

AMPHENOL TCS

TB-2047

VHDM[®] 6 AND 8 ROW CONNECTOR SINGLE PIN REPLACEMENT PROCEDURE

Revision “D “

Specification Revision Status

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“A”	26408	Revised in its Entirety	C. Murphy	12-18-98
“B”	39894	Add trade mark and reformatted	P. Yeh	09-13-02
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1.0 SCOPE

- 1.1 This technical bulletin describes the process for VHDM 6 and 8 row connector single pin replacement.

2.0 TOOLS

- 2.1 Pin Replacement Tool – Part No. 600-1881-000 (See Figure 1)
- 2.2 Miniature Needle Nose Pliers
- 2.3 Non-Conductive Tweezers
- 2.4 Test Probe (TECHNI-TOOL) – Set No. 202SP040

3.0 PROCEDURE

- 3.1 **Removal of Damaged Pin** - The method for removing a bent or otherwise damaged signal pin varies slightly according to the severity of the damage. If the pin is not badly damaged it may be possible to grasp it with a pair of miniature needle nose pliers and pull straight up removing the pin. A pin that is severely bent may have to be straightened somewhat, with a test probe or tweezers, to allow access with the pliers. In certain instances, removal of an adjacent pin might facilitate removal of the damaged pin. If there is access to the other side of the PC board the damaged pin may be pushed out from that side. An 0.018" to 0.020" diameter steel pin would be used in this case. This is particularly useful in the event of a pin that is broken off at the insulator surface.
- 3.2 **Replacement of the Pin** - Several methods may be utilized for the installation of a new signal pin. The correct method is determined by the attitude of the PC board. If the board is vertical the new pin is placed mating end first in Tool No. 600-1881-000. The pin is oriented in the tool so it sits in the slot (see Figure 2) at the tip. This slot is parallel to two of the flats on the hexagonal shaped handle. These flats are used to aid in pin orientation. The flats are placed parallel to the sides of the insulator. The new pin is then inserted into the insulator and seated. Once this has occurred, pull back slightly on the tool and rotate it 90° and press down on it. This fully seats the contact. Remove the tool and visually inspect replaced contact for perpendicularity and true position using the surrounding pins as a reference. In cases where the backplane is horizontal, the new pin may not be retained in the tool. If this is the case, the pin will have to be placed in the insulator using non-conductive tweezers prior to using Tool No. 600-1881-000 for seating purposes. When tweezers are utilized in placing the contact, care must be used not to scratch the mating surface.

The preferred way of accomplishing this is to grasp the contact by the sides perpendicular to the mating surfaces. If the contact is placed with tweezers, the orientation of the tool is not important. Note the continued emphases on new pins. Never should a complaint pin be inserted into a PC board twice. Also no more than three new pins should ever be pressed into any plated thru hole.



Figure 1

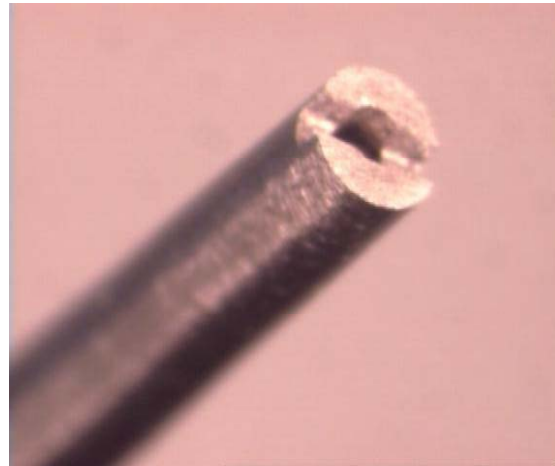


Figure 2