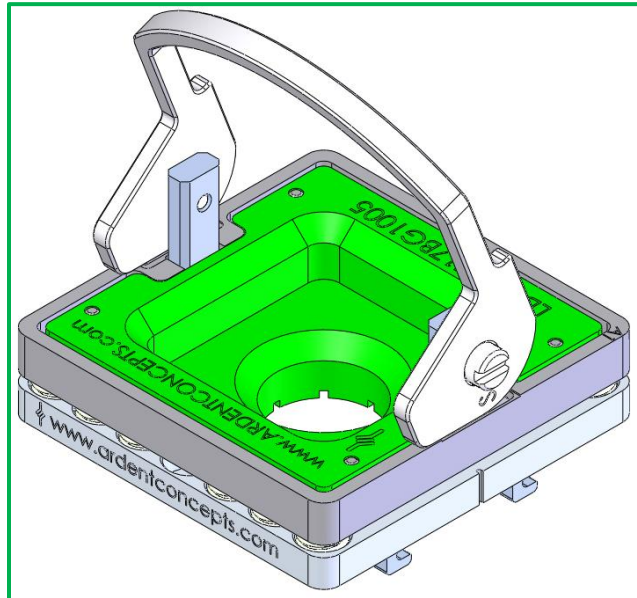




LEVER LID DIE SPRING FORCE ADJUSTMENT PROCEDURE



Document # AE-AN-SK-004

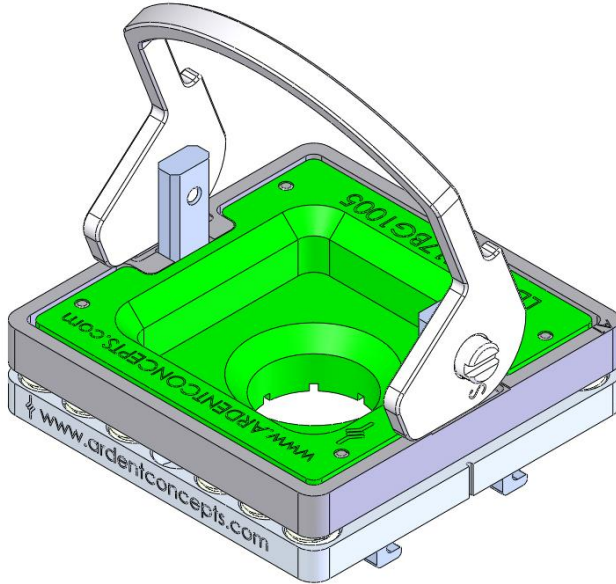
Lever Lid Die Spring Force Adjustment Procedure

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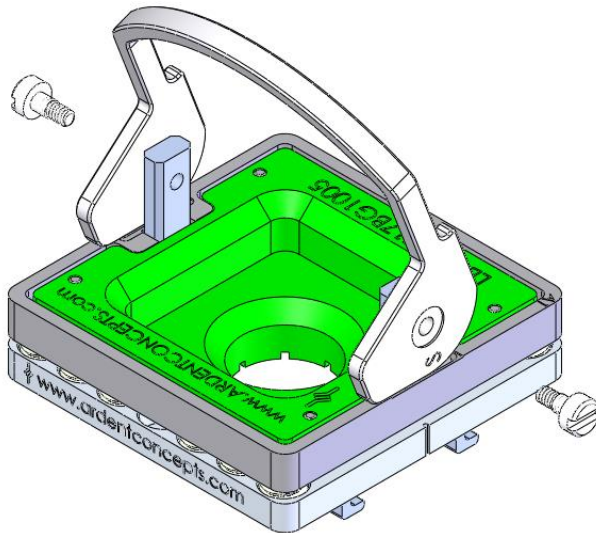
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This procedure will guide you through the steps necessary to disassemble the lid, remove springs, and reassembly.



