

Figure 1

## 1. INTRODUCTION

Seating Tools 318868-1, 91326-1, and 91327-1 and Support Anvil 318867-1 are used to seat upper ground return shields onto Z-PACK HM 2mm receptacles and right-angle receptacles with integral upper ground return shields onto printed circuit (pc) boards. The shields and receptacles with integral shields contain ACTION PIN contacts to allow solderless pc board installation. See Figure 1.

**NOTE**

*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

Read these instructions and understand them before using the seating tool and support anvil.

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

## 2. DESCRIPTION

The seating tool and support anvil are each a one-piece design.

The support anvil is positioned into a pc board support fixture to support the pc board. During seating, the seating tool covers the shield and receptacle and presses on the top surface of the shield when the applicator ram applies force.

## 3. REQUIREMENTS

### 3.1. PC Board Support Fixture (Customer Supplied)

A pc board support must be used to provide proper support for the pc board and to protect the pc board and header assembly from damage. PC Board Support Fixture 679980-[ ] is recommended for use with this seating tool and support anvil. For proper selection and detailed information, refer to instruction sheet 408-4038. Or, design a pc board support fixture using the recommendations in 408-6927.

### 3.2. Application Tooling

Power for the seating tool must be provided by an application tool (with a ram) capable of supplying a downward force of 89 N [20 lb] per contact.

Manual Electric Servo Presses (CMP 6T) 1585699-8 and (CMP 12T) 1585698-8, and Bench Top Electric Servo Press (CBP 5T) 1585696-9 are available for this seating tool. For information on the presses, visit the press-fit assembly equipment website at <http://tooling.te.com/pressfit.asp>.

### 4. SEATING

1. Set the seating height to the dimension shown in Figure 2 (machine shut height will equal the seating height *plus* the combined thickness of the pc board and pc board support fixture).
2. Position the support anvil, grooved side up, into the pc board support fixture, and center it under the ram of the application tooling. Position the pc board with the receptacle over the support anvil.
3. Position the shield or receptacle (with integral shield) onto the pc board so that the contacts are properly aligned to the pc board and the support anvil. See Figure 2.
4. Insert the contacts into the pc board until the compliant lead section of the contacts are resting securely on, but have not fully entered, the pc board.

### 5. Position the seating tool onto the shield.

6. Center the seating tool and shield under the ram of the application tooling; slowly lower the ram until it just meets the seating tool. Verify the alignment of the pc board support, pc board, connector, shield, seating tool, and anvil.

**CAUTION**



*Damage to the pc board, seating tool, shield, or receptacle may occur if the seating height is improperly set, if the pc board is not properly positioned over the support anvil, or if the seating tool is not properly seated on the shield before cycling the ram.*

7. Cycle the ram according to instructions for the application tooling. Check the assembly for proper seating using the requirements in Figure 2.

8. Remove the pc board with the seated shield or receptacle (with integral shield), or re-position the pc board and pc board support for seating additional shields or receptacles (with integral shields).

### 5. MAINTENANCE AND INSPECTION

Inspect the seating tool and support anvil using Figure 3 immediately upon arrival at your facility to ensure that they have not been damaged during shipment. Thereafter, regular inspections should be performed by quality control personnel. Remove dust, moisture, and other contaminants with a clean, soft brush, or lint-free cloth. Do NOT use objects that could damage parts. When not in use, store them in a clean, dry area.

