

Amphenol

TB-2056

TUNING FORK GROUND REWORK PROCEDURE FOR S1000, S1200, AND S1500 SERIES
PART NO. 516-0014-000

REVISION “-”

SPECIFICATION REVISION STATUS

| <u>Revision</u> | <u>SCR No.</u> | <u>Description</u> | <u>Initial</u> | <u>Date</u> |
|-----------------|----------------|-------------------------------------|----------------|-------------|
| “-” | 26416 | Initial Release (Supersedes TB-217) | H. Cook | 12-18-98 |

Copyright © 2001 by Amphenol Backplane Systems. The material contained in this document is proprietary to Amphenol Backplane Systems. It may not be disclosed to third parties in any form or by any means, electronic, mechanical, photocopying, or recording without the prior written permission of Amphenol Backplane Systems.

1.0 SCOPE

- 1.1 This technical bulletin covers the Tuning Fork Ground Rework Procedure for S1000, S1200, and S1500 Series, Part No. 516-0014-000.

2.0 TOOLS

- 2.1 Contact Removal Tool – Tool No. 600-0002-000
2.2 Bushing Breakoff Tool – Tool No. 600-0156-000
2.3 Stem Removal Tool – Tool No. 600-0157-000
2.4 Multi Position Support Tool – Tool No. 600-0160-000
2.5 Bushing Insertion Tool – Tool No. 600-0158-000
2.6 Contact Insertion Tool – Tool No. 600-0004-000
2.7 Contact Sizing Tool – Tool No. 600-0162-000
2.8 Hole Diameter Gauge – Tool No. 600-0164-000
2.9 Mallet – Tool No. 600-0172-000

3.0 PROCEDURE

- 3.1 Intended Use – For use at Maintenance Level 4 facilities (i.e., contractor site – GEOS). This technical bulletin covers the removal of tuning fork ground bushings from the baseplate. It is necessary to remove the fork contact prior to using the bushing removal tooling. As will be seen, the bushing will be destroyed during removal and will require replacement.

CAUTION: When reworking wrapped plates, the area around the bushing to be reworked should be cleared either by tying back wires or if necessary unwrapping wires. These should be clearly identified for rewinding after completion of rework.

- 3.2 Place backplane connector side down on supporting strips and using Tool No. 600-0002-000, push out contact from the rear (wirewrap side) of the backplane.
- 3.3 Fully insert Tool No. 600-0156-000 into the bushing from the front (connector side) of the plate and by inclination of the tool, break the main bushing body away from the stem in the plate. Check adjacent bushings for damage and replace as necessary.
- 3.4 Support the rear of the plate on parallel strips of insulating material between the banks of contact terminations as shown.

NB: For Wired Assemblies, Support Plate on Foam Pad



- 3.5 Using Tool No. 600-0157-000, drive the ground bushing stem from the plate. Recover the stem and probe the rear of the plate.
- 3.6 Gauge the hole diameter using Tool No. 600-0164-000 (rotate gauge through 90° to determine hole size). If the diameter is over .0742, hold the plate for further disposition.
- 3.7 Take a new bushing, Part No. 516-0106-000, and fit onto Tool No. 600-0158-000. Ensure that the plate is fully supported using Tool No. 600-0160-000 or foam pad for wired assembly and that the tool is approximately perpendicular to the plate. Feed the bushing stem into the hole in the plate and tap home until the top of the tool touches surrounding ground or insulator.
- 3.8 Take a new contact, Part No. 010-5514-533, and check contact orientation using Tool No. 600-0004-000. Insert contact into the bushing from the front of the plate and tap home.
- 3.9 Check that contact height is flush or below top edge of bushing.
- 3.10 Check contact gap per WS6157, Paragraph 4.6.7, and adjust using Tool No. 600-0162-000 if necessary.
- 3.11 Check pushout force per WS6157, Paragraph 3.3.2.
- 3.12 Check torque per WS6157, Paragraph 3.3.3.
- 3.13 Check contact resistance (IR) on the replace bushing and retest entire plate for contact resistance.

