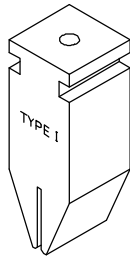
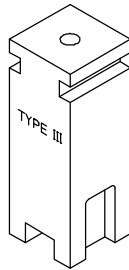


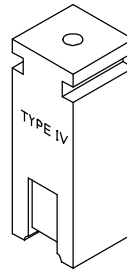
**Seating Tool**  
**543574-1**



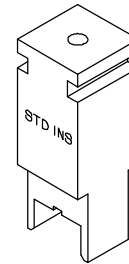
**Seating Tool**  
**543575-1**



**Seating Tool**  
**543576-1**



**Seating Tool**  
**543577-1**



SEATING TOOL	POWER DISTRIBUTION TAP	
	BASE PART NUMBER	TYPE
543574-1	216843, 216926	.250 Series, Type I
543575-1	213816, 216905, 216906, 216907	4-Position and 6-Position, Type III
543576-1	167892	8-Position, Type IV
543577-1	55556, 55557, 55673	10-Position, Standard Insulated

Figure 1

## 1. INTRODUCTION

Power Tap Seating Tools 543574-1, 543575-1, 543576-1, and 543577-1 are used in conjunction with Miniature Arbor Frame Assembly 91295-1 to seat the power distribution taps listed in Figure 1 onto a printed circuit (pc) board. Figure 1 provides a guide for tool-to-product cross-reference.

For information on the setup and operation of the arbor frame assembly, refer to Instruction Sheet 408-9817. For detailed information on the power distribution taps, refer to 408-3001.

### NOTE



All numerical values in this instruction sheet are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

## 2. DESCRIPTION

Each seating tool is a one-piece, steel configuration individually designed and marked for seating a specific type of power distribution tap. The seating tool, designed to be attached to the arbor frame, applies an even force over the length of the power tap and protects the power tap from damage during seating.

## 3. INSTALLATION

1. Secure the arbor frame assembly to a suitable workbench according to 408-9817.
2. Align the grooves in the seating tool with the arbor frame ram tooling adapter, as shown in Figure 2, and slide the seating tool onto the adapter.
3. Position the prepared pc board onto a pc board support fixture, then place the fixture onto the machined base of the arbor frame.

### NOTE



The pc board support fixture must be designed for specific needs. Refer to the recommendations in 408-6927.

## 4. SEATING PROCEDURE

### NOTE



If applicable, remove the cover, screw, and washer from the power distribution tap before starting seating procedure.

1. Partially insert the legs of the tap into the pc board.
2. Re-position the pc board support fixture so that the partially inserted tap is centered under the seating tool. Refer to Figure 2.

