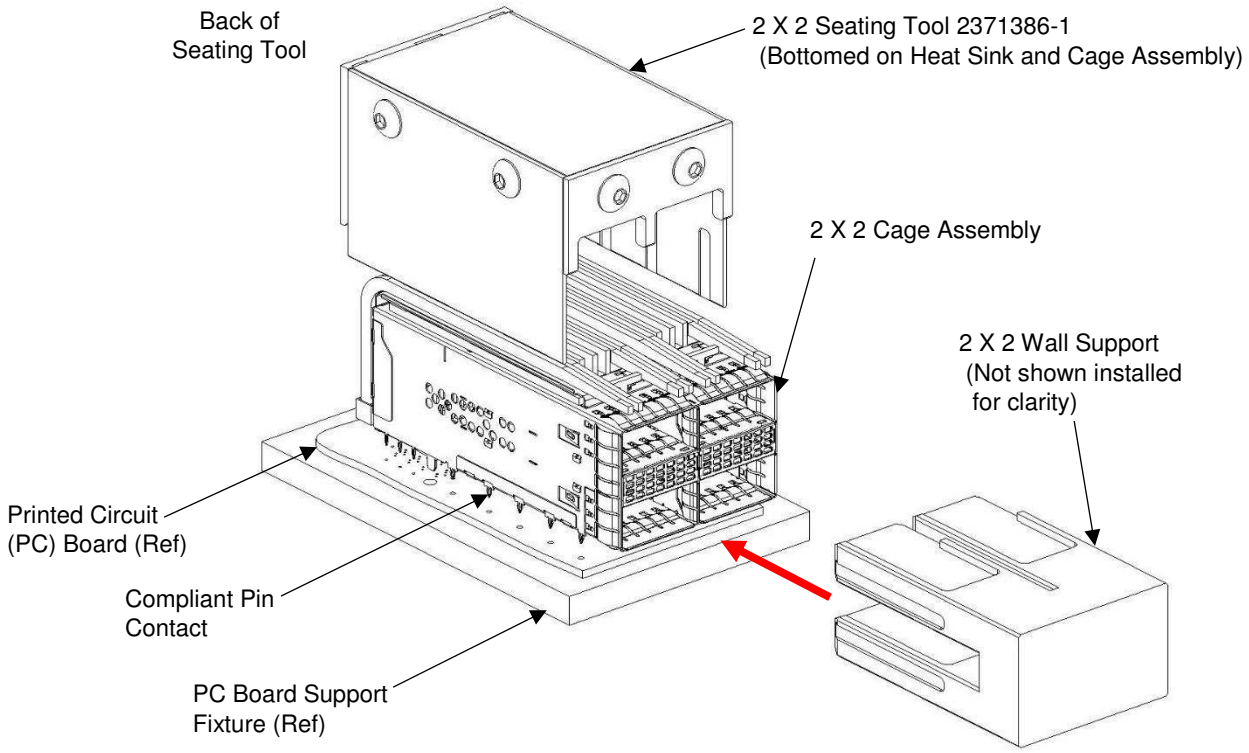
ORIGINAL INSTRUCTIONS

Stacked Quad Small Form-Factor Connector and Cage Assembly Seating Tool Kit: PN 2371386- [1]



Seating Tool Kit PN	Cage Assembly Configuration	Cage Assembly PN	Application Specification
2371386-1	2 X 2	2-2299870-8	114-13120

Figure 1

1. INTRODUCTION

zQSFP+ connector and cage assembly seating tool listed in Figure 1 is used to seat the connector and cage assembly described in Figure 1 onto the pc board. The cage assembly contains compliant pin contacts to allow solderless pc board installation.

NOTE
All dimensions on this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

NOTE
Read these instructions thoroughly before using the Seating Tool kit.

2. DESCRIPTION

Each Seating Tool kit consists of a seating tool assembly and a wall support.

NOTE
The seating tool and wall support can be purchased separately.

The wall support fits into the port of the cage assembly.

The top of the seating tool provides a surface to accept the force applied by the application tool to seat the connector onto the pc board. During seating, the back and sides of the seating tool protect the cage assembly from damage; the wall support provides rigidity to the port(s) of the cage assembly.

3. REQUIREMENTS

3.1. PC Board Support Fixture (Customer Supplied)

A pc board support fixture must be used under the pc board to protect the pc board, connector and cage assembly from damage. The support fixture must be designed for the specific application; using the following recommendations. The pc board support fixture:

- Should be at least 25.4 mm [1 in.] longer and wider than the pc board
- Should have flat surfaces with holes or a channel large enough and deep enough to receive any protruding components of the product(s).

3.2. APPLICATION TOOL

Power for the Seating Tool kit must be provided by an application tool (with a ram) capable of supplying a downward force greater than that specified in the 108 Series Product Spec or 114 Series Application spec.

NOTE
For information on the application tool(s) available, contact PRODUCT INFORMATION at the phone number on the bottom of page 1.

CAUTION
Over-driving of the connector will deform parts critical to the quality of the connection.

4. SETUP

1. When setting up equipment to seat the cage assembly, pay attention to the following:

- The seating tool must be matched to the cage assembly.
- Light pipes MUST NOT be assembled onto the cage assembly.

CAUTION
If the seating tool and connector are mismatched or are improperly aligned, damage could occur to the tooling, connector, or both.

- The wall support must be properly installed (if applicable), and the seating tool, cage assembly, and application tool ram must be properly aligned before cycling the application tool.

NOTE
Reference the applicable 114 Series Application Specification for seating requirements.

5. SEATING

1. Place the pc board on the support fixture.
2. Slide the wall support into the port of the cage assembly until the wall support is secure.
3. Place the cage assembly on the pc board so the contacts and alignment posts are aligned and started into the matching holes in the pc board.

4. Orient the seating tool over the cage assembly so the back of the tool is aligned with the back of the cage assembly. Lower the seating tool onto the cage assembly (ensuring the cutouts slide over the protruding components of the cage assembly) until the seating tool bottoms on the top of the cage assembly.
5. Center the seating tool (with the cage assembly) under the ram of the application tool. Slowly lower the ram until it just meets the seating tool. Verify alignment of pc board support fixture, pc board, cage assembly, and seating tool.

CAUTION
Damage to the pc board, seating tool, or cage assembly can occur if the seating tool is not properly seated on the cage assembly before cycling the application tool.

6. Cycle the application tool to seat the cage assembly onto the pc board. Retract the ram and carefully remove the seating tool by pulling it straight up from the cage.
7. Remove the wall support by pulling it straight out of the cage assembly.
8. Check the cage assembly for proper seating in accordance with the product specification

NOTE
For detailed application requirements of the cage, refer to the 114 Series Application Specification per Figure 1.

6. MAINTENANCE AND INSPECTION

The Seating Tool kit is assembled and inspected before shipment. TE Connectivity (TE) recommends that the kit be inspected immediately upon arrival at the facility of use to ensure that it has not been damaged during shipment.

6.1. Daily Maintenance

It is recommended that each operator be made aware of, and responsible for, the following steps of daily maintenance:

- Remove dust, moisture, and contaminants with a clean, soft brush or a lint-free cloth. DO NOT use objects that could damage the Seating Tool Kit components.
- When the Seating Tool and Wall Support are not in use, store in a clean, dry area.

6.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to personnel responsible for the tool. Inspection frequency should be based on amount of use, working conditions, operator training and skill, and established standards.

7. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in the product drawing. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Parts other than those listed should be replaced by TE Connectivity to ensure quality and reliability. Order replacement parts through your TE representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
TE CONNECTIVITY CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

8. REVISION SUMMARY

- Initial release of document.