.062" PITCH COMPLIANT PIN

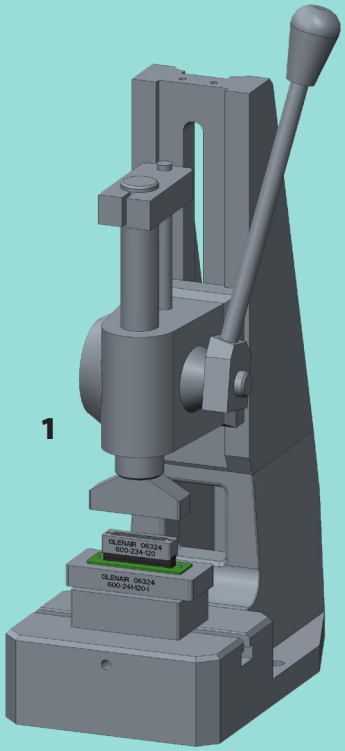
HD Stacker™

Connector-to-board installation guide

INSTALLATION OVERVIEW:

HD Stacker board mounting equipment provides reliable, trouble-free installation of the complete connector series (top, middle, and bottom) to customer printed circuit boards. Customers may choose to purchase tooling directly from Glenair or fabricate per available equipment drawings (consult factory). In either event, assembly tooling must conform to the PCB layouts provided on page 3 of this catalog.

1



EQUIPMENT:

1. Manual Arbor Press or Pneumatic Press

Press capable of 22.5 lbs. per contact. Pneumatic equipment provides superior monitoring and application of force during installation. Glenair can recommend the Pneumatic Press with Force / Stroke Monitoring available from Schmidt®.

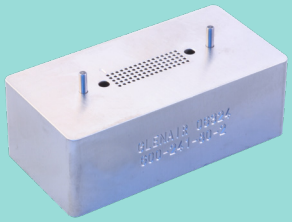
Manual Arbor Press equipment is also suitable, but relies more on operator experience and visual verification of connector seating. Glenair can recommend the 3-ton Dayton Arbor Press available from Grainger.

2

2. Mounting Head with Contact Alignment Pins:

The mounting head protects the connector during installation by evenly distributing press forces throughout the connector body. Contact alignment pins prevent socket contact misalignment within the connector body during installation.

3



3. Support Plate with Board Alignment Pins:

The support plate protects the printed circuit board during installation by evenly distributing press forces to each plated through-hole. The support plate includes clearance holes for the connector contacts and guide pins. Board alignment pins prevent lateral movement between the board and support plate during connector installation.

4

4. Contact Alignment Comb

For connectors with termination length larger than .500", pin organizer or contact alignment tools are recommended to ensure pin alignment during insertion into the board.

Dimensions in Inches (millimeters) are subject to change without notice.

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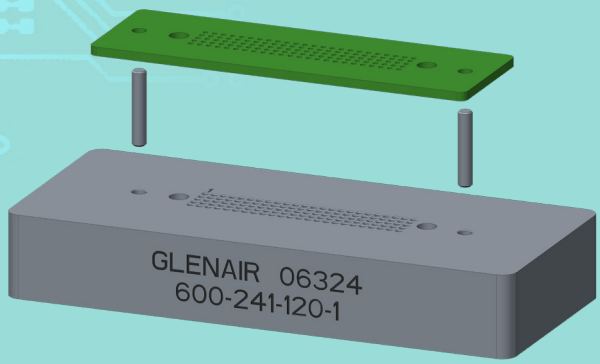
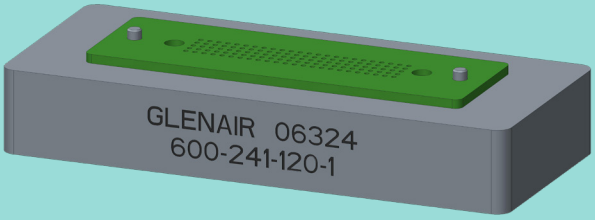
PC BOARD PREPARATION

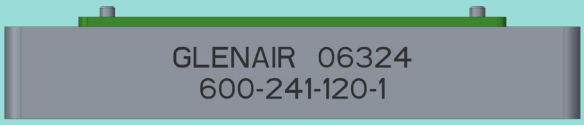
1. Install the loose guide pins into the support plate.



