

INSTALLATION OF BERG PINS

STEP 1. MAKE SURE THAT ALL EXCESS SOLDER IS REMOVED FROM THE BARREL. NEXT, REMOVE ALL FLUX FROM THE AREA, ESPECIALLY IN THE BARREL, THIS INSURES THAT DURING CONNECTOR INSERTION FLUX WILL NOT GET IN OR ON THE PIN OR CAGE SECTIONS OF THE CONNECTOR CAUSING WICKING OF THE SOLDER INTO THESE AREAS.

STEP 2. FOR PASS-THRU AND TERMINATOR TYPE CONNECTORS, INSERT THE CONNECTOR INTO THE INSERTION TOOL. FROM LAYER ONE SIDE OF THE BOARD, MAKING SURE THAT THE CONNECTOR SPINE IS IN THE SAME RELATIVE POSITION AS THE ONE YOU REMOVED, INSERT THE CONNECTOR BY PRESSING DOWN FIRMLY UNTIL THE BOARD STOP ON THE CONNECTOR IS FLUSH AGAINST THE BARREL PAD.

FOR STARTER TYPE CONNECTORS, FROM SIDE ONE, USE A TWEEZERS TO START THE INSERTION. FINISH SEATING THE CONNECTOR USING THE FLAT SURFACE OF A SMALL PUNCH OR A LARGE PAPER CLIP BY PUSHING ON THE COMPLIANCE SECTION UNTIL IT IS FLUSH WITH THE BARREL PAD.

*** NOTE ***

IF YOU ARE HAVING DIFFICULTY INSERTING ANY CONNECTOR TYPE, IT SHOULD BE RECOGNIZED THAT UPON MANUFACTURE THE BARREL IS ONLY .001 INCHES LARGER IN DIAMETER THAN THE COMPLIANCE SECTION OF THE CONNECTOR. THEREFORE, USING 600 DEGREE SOLDER IRON, FIRST TRY TO REMOVE EXCESS SOLDER BY APPLYING FLUX, FILLING BARREL WITH SOLDER AND THEN REMOVING SOLDER FROM BARREL AGAIN. THIS PROCEDURE WILL USUALLY FIX THE PROBLEM. IF STILL HAVING DIFFICULTIES, TRY ROTATING THE CONNECTOR 45 DEGREES INSIDE THE BARREL BEFORE PRESSING DOWN.

STEP 3. WITH THE CONNECTOR FULLY SEATED AND THE AREA FREE FROM FLUX, IT IS TIME TO APPLY A VERY SMALL AMOUNT OF FLUX, PREFERABLY OF THE GOOIER VARIETY, TO THE BARREL/COMPLIANCE SECTION JOINT ON LAYER 6. NOW, USING THE 600 DEGREE IRON, FLOW JUST ENOUGH SOLDER TO MAKE A SOLID CONNECTION BETWEEN THE BARREL AND OUTSIDE OF THE COMPLIANCE SECTION. THE CENTER OF THE COMPLIANCE SECTION SHOULD REMAIN EMPTY AND THERE SHOULD BE NO SOLDER ON THE PIN OR IN THE CAGE OF THE CONNECTOR. IF THERE IS SOLDER WHERE IT SHOULDN'T BE, REPLACE THE CONNECTOR!