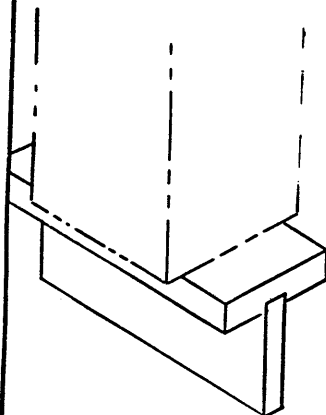
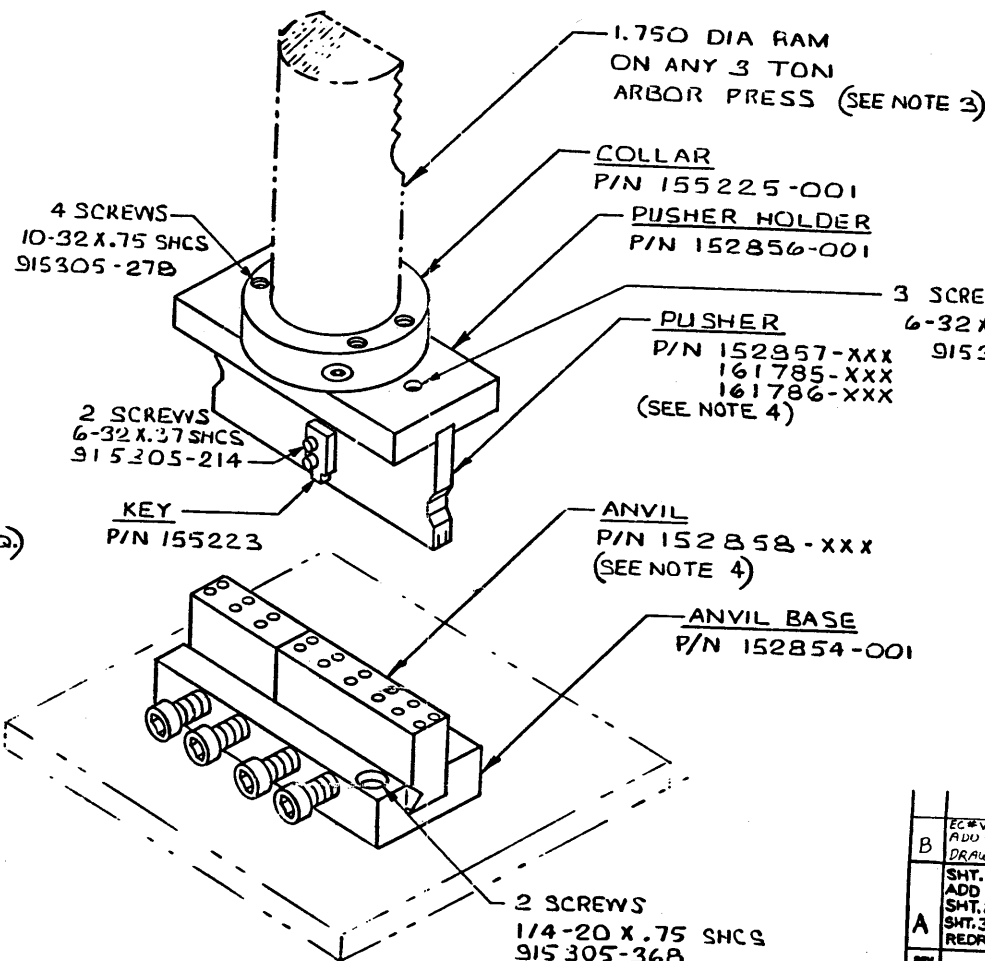


PART NO.
TA-556



OPTIONAL SQUARE
RAM MOUNTING
(NOTE: MACHINING REQ.)



