

# AMPHENOL TCS

TB-2009

HDM DAUGHTERCARD POLARIZING KEY INSERTION PRESS  
PART NO. 602-0555-000

REVISION "D"

## SPECIFICATION REVISION STATUS

| <u>Revision</u> | <u>SCR No.</u> | <u>Description</u>       | <u>Initial</u> | <u>Date</u> |
|-----------------|----------------|--------------------------|----------------|-------------|
| "B"             | 26379          | Revised in its Entirety  | D. Smith       | 12-18-98    |
| "C"             | 28982          | Revised Paragraph 2.7    | R. Roody       | 9-16-99     |
| "D"             | S0079          | Replaced template format | M.Lee          | 02-01-06    |

## **Amphenol TCS**

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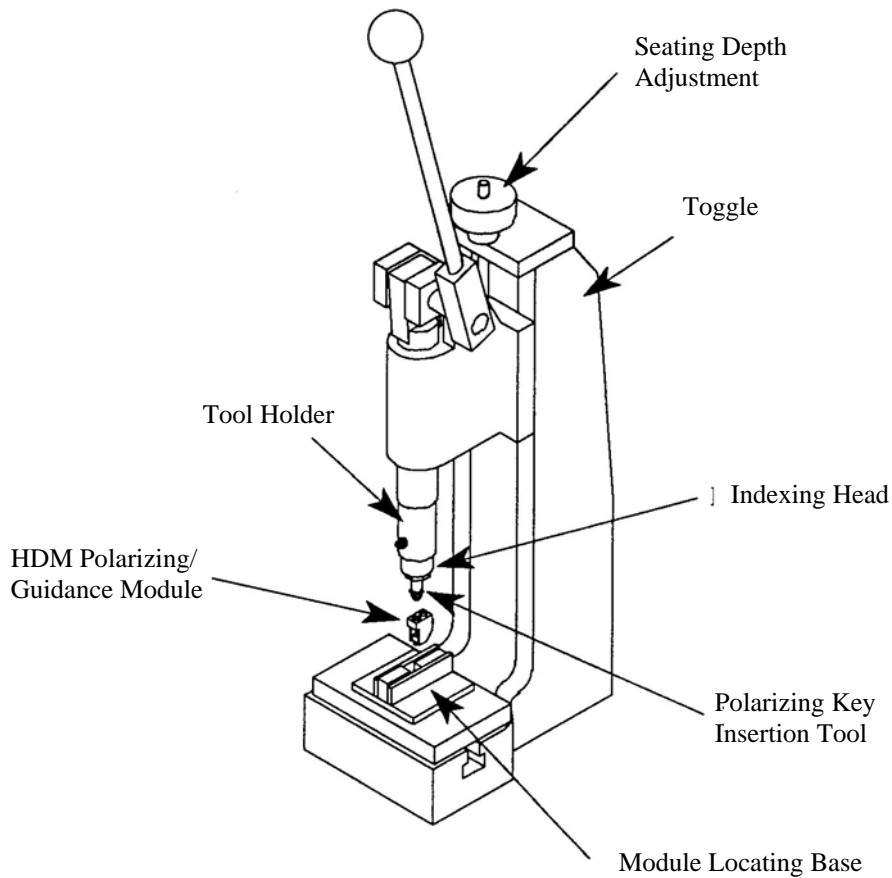


Figure 1

## 1.0 SCOPE

1.1 This technical bulletin covers Amphenol TCS HDM manual polarizing key insertion press, Part No. 602-0555-000. The press is used to install polarizing keys, Part No. 564-0307-000, into HDM polarizing/guidance modules, Part No. 438-0025-060.

## 2.0 PROCEDURE

2.1 This tool is intended to be used on loose piece modules only. Review Figure 1 to become familiar with the component descriptions that will be used later in this instruction sheet.

### 2.2 Indexing Polarizing Keys

2.2.1 The key orientation can be changed by grasping the indexing head and rotating it to the desired position. Each location is marked on the tool and will snap into location.