Step 1

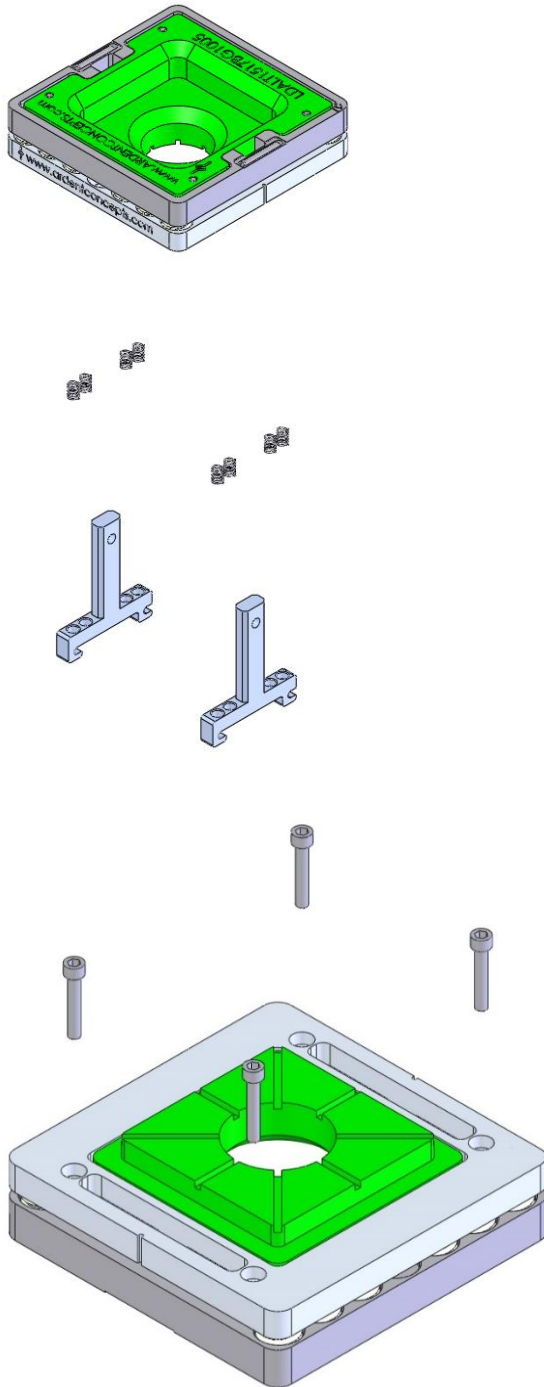
Place the lid on a flat, clean surface. Remove the two shoulder bolts that hold the lever together. Once this is done, the lever will slide up and off the assembly. Set the bolts and lever aside on a clean bench top.

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Step 2 is to remove the two anchors and the eight small return springs that sit between the anchors and the rest of the assembly.

The springs are 1/8" in diameter, so they are very easy to lose. Carefully set them aside on a clean bench top.

Contact ACI if you need replacements.

Step 3 is to remove the four #2-56 socket head cap screws that hold the assembly together.

This should be done a little at a time in a criss-cross pattern since the screws are under tension from the die spring force. Set the screws aside on a clean bench top.

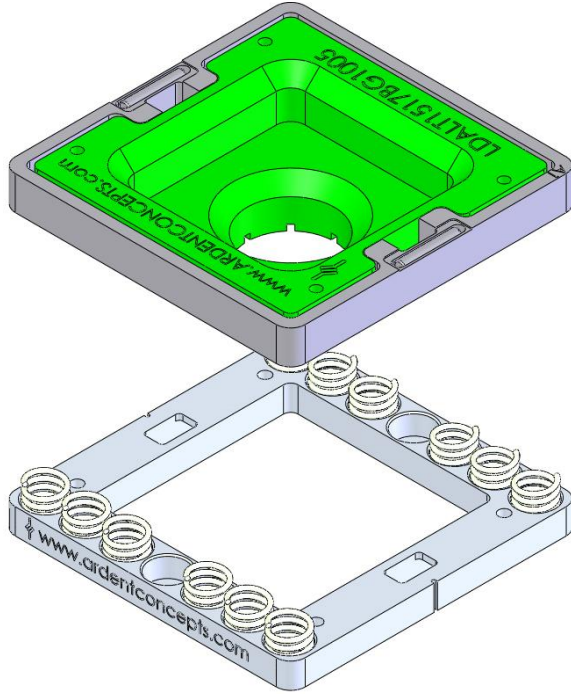
You will need a 5/64" Allen wrench for the socket heads.

