

Description:

AirBorn's R-series compliant pin (press-fit) assembly tooling consists of a support plate, a fixture plate, an insertion head and a hydraulic, mechanical or pneumatic press.

Support plate: A flat metal plate which is mounted directly to the press base.

Fixture plate: A G10 or phenolic plate which is identical to the PWB drill pattern but is typically .50-1.0" thick. The holes in the fixture plate are clearance holes and should be drilled at $\phi.038/.042$ ".

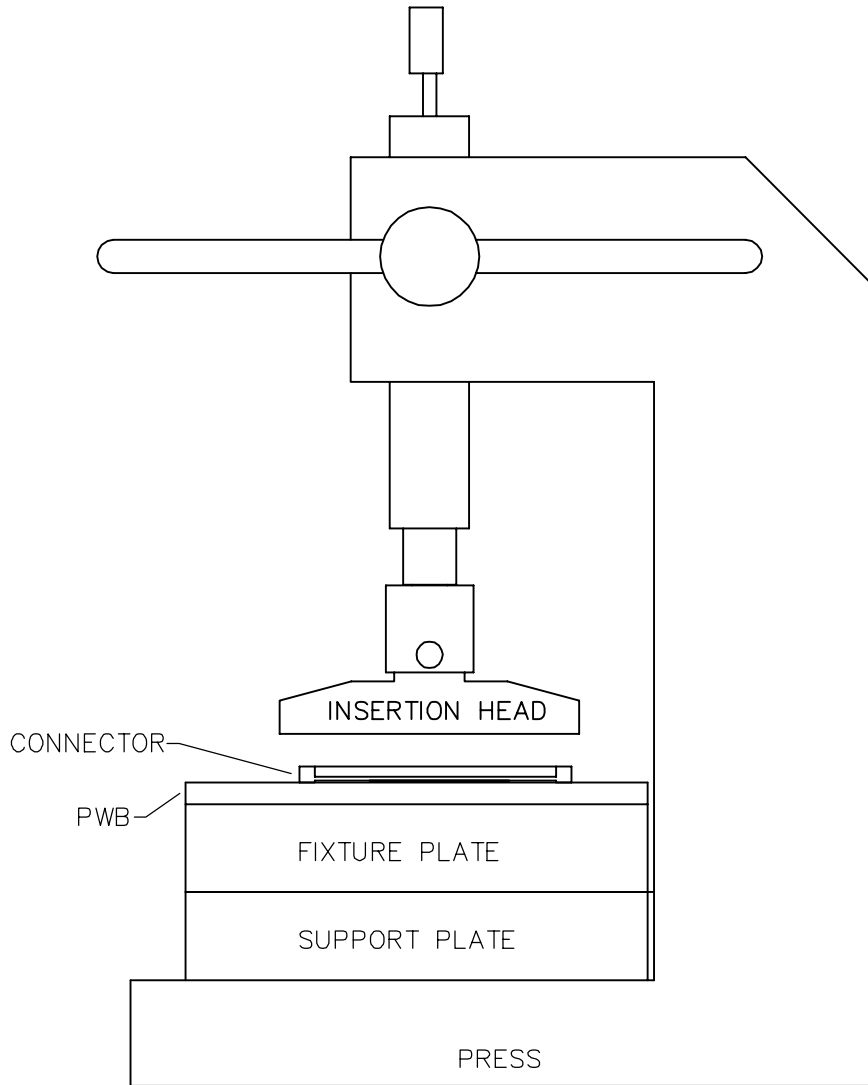
Insertion head: A flat-faced metal plate with means for attachment to the ram of the arbor press. The head must be as wide as the connector and should extend the length of the connector.

Note: Hardware is shipped unassembled for all compliant pin connectors so there is not a need for clearance holes for hardware in the insertion head.

Arbor press: Must be capable of exerting a force equal to a minimum of 20 lbs. per contact. The average press-in force per contact is 12-15 lbs. The contact, when fully inserted into the PWB, will be flush with the mating surface of the connector.

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					ENGR.	DLH	061898				
					MFG.			TITLE	ASSEMBLY INSTRUCTIONS COMPLIANT PINS, R-SERIES		
	~	INITIAL RELEASE	DLH	061898	QA			SIZE	A	REV. SHEET	1 OF 2
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