

## INSTALLATION OF PRINTED CIRCUIT (PC) CONNECTORS WITH CONTACT TAIL ALIGNMENT COMB

1. Remove split stem fasteners which hold alignment comb in position on connector (Ref. Figure 1) and manually maintain comb position until connector contact tails protrude through the printed circuit board holes. The alignment comb will assure proper contact alignment to printed circuit board during installation.
2. After the PC connector has been positioned onto the printed circuit board, the contact alignment comb is removed from the connector. (Ref. Figure 2)
3. Locking bushing accessory, 10-411196-4 (two per connector), may be inserted into any PC connector body from the back into the large mounting holes at each end. (Ref. Figure 3) The 0.126 inch diameter cross hole in the locking bushing must be aligned with the 0.126 inch diameter cross hole in the connector body. These holes accept a 4-40 UNC-2A screw, for mounting the connector to the printed circuit board. The screw should be used with a suitable washer under the head and a suitable washer and nut for fastening. The front of the locking bushing has a 4-40 UNC-2B thread which will mate with the locking screw accessory of an I/O connector.
4. The mounting surface to which the connector is applied should not extend forward of the shoulder of the PC connector. See Figure 4.

### NOTE

- If the mounting surface does extend beyond the shoulder, a shim (minimum 0.005 inch thick) must be inserted between the connector body and the mounting surface. (Ref. Figure 5)
5. The PC connector mounting screws should be loosely attached (finger tight only) to the printed wiring board prior to any soldering of contacts.
  6. Fixturing of the PC connector and mounting surface may be desirable to assure straightness during and after soldering. Complete all solder connections.
  7. Properly torque mounting screws.

L-1231

April 1991

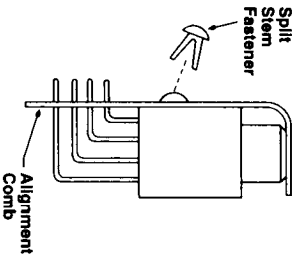


Figure 1

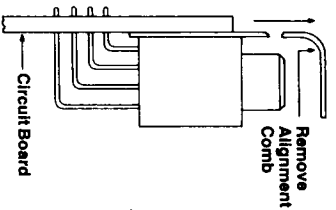


Figure 2

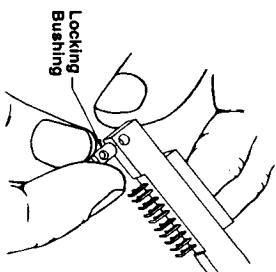


Figure 3

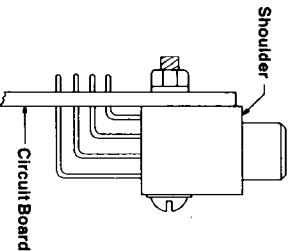


Figure 4

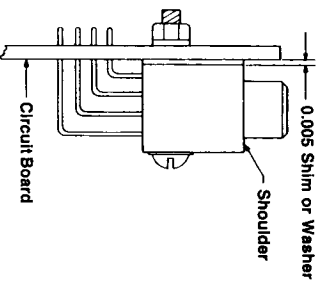
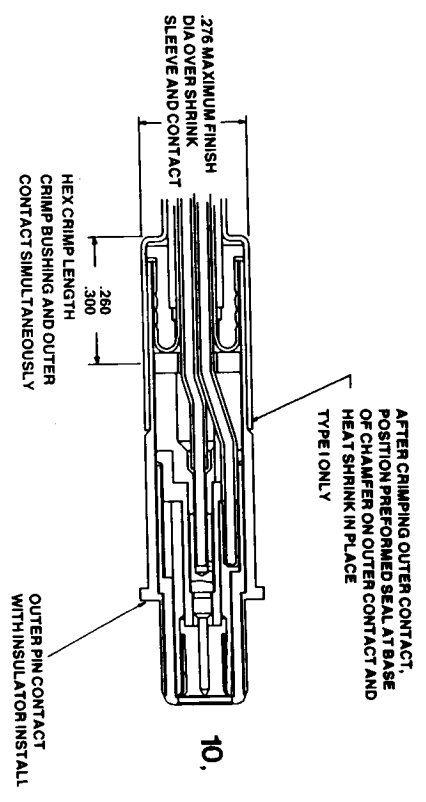
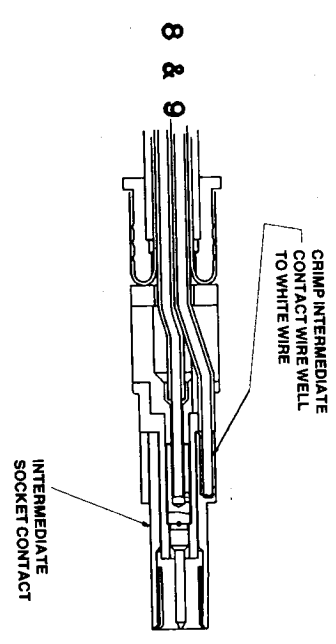
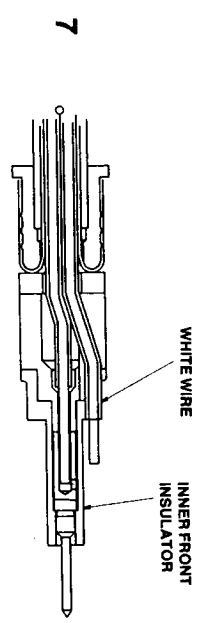
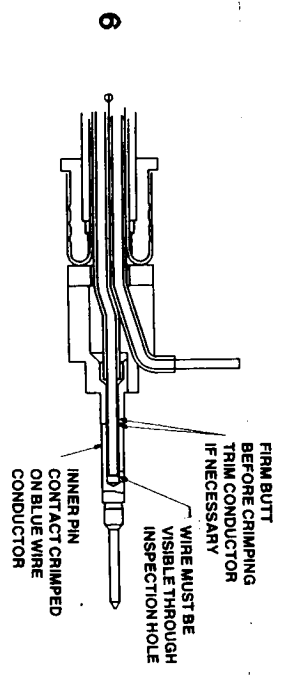


Figure 5

# Amphenol

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EQUIVALENT APPLICATION TOOLS		
DIE SET	POSITIONER	CONTACT REMOVAL
M22520/5-200 OR BENDIX® 11-12101 OR DANIELS Y631	M22520/2-37 OR BENDIX® 11-12102 OR DANIELS K709	DANIELS DRK 264-8