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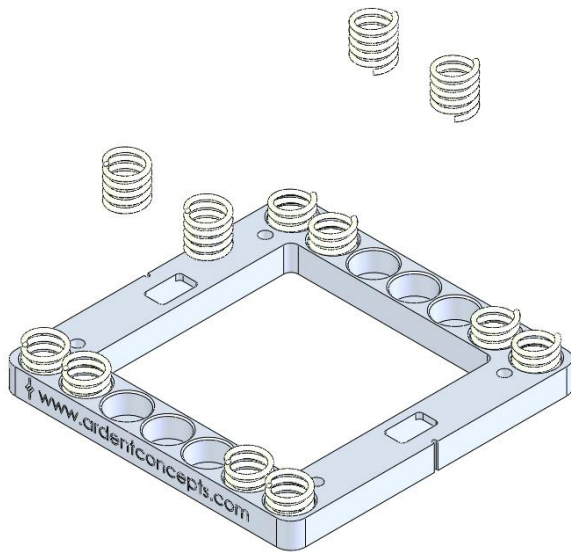
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Step 4 is to lift the pressure foot and lead backer off of the rest of the assembly.

You can now add or remove springs as needed.

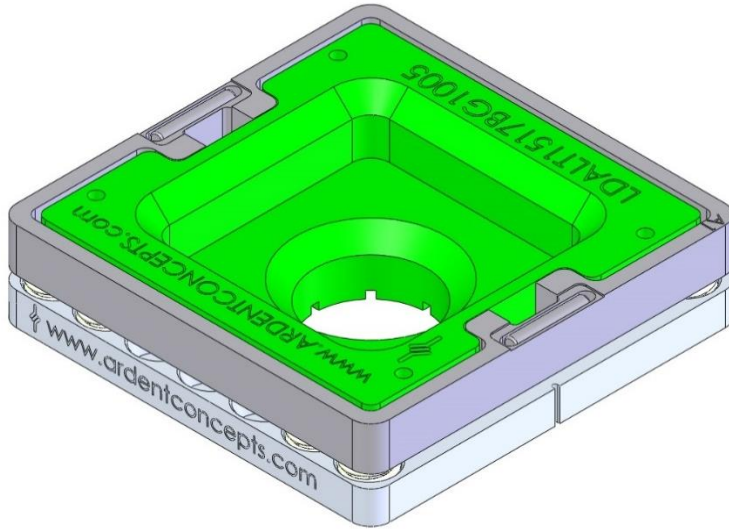


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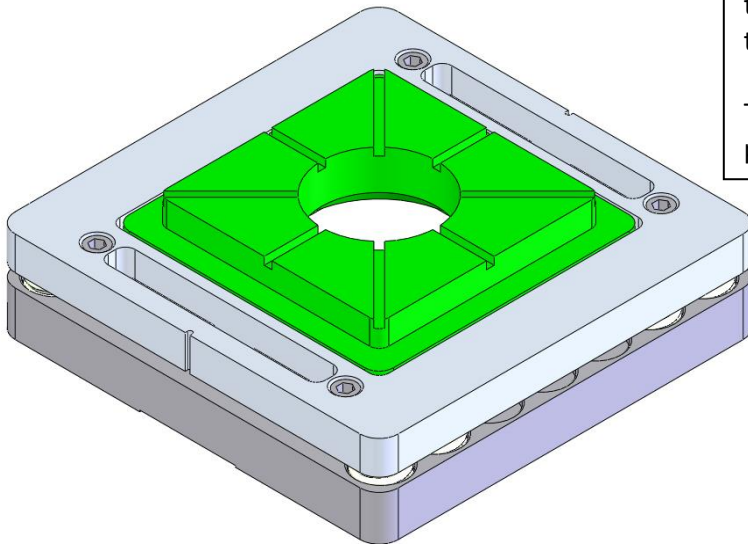
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Step 5 is to replace the pressure foot and lead backer and then to replace the four socket head screws.

