

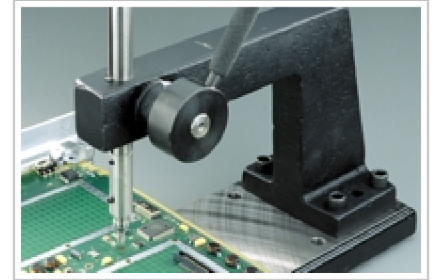
110-5202 Eyelet Press

Instruction: INS1075

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This rugged, heavy duty press precisely forms eyelets in circuit boards for repair or assembly. The unit has a 6.50" (16.50 cm) throat depth to accommodate 12" wide circuit boards.

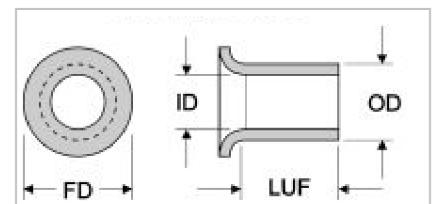
The heavy duty construction ensures eyelets are forming per IPC guidelines. Includes two #115-3123 Setting Tool, Small and two #115-3126 Setting Tool, Large to form and flat set a wide range of eyelet sizes.



The CircuitMedic Eyelet Press will deliver years of maintenance-free reliable production.

Specifications	
Throat Depth	6.50" (16.50 cm)
Minimum Throat Opening	1.00" (2.54 cm)
Tooling Shank Size	.375" (9.52 mm) Diameter
Weight	28 lbs. (13 kg.)

Eyelets are used to repair plated holes in circuit boards, and also to create a conductive path through circuit boards for various applications. All eyelets are manufactured from copper or brass, and have a bright tin plating.



See guides covering a variety of plated hole repair and rework procedures at www.circuitrework.com/guides/guides.html.

See the full list of available eyelets at www.circuitmedic.com/parts/eyelets.html.

Eyelet Selection Criteria	
ID - Inside Diameter	.003" - .020" greater than the component lead diameter.
OD - Outside Diameter	The clearance hole in the circuit board should be .001" - .005" greater than the outside diameter.
LUF - Length Under Flange	The length of the flange should be .020" - .035" greater than the thickness of the circuit board.
FD - Flange Diameter	The flange diameter should be small enough to prevent interference with adjacent pads or circuits.

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Eyelet Press Setup

1. Be sure the upper and lower Setting Tools are perfectly aligned. The tips should touch when the press is lowered. If the tips are not aligned, loosen the four mounting bolts and adjust as needed.

2. If needed, drill out the plated hole removing all the plating. The drilled hole should be .001" - .005" (.025 - .125 mm) larger than the eyelet outside diameter. Use caution when working on circuit board with inner layers.

3. Insert the proper Setting Tool into the Tool Holder installed in the base of the Eyelet Press. The small cone tip end of the Setting Tool should be facing up. Tighten the set screw to secure in position. (See Figure 1)

4. Insert the proper Setting Tool into the ram of the Eyelet Press. The larger cone end of the Setting Tool should be facing down. No tightening should be needed, springs inside the ram should hold the Setting Tool in position. (See Figure 1)

5. Insert the Eyelet into the hole in the circuit board. The flat flange of the Eyelet should be on the underside. This is needed to ensure you can observe the flaring process. If needed place a small piece of tape over the flange of the Eyelet to prevent it from falling out of the circuit board. Pierce a small hole in the tape to help center the tip of the lower Setting Tool.

6. Lower the ram of the Eyelet Press and flare the barrel of the Eyelet by applying moderate force using the Eyelet Press. (See Figure 2)

7. Change the upper Setting Tool so the small cone tip end of the Setting Tool is facing down. Apply firm even pressure to flatten the eyelet barrel. (See Figure 3)

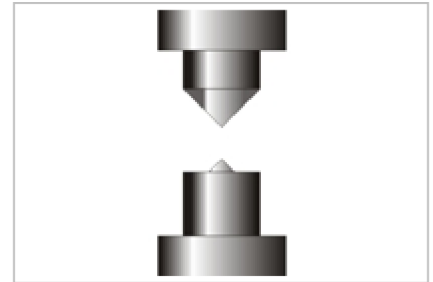


Figure 1: The small cone tip end of the lower Setting Tool faces up. The large cone end of the upper setting tool faces down.

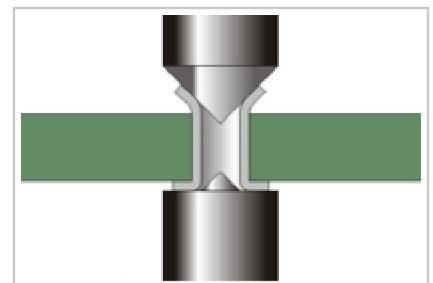


Figure 2: Flare the eyelet barrel using the flare end of the setting tool.

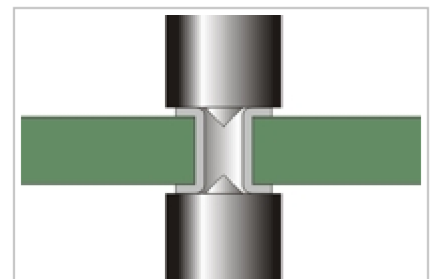


Figure 3: Flatten the eyelet barrel using the flat end of the setting tool.