

Amphenol

TB-2051

TUNING FORK CONTACT INSERTION TOOL FOR KS1025 SERIES
PART NO. 600-0274-000

REVISION “-”

SPECIFICATION REVISION STATUS

<u>Revision</u>	<u>SCR No.</u>	<u>Description</u>	<u>Initial</u>	<u>Date</u>
“-”	26411	Initial Release (Supersedes TB-208)	H. Cook	12-18-98

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1.0 SCOPE

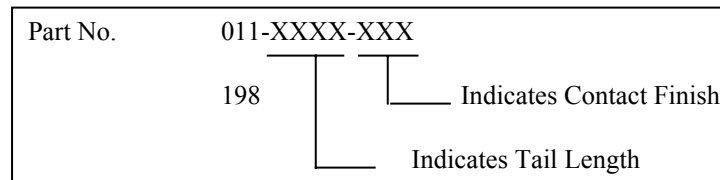
- 1.1 This technical bulletin covers Tuning Fork Contact Insertion Tools for KS1025 Series, Part No. 600-0274-000.

2.0 PROCEDURE

- 2.1 Intended Use – For insertion of replacement contacts into vacated contact positions in PC boards. It is not necessary to remove contact insulators. However, if the insulator is removed, it can be reused two or three times without significantly reducing its retention although it is better to use a new insulator if available.

2.2 Method of Use

- 2.2.1 Be certain that the new contact is a correct replacement part.



- 2.2.2 Support connectors with wrappost end of contact facing up. The connector should rest on parallel supports approximately 1” high. The face of the supports should be covered with a protective material such as masking tape to prevent damage to the connector. The supports should be positioned to give maximum support to the connectors. With large PC boards, it is more practical to lay the plate on a suitably sized sheet of plastic foam 1” thick.
- 2.2.3 Place a new contact into the vacant hole position and orient correctly.
- 2.2.4 Insert the blade of insertion tool into the fork of the new contact (see Figure 1).
- 2.2.5 Hold tool so that it is vertical to the connector in all planes and also so that the blade is in line with any other contacts in the same row.
- 2.2.6 Strike the top of the tool gently with a small mallet until the contact is fully seated being careful not to tilt the tool from vertical as this may probe open the tuning fork.
- 2.2.7 Inspect for proper seating and alignment of contact and probing (see Figure 1).

NOTE: This tool is not intended for production use. Rows of contacts inserted by this tool do not, therefore, reflect the integrity of alignment made possible by volume production tools.

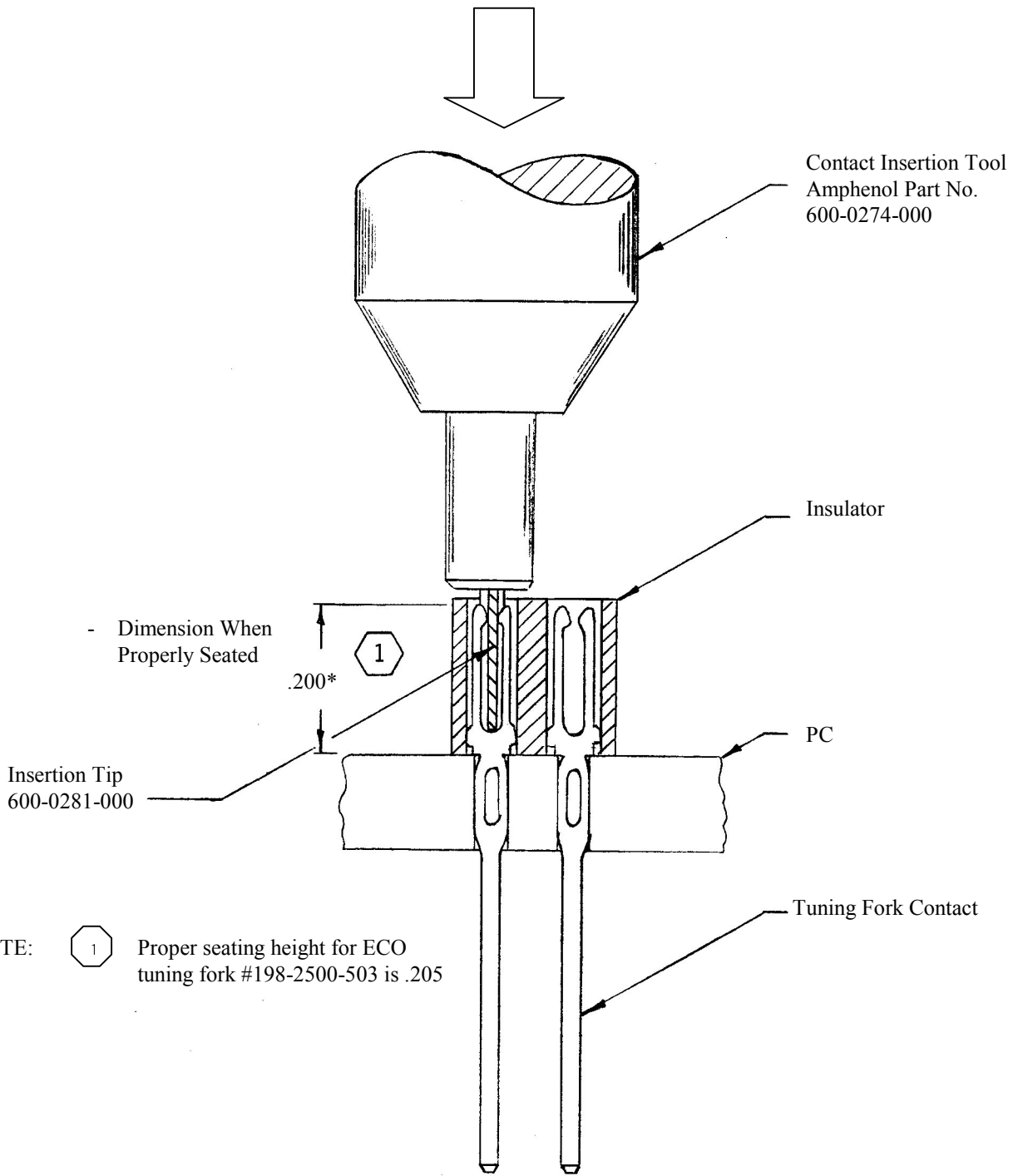


Figure 1