## 2.3 Key Insertion

- 2.3.1 Verify that the indexing head is in the proper location (A – H).
- 2.3.2 Place the polarizing key over the insertion tool. the key will be held in place by a spring loaded finger.
- 2.3.3 Place the module to be loaded into the module locating base. The key hole will be closest to you while the guidance hole will be away from you.
- 2.3.4 Pull the handle of the toggle press down completely. This will insert and seat the polarizing key.
- 2.3.5 Return the handle to the upright position.
- 2.3.6 Repeat Paragraphs 2.3.1 through 2.3.5 until all keys are loaded.

## 2.4 Seated Key Requirements

- 2.4.1 Verify that the key has been located in the required position (A – H).
- 2.4.2 Check the seating depth of the key (see Figure 2).

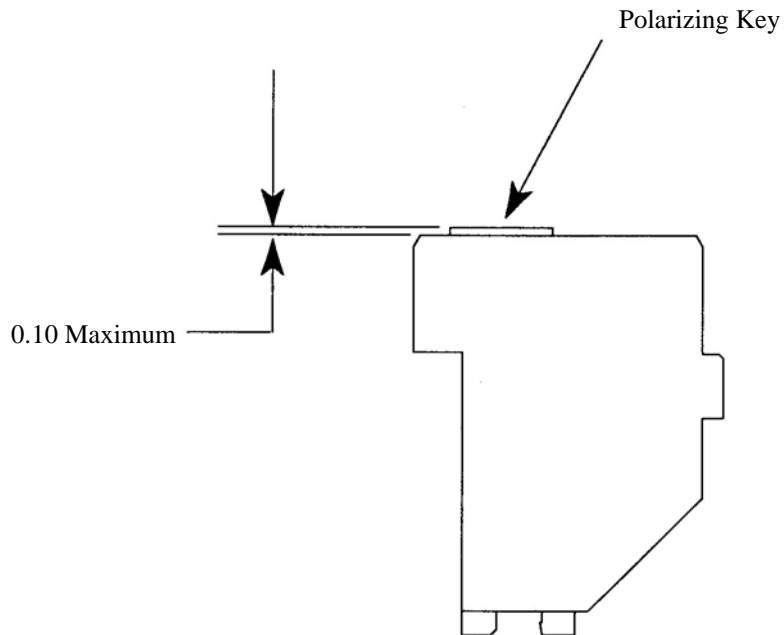


Figure 2

## 2.5 Quality

2.5.1 This tooling has been inspected before shipment. It is recommended that you unpack and inspect the tool immediately to ensure that it has not been damaged during shipping.

## 2.6 Related HDM Tooling

| Tool  | Part No.     | Bulletin |
|---|--------------|----------|
| Backplane Contact Knock-Out Tool                    | 600-1692-000 | TB-2007  |
| Backplane Single Contact Insertion Tool             | 600-1718-000 | TB-2011  |
| Backplane Power Module Removal Tool                 | 600-1693-000 | TB-2005  |
| Backplane Power Contact Removal Tool                | 600-1694-000 | TB-2006  |
| Backplane Insulator Removal Tool, 144 Positions     | 600-1697-000 | TB-2004  |
| Backplane Insulator Removal Tool, 72 Positions      | 600-1698-000 | TB-2004  |
| Backplane Polarizing and Guide Pin Assembly Press   | 602-0549-000 | TB-2002  |
| Backplane Signal Module Loading Head, 144 Positions | 694-0581-000 | TB-2001  |
| Backplane Signal Module Loading Head, 72 Positions  | 694-0655-000 | TB-2001  |
| Backplane Power Module Loading Head                 | 694-0586-000 | TB-2003  |
| Daughtercard Module Polarizing Key Removal Tool     | 602-0525-000 | TB-2008  |
| Daughtercard Module Polarizing Key Insertion Tool   | 602-0555-000 | TB-2009  |
| Daughtercard Module Removal Tool                    | 600-1701-000 | TB-2010  |

2.7 Customer Service and Technical Support for Amphenol TCS connectors is available from:

Amphenol TCS  
Attention: Connector Marketing Team  
44 Simon Street  
Nashua, NH 03060  
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