

**0.64 SERIES I/O CONNECTORS(SMD-Top Entry Type)**

**1. PART NAME AND PART NUMBER**

1.1. Part Name and Part Number

TE Part Number*	Part Name
1939403	0.64 series 8Pos. Cap Housing Assembly SMD-TOP ENTRY TYPE (Male Connector)
2174290	0.64 series 8Pos. Cap Housing Assembly SMD-TOP ENTRY TYPE Keying(Male Connector)
1717396	0.64 series 16Pos. Cap Housing Assembly SMD-TOP ENTRY TYPE (Male Connector)
1554857	0.64 series 16Pos. Cap Housing Assembly SMD-TOP ENTRY TYPE (Male Connector)
1717394	0.64 series 24Pos. Cap Housing Assembly SMD-TOP ENTRY TYPE (Male Connector)
1747642	0.64 series 40Pos. Cap Housing Assembly SMD-TOP ENTRY TYPE (Male Connector)

\*Note : Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.

1.2. Components View

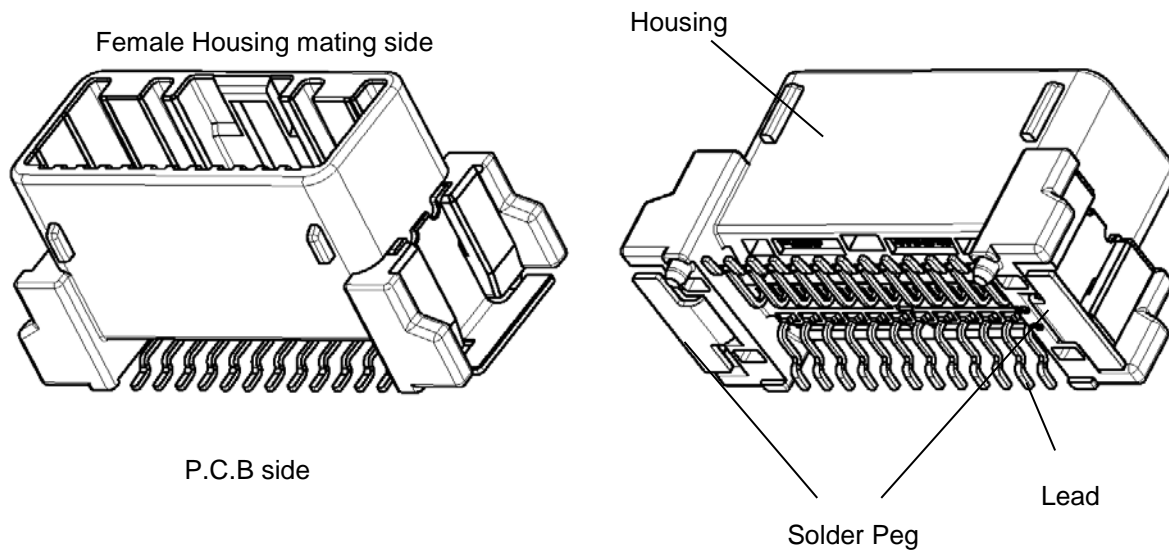