**Note:** View After Seating

**Note:** Not to Scale

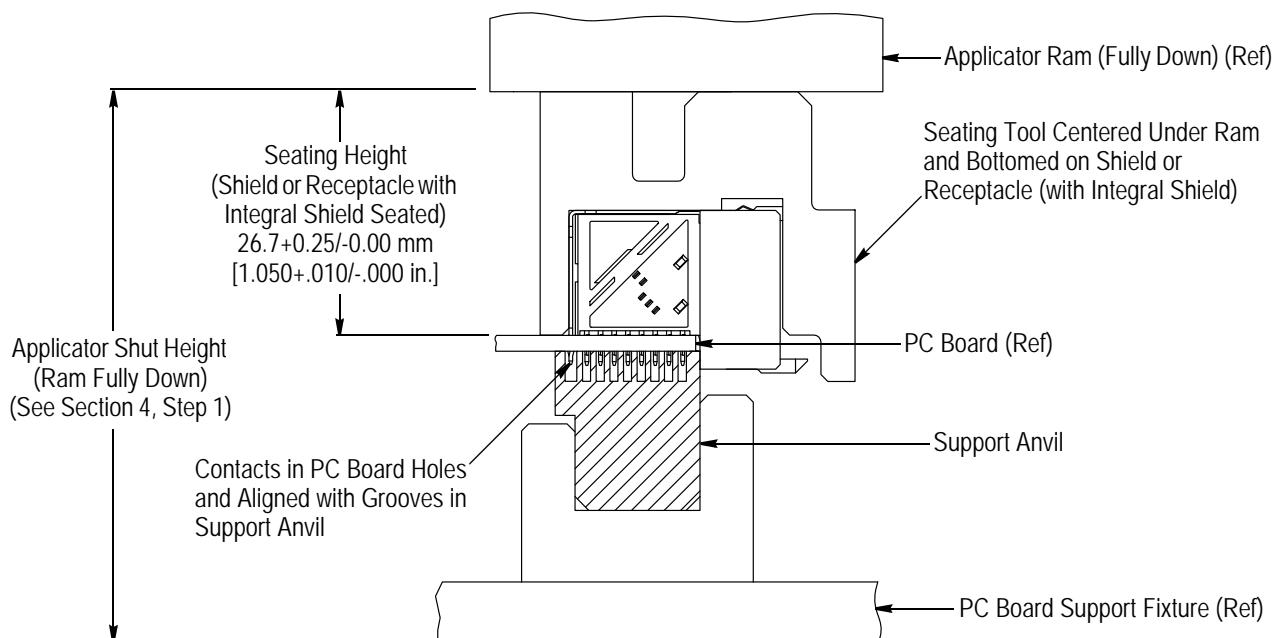


Figure 2

## 6. REPLACEMENT AND REPAIR

Order replacement seating tools and support anvils through your Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (038-035)  
 TYCO ELECTRONICS CORPORATION  
 PO BOX 3608  
 HARRISBURG PA 17105-3608

The seating tool and support anvil may be returned for evaluation and repair. For customer repair service, call 1-800-526-5136.

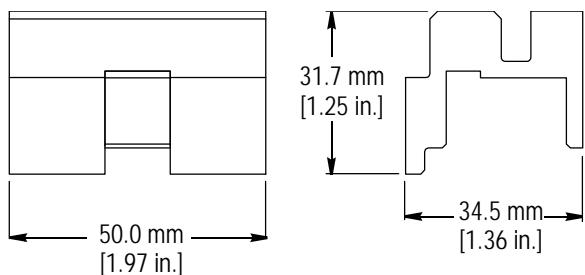
## 7. REVISION SUMMARY

Revisions to this instruction sheet include:

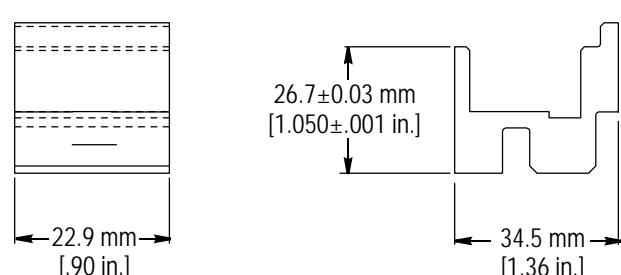
- Changed company name and logo
- Changed tooling information in Paragraph 3.2

### *Initial Inspection of Tooling*

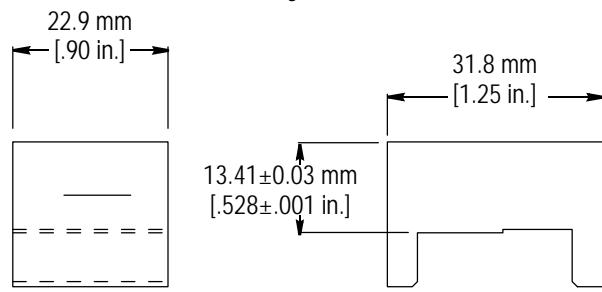
*Seating Tool 318868-1*



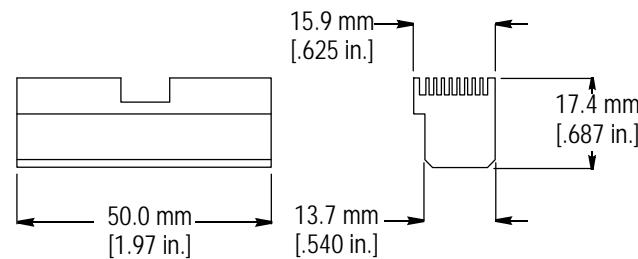
*Seating Tool 91327-1*



*Seating Tool 91326-1*



*Support Anvil 318867-1*



*Figure 3*

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