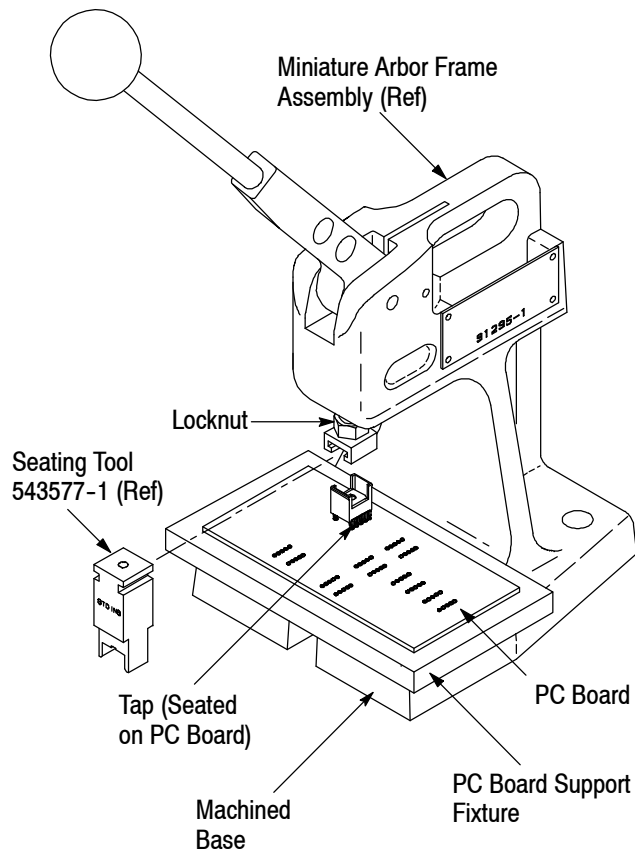


Figure 2

3. Using the arbor frame handle, lower the ram until the seating tool fits onto the tap. Continue lowering the ram until the tap is fully seated onto the pc board.
4. Holding the pc board in place, allow the ratchet to release and the ram to return to its original position.
5. Inspect the tap for proper seating according to Application Specification 114-11000 or .



*If the tap inspection does not meet the requirements or if the arbor frame ratchet does not release after the tap is fully seated, it may be necessary to adjust the shut height of the ram. To adjust the shut height, loosen the locknut (located above the ram tooling adapter, shown in Figure 2) and rotate the adapter clockwise to decrease the shut height or counterclockwise to increase the shut height. Tighten the locknut to secure the adjustment.*

### 5. SEATING TOOL INSPECTION

It is recommended that the seating tool be inspected and verified with the information provided in Figure 3 immediately upon arrival at your facility (and at regularly scheduled intervals) to ensure the seating tool has not been damaged during handling.

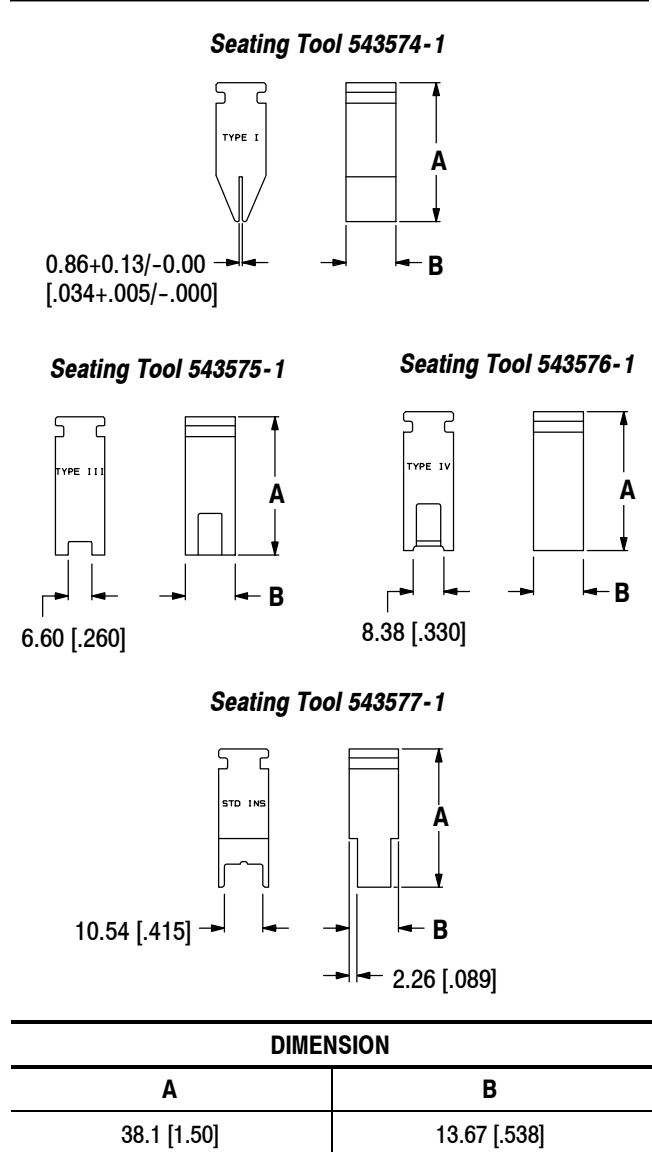


Figure 3

### 6. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Removed obsolete Seating Tool 543578-1
- Removed obsolete taps and modified Type in table of Figure 1

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