

| CONNECTOR DESCRIPTION | | | | | REPLACEMENT CONTACT | |
|--|----------------|-----------------------|--------------------|-----------------------|---------------------|------------|
| CONTACT DESIGNATOR | IN-ROW SPACING | WITHOUT MOUNTING EARS | WITH MOUNTING EARS | WITH THREADED INSERTS | TYPE | PART NO. |
| Flow Solder (.140 in. row-to-row spacing) | .125 in. | 530673 | 530659 | 530685 | Flow Solder | 1-530652-4 |
| | | 530674 | 530661 | 530686 | | |
| | .156 in. | 530668 | 530657 | 530679 | | |
| 530669 | | 530658 | 530680 | | | |
| Flow Solder (.200 in. row-to-row spacing) | .125 in. | 530671 | 530662 | 530683 | Flow Solder | 1-530651-4 |
| | | 530672 | 530663 | 530684 | Flow Solder | 1-530651-4 |
| | .156 in. | 530666 | 530655 | 530677 | Solder | 1-530651-4 |
| | | 530667 | 530656 | 530678 | | |
| Solder Eyelet | .125 in. | --- | 530664 | 530682 | Solder Eyelet | 1-530650-2 |
| | .156 in. | --- | 530654 | 530676 | | |

FIGURE 1

1. INTRODUCTION

This instruction sheet (IS) covers the removal and replacement of contacts in the AMP Low Profile Edge Connectors listed in Figure 1.

Read this material thoroughly before starting.

2. DESCRIPTION

These connectors consist of low profile housings with factory installed bifurcated spring contacts. The connectors designed for printed circuit (pc) board applications have row-to-row contact centerline spacing of either .140 or .200 in., and flow solder contacts installed. The connectors designed for wiring applications have solder eyelet contacts installed. The base part numbers for all connectors are listed in the chart in Figure 1.

All housings have dual contact positions, with in-row contact centerline spacing of either .125 or .156 in. They are molded with or without mounting ears. Those with mounting ears are available with threaded inserts installed. See Figure 1.

Contacts have a single lance that provides retention inside the housing. Although they have been designed for maximum retention, the contacts can easily be removed and replaced. This includes those that are soldered AND those that are NOT soldered to a pc board.

3. REMOVING A DAMAGED CONTACT (See Figure 2)

The following procedure applies to connectors that are soldered to a pc board as well as those that are NOT . . . simply omit Step 1 when removing a contact from an unsoldered connector.

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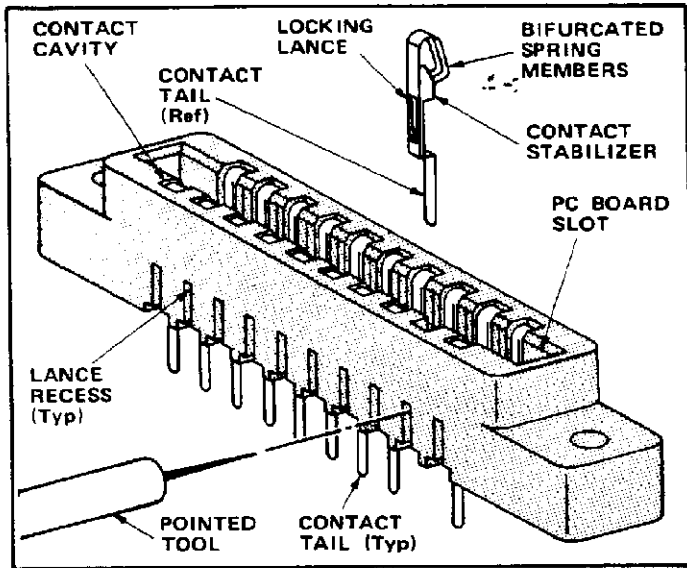


FIGURE 2

Proceed as follows:

1. Heat and remove ALL solder securing the damaged contact to the pc board. If applicable, remove wire from tail of contact.
2. Insert a pointed tool into the lance recess and depress the lance. Only light force will be required.
3. Push on the tail of the contact to force the contact out through the pc board slot.
4. Pull the contact straight out of the pc board slot and *discard it*.

4. INSTALLING A CONTACT

The following is applicable for connectors that are soldered to a pc board AND those that are NOT.

Proceed as follows:

1. Select the applicable contact using the selection chart in Figure 1.
2. Align the tail of the contact with the contact cavity as indicated in Figure 2. Make sure the spring members are facing the center of the connector.
3. Guide the contact tail into the contact cavity (and if applicable, through the hole in pc board) until the stabilizer **STARTS** entry, into the connector as indicated in Figure 3. Do NOT fully insert the contact at this point as damage to the spring members could result.

4. Select an .062 in. thick dummy board that is wide enough to cover at least three (3) contact positions. The dummy board must NOT interfere with keying plugs – if necessary – make a cut-out in the board. Do NOT remove any keying plugs.

5. Insert the dummy board *straight* into the pc board slot until it bottoms. Make sure the contact does NOT slide into the connector as the dummy board is inserted. Also, make sure the contact spring members are NOT over deflected and deformed during insertion of the board.

6. Using care, push the contact straight into the connector until it bottoms.

7. Remove the dummy board and check to be sure both spring members are seated behind the spring retainer as shown in Figure 3. If NOT, remove and discard the contact. Then replace it with a new one. Do NOT attempt to reset deformed locking lance or spring members.

NOTE

The contact tail length and the gold plating equal the maximum for contacts used in these connectors. If the tail length is too long – cut off excess with a good pair of diagonal cutters.

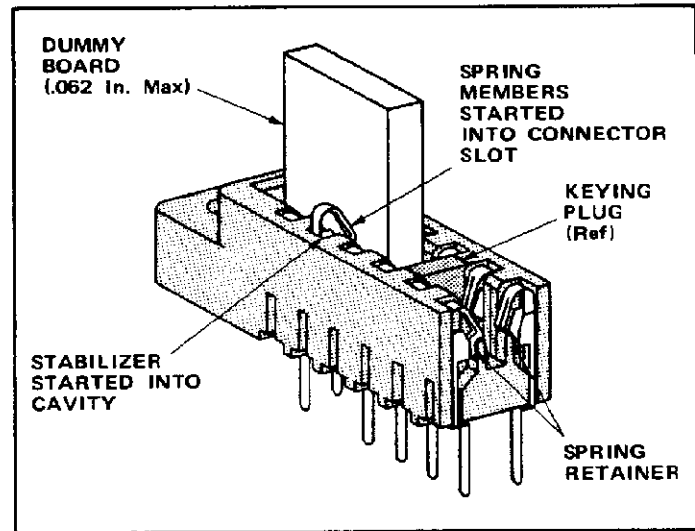


FIGURE 3

8. If the contact was removed from a connector that was soldered to a pc board, solder the replacement contact into position using standard soldering techniques.

This completes the removal and replacement of a damaged contact.