The screws should be tightened a little at a time in a criss-cross pattern until all four of the screws bottom out.

The torque setting should be 4-5 inch-pounds.

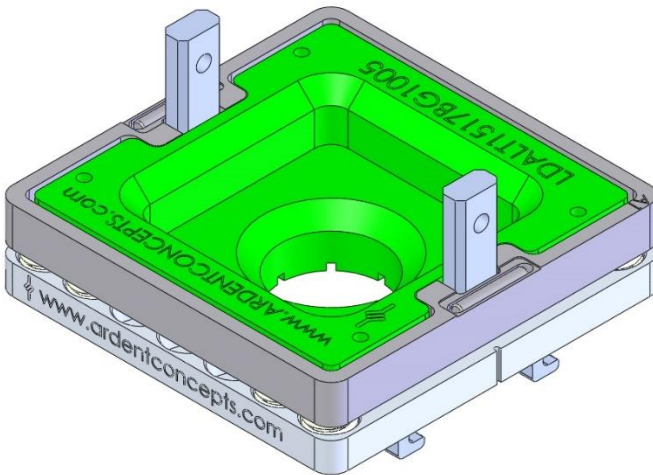


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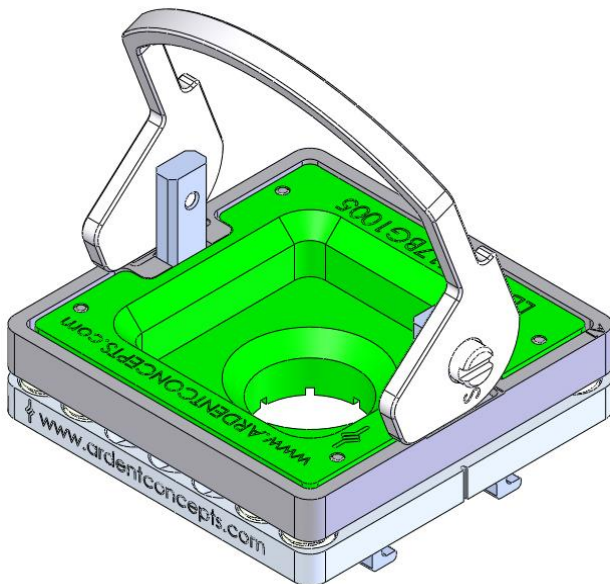
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Step 6 is to replace the anchors and their return springs.

If the springs have fallen out, it is easiest to use tweezers to reposition them in their holes on the anchors. Lubricant has been applied to the holes and that will help keep the springs in place.

Once all the springs are back in their holes, the anchors can be set standing up on the bench top, side by side. The lid assembly can then slide onto the anchors. The hooks on the anchors should be facing the same way.



Step 7 is to replace the lever and shoulder bolts.

Thread locker was used to keep the shoulder bolts tight. If the thread locker is no longer active, ACI can provide a fresh batch.

The shoulder bolts should be tightened until they bottom out (4-5 in-lbs).

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Who Is Ardent Concepts?

Ardent Concepts, Inc. is a leading designer and manufacturer of high performance multicoax and coaxial assemblies, connectors, and sockets used in the development of next generation semiconductors and electronics systems. Our core technology is the smallest, fastest, most electrically efficient compression mount connector technology worldwide. As data rate requirements increase and devices and systems shrink, Ardent's products deliver superior signal integrity in a dense footprint that can be reusable across programs to maximize cost savings.

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