

## CONNECTOR INSTALLATION

### TOOLS:

<u>Tool Description</u>	<u>P/N</u>
Jig	N/A
Clipper	0156-1700
Tweezers	0153-1701
Spacers (2)	5103-0900
Clamps (2)	N/A
Double Sided Tape	5107-0900
Connector	5103-1300
Board	As required

### PROCEDURE:

1. Cut tape and install on layer 1 side of board. (Do not cover the two mounting pad holes.)
2. Place board with alignment pins and spacers on jig. Layer 1 side up.
3. Remove covering on tape.
4. Lightly place connector over alignment pins and put on pressure bar with wing nuts.
5. Tighten wing nuts until connector lays flush on board. (Excessive pressure can cause damage.) Allow it to sit 2 minutes on jig to set tape and connector.
6. Check so all connector pins line up to holes on board. If not, using a tweezer move them to match up. Solder a few pins to hold in place.
7. Remove wing nuts, pressure bar and alignment pins from jig.
8. Using a tweezer, remove spacers from the connector.
9. Place clamps on to secure connector in place.
10. Solder connector. Flux front and back of board. Solder from back and touch up front so good joints are on both layers. Allow board to sit 15 minutes before washing.
11. Check for proper alignment. If the connector appears off center, set the board aside.
12. Repeat above procedures for each connector installation.