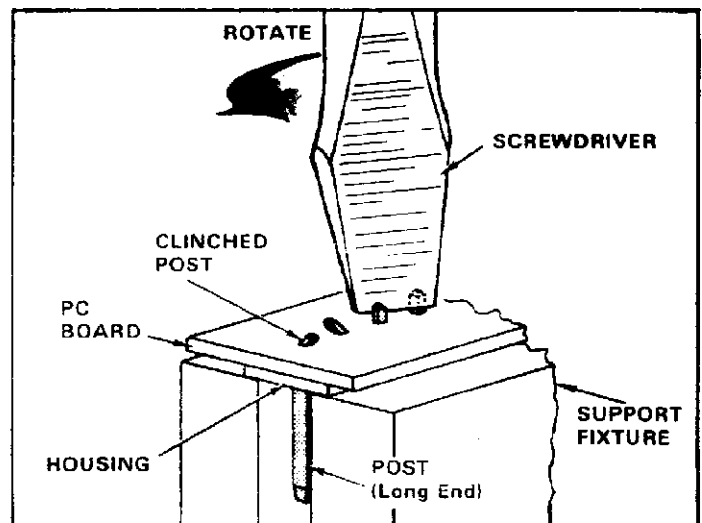


Fig. 5