2. Place the board on the support plate and align board clearance holes with the guide pins.

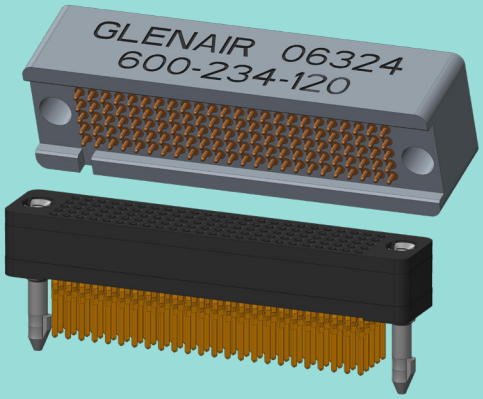


3. Verify the board lies flat and level against the plate.



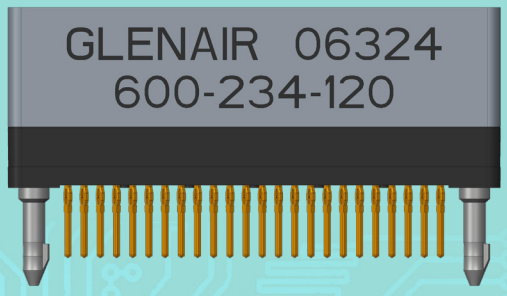
CONNECTOR PREPARATION

1. Note the pattern of contact alignment pins on the mounting head exactly matches the connector contact hole pattern.



2. Mate the mounting head alignment pins to the connector socket cavities.

3. Verify the mounting head is seated against the top of the connector.



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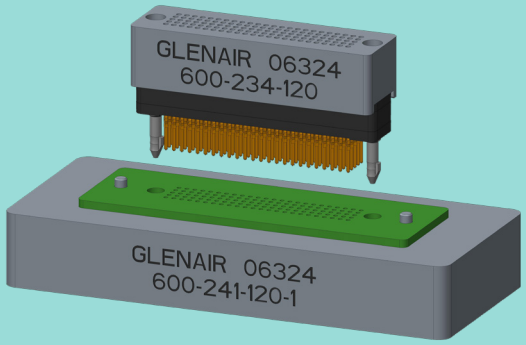
CONNECTOR INSTALLATION TO THE BOARD

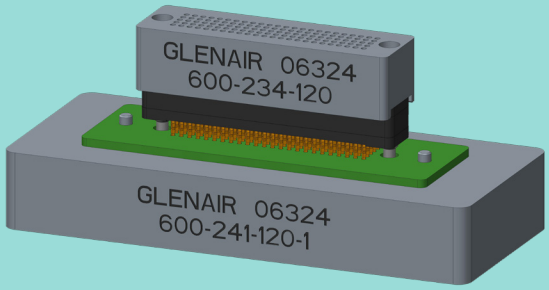
1. Feed the contacts into the board and the mounting plate.

   Again, for connectors with termination length larger than .500", pin organizer tools should be considered to assist the operator in organizing pins before insertion into the board.

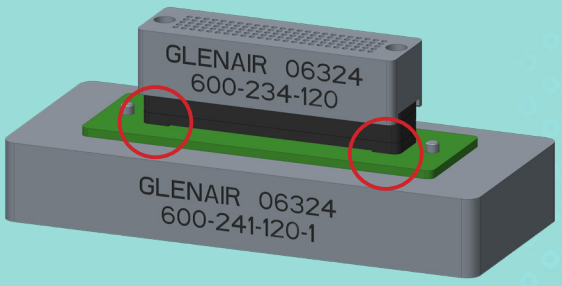


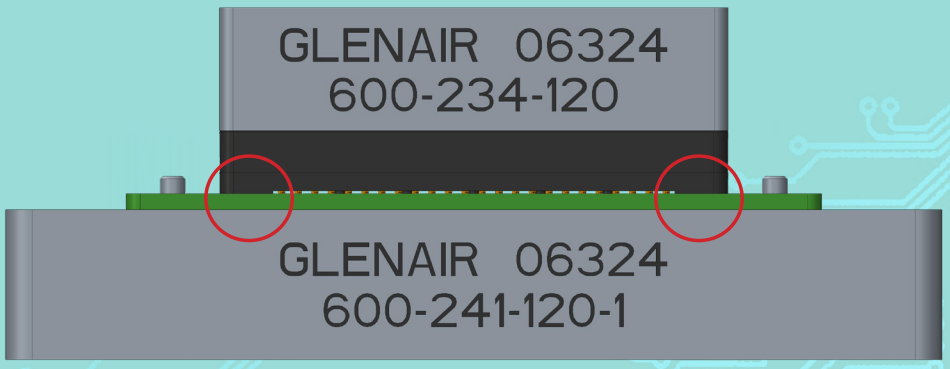
2. Verify the mounting head is seated against the top of the connector.

   Verify the board lies level and flat against the plate and is prevented from sliding by the guide pins.



3. The connector is ready for press-fit mounting onto the board. Carefully operate the manual or pneumatic press to apply only enough force to seat the connector tight against the surface of the board. When using a manual press, visually confirm that the standoff region surrounding the connector guide pins (circled on the diagrams at right and below) is seated directly onto the surface of the board.





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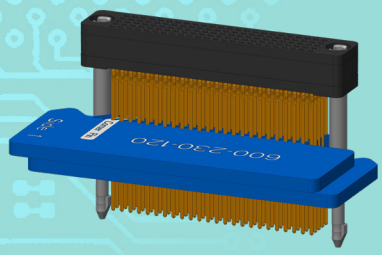


INSTALLATION WITH CONTACT ALIGNMENT COMBS

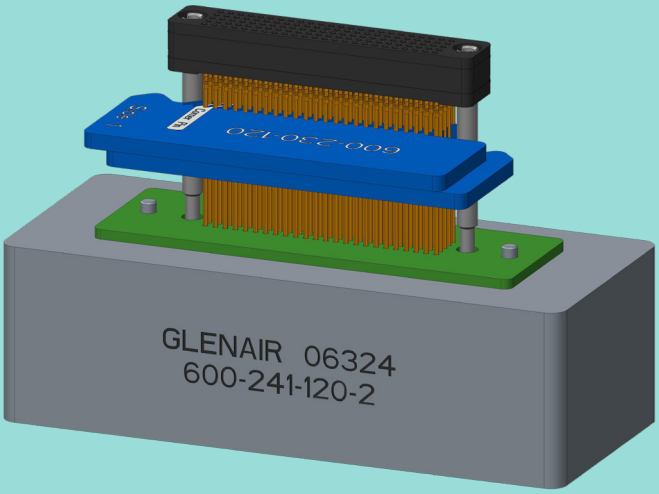
HD Stacker connectors with longer pins may require alignment with the addition of pin organizer combs.

CONNECTOR PREPARATION

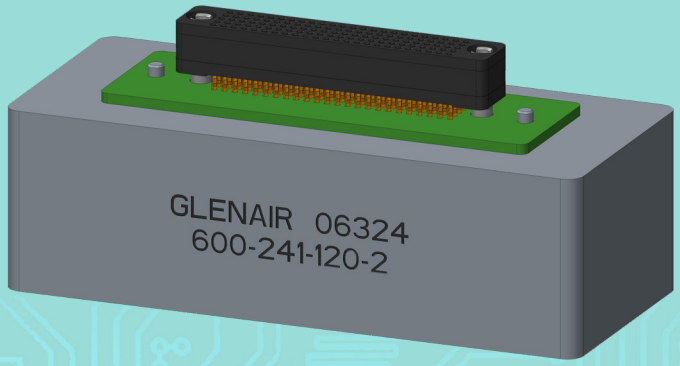
1. Insert the first comb. For optimal pin engagement, leave the two circled cavities (shown in step 1 and 2 diagrams) empty.

2. Insert Second Comb. For optimal pin engagement, leave the two circled cavities empty.

3. Feed the contacts into the board and the mounting plate.



4. Remove the combs and slide the connector pins into the mounting plate.



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