- NOTES
1. BREAK ALL SHARP EDGES APPROX .010
 2. LEAVE ALL SHARP EDGES
 3. MARK IN AREA INDICATED BY X
 4. PART NO.
 5. REVISION LEVEL
3. RECOMMEND
"GREENERD" ARBOR
PRESS MODEL
3A FOR CIRCUIT
BOARDS 24 INCHES
SQUARE AND SMALLER
4. DASH NUMBERS
FOUND ON PAGE
3 OF 4
5. COMPLETE KIT
NUMBER 155220

B	EC#V40197	Jm	GSP	GSP
	ADD -035 TO SHT. 3. DRAW SHCS ON AUTO CAD			
A	SHT. 1 WAS SHT. 2 ADD 161785 & 161786. SHT. 2 WAS SHT. 1 SHT. 3: CHART REV'D & REDRAWN.	DRW	11-6-90	DATE
	CN-4661			
REV	DESCRIPTION	DATE	CHKD	APPD

UNLESS OTHERWISE SPECIFIED:		SUPER FINISH PROTECTION	
SURFACE FINISH	ALL OVER	MATERIAL	HARDNESS
TOLERANCES UNLESS		ALT. MATL.	HARDNESS
LINEAR	0.00 ± 0.25 0.00 ± .01	FINISH	
	0.000 ± 0.127 0.000 ± .005	DRW	PONTIUS
	0.0000 ± 0.0025 0.0000 ± .0000	DATE	2-22-72
	ANGLES ± 1°	APPD	P.H.
EPL 155220		DATE	9-13-87
USED ON		SCALE	1/-

DU PONT CONNECTOR SYSTEMS

TITLE PRESS-FIT GKE. HDR TOOLING INFORMATION

SIZE C

TA-556

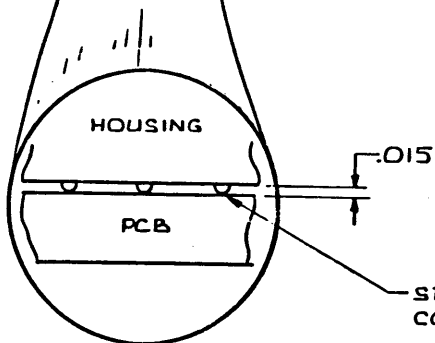
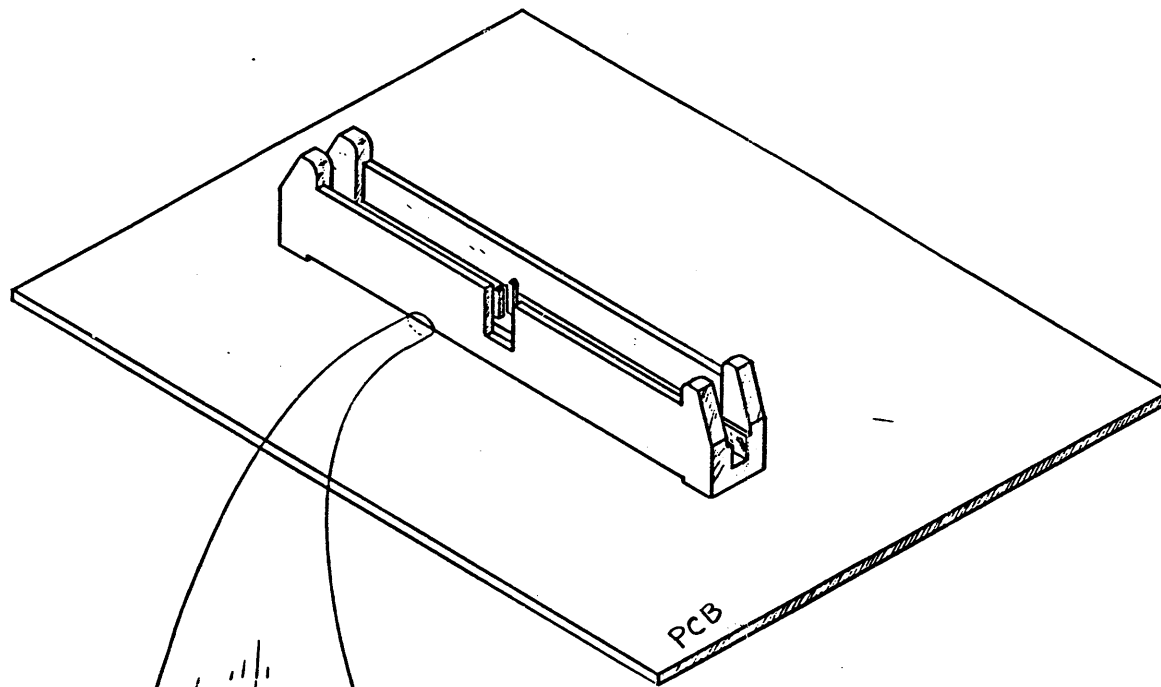
SHEET 1 OF 4

DO NOT SCALE DRAWING

C B A

PART NO.
TA-556

- NOTES
 1. ☐ BREAK ALL SHARP EDGES APPROX. .010
☐ LEAVE ALL SHARP EDGES
 2. MARK IN AREA INDICATED BY X _____
☐ PART NO.
☐ REVISION LEVEL



TYP. FOR BOTH
SEA HORSE AND SLIM LINE
PRODUCT

STAND-OFF MUST
CONTACT PCB

UNLESS OTHERWISE SPECIFIED:		THIRD ANGLE PROJECTION	
SURFACE FINISH	✓ ALL OVER	MATERIAL	HARDNESS
TOLERANCES MM		ALT. MAT'L	HARDNESS
LINEAR	$0.00 \pm 0.127 (0.00 \pm .005)$ $0.000 \pm 0.0127 (0.000 \pm .0005)$ $0.0000 \pm 0.0127 (0.0000 \pm .00005)$ $0.0000 \pm 0.00127 (0.0000 \pm .00001)$	FINISH	DATE 2-2-82
ANGLES	$\pm 1^\circ$	DRN Positive	C/D
USED ON		APPR /	4-8-87

B			
A			
REV	DESCRIPTION	DATE	BY
DU PONT CONNECTOR SYSTEMS			
TITLE PRESS-FIT QKE HDR TOOLING INFORMATION			
DATE	DATE	DATE	DATE
C	TA-556		
SHEET 2 of 4			
SCALE	/	DO NOT SCALE DRAWING	

C

B

A

PDM: Rev: B

STATUS: Released

Printed: Jan 24 2006

PART NUMBER
TA-556

TOOLING SELECTION CHART FOR QUICKIE™ PRESS FIT HEADERS - SLIMLINE AND SEAHORSE.

NOTES:
1. CHAMFER ALL SHARP EDGES APPROX. .010
2. LEAVE ALL SHARP EDGES
3. HIDE IN AREA INDICATED BY X
4. PART NUMBER
5. REVISION LEVEL

		NUMBER OF POSTIONS												
		2X5	2X7	2X8	2X10	2X12	2X13	2X15	2X17	2X20	2X22	2X25	2X30	2X35
PUSHER (NOTE 1)														
SUPERTIP	PYRAMID TIP													
161786-007	152857-007													
161786-010	152857-010													
161786-013	152857-013													
161786-017	152857-017													
161786-022	152857-022													
161786-025	152857-025													
161786-030	152857-030													
161786-035	152857-035													

		NUMBER OF POSTIONS												
ANVIL		2X5	2X7	2X8	2X10	2X12	2X13	2X15	2X17	2X20	2X22	2X25	2X30	2X35
152858-007		1	1							1				1
152858-010				1	1						1	1		
152858-013						1	1			1	1		1	1
152858-017								1	1			1	1	1

DESC.	QTY.	PART NUMBER	IN ADDITION TO THE VARIABLE TOOLING SHOWN IN THE CHART ABOVE THESE 4 PARTS ARE REQ'D FOR A COMPLETE TOOLING SET.
ANVIL BASE	1	152854-001	
KEY	1	155223-001	
PUSHER HOLDER	1	152856-001	
COLLAR (NOTE 2)	1	155225-001	

NOTES:

- FOR MULTI-KEY HEADER PUSHER SELECTION SEE DWG. 161785.
- P/N 155225-001 IS FOR USE WITH 1-3/4" DIA. ARBOR PRESS RAM.

REV	DESCRIPTION	BY	DATE
B	EC/ V40197	JM	7/94
ADD	2X35	JM	7/94

TOLERANCE UNLESS OTHERWISE SPECIFIED		THIRD ANGLE PROJECTION	
SURFACE FINISH	ALL OVER	MATERIAL	HARDNESS
TOLERANCE IN/MM		ALT. MAT'L	HARDNESS
LINEAR	0.001 0.002 0.005 0.010 0.020 0.050 0.100 0.150 0.250 0.500 1.000 1.500 2.000 3.000 4.000 5.000 6.000 8.000 10.000 12.000 15.000 20.000 25.000 30.000 40.000 50.000 60.000 80.000 100.000 120.000 150.000 200.000 250.000 300.000 400.000 500.000 600.000 800.000 1000.000 1200.000 1500.000 2000.000 2500.000 3000.000 4000.000 5000.000 6000.000 8000.000 10000.000 12000.000 15000.000 20000.000 25000.000 30000.000 40000.000 50000.000 60000.000 80000.000 100000.000 120000.000 150000.000 200000.000 250000.000 300000.000 400000.000 500000.000 600000.000 800000.000 1000000.000 1200000.000 1500000.000 2000000.000 2500000.000 3000000.000 4000000.000 5000000.000 6000000.000 8000000.000 10000000.000 12000000.000 15000000.000 20000000.000 25000000.000 30000000.000 40000000.000 50000000.000 60000000.000 80000000.000 100000000.000 120000000.000 150000000.000 200000000.000 250000000.000 300000000.000 400000000.000 500000000.000 600000000.000 800000000.000 1000000000.000 1200000000.000 1500000000.000 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STEP #1. SELECT PROPER "PUSHER" AND "ANVIL" DASH NUMBERS WHICH AGREES WITH THE NUMBER OF POSITIONS IN THE HOUSING BEING USED. SEE ATTACHED CHART

NOTE: WHEN USING A SHORT SOLDIER TAIL, THE CUSTOMER MAY ELECT TO REPLACE THE ANVIL AND ANVIL HOLDER WITH A DUPLICATE CIRCUIT BOARD, PRECISELY LOCATED BENEATH THE BOARD TO BE INSERTED.

STEP #2. OBTAIN AN ARBOR PRESS BETWEEN TWO AND THREE TONS CAPACITY. THE TOOLING IS ADAPTABLE TO BOTH ROUND AND SQUARE RAM TYPES. A ROUND RAM AS USED IN A "GREENARD" ARBOR PRESS MODEL 3A REQUIRES NO MACHINING.

STEP #3. MOUNT TOP TOOLING TO THE RAM BY TIGHTENING THE SET SCREW.

NOTE: A SMALL PIECE OF SOFT BRASS OR COPPER SHOULD BE PLACED BETWEEN THE SET SCREW AND THE RAIN TO PROTECT THE RAIN'S SURFACE.

STEP #4. WHEN USING AN ANVIL, CENTER THE ANVIL HOLDER WITH THE TOP TOOLING AND MOUNT TO THE BASE PLATE WITH TWO 1/4" - 20 SOCKET HEAD CAP SCREWS.

CAUTION: ANVIL HOLDER MUST BE CENTERED IN BOTH DIRECTIONS AND ALSO PARALLEL TO TOP TOOLING.

STEP #5. PLACE HOUSING ON TOP TOOLING USING THE LOCATING KEY TO CENTER THE HOUSING ON THE TOOL.

STEP #6. USING THE PRESS - FIT SECTION OF THE PIN TIPS, LOCATE THE ANVILS IN THE ANVIL HOLDER AND SECURE IN POSITION BY THE FOUR 8-32 SOCKET HEAD CAP SCREWS.

STEP 47. LINE UP THE HOLES IN THE CIRCUIT BOARD WITH THE PIN TIPS AND APPLY ENOUGH FORCE TO SEAT THE HOUSING DOWN ONTO THE CIRCUIT BOARD.

CAUTION: IF BOARD IS NOT DIRECTLY BENEATH THE PIN TIPS IMPROPER TERMINATION WILL RESULT.

• • DUPONT TRADEMARK

	UNLESS OTHERWISE SPECIFIED:		TWO ANGLE PROJECTIONS 		DU PONT CONNECTOR SYSTEMS TITLE PRESS-FIT GKE. HDR. TOOLING INFORMATION	
	SURFACE FINISH ✓	ALL OVER	MATERIAL	HARDNESS		
	TOLERANCES UNLESS		ALT. MAT'L.	HARDNESS		
	LINEAR	0.008 ± 0.0008 @ 0.91		FINISH	SIZE C	Dwg No TA-556
		0.000 ± 0.127 @ 0.005				
		0.000 ± 0.0127 @ 0.0005				
		0.0000 ± 0.0001 @ 0.0000				
		0.0000 ± 0.0001 @ 0.0000		CHEM	PONTIUS DATE 3-2-81	
USED ON	ANGLES ± 1°		APPROX. 4-1-81		SCALE /	SHEET 4 of 4
DO NOT SCALE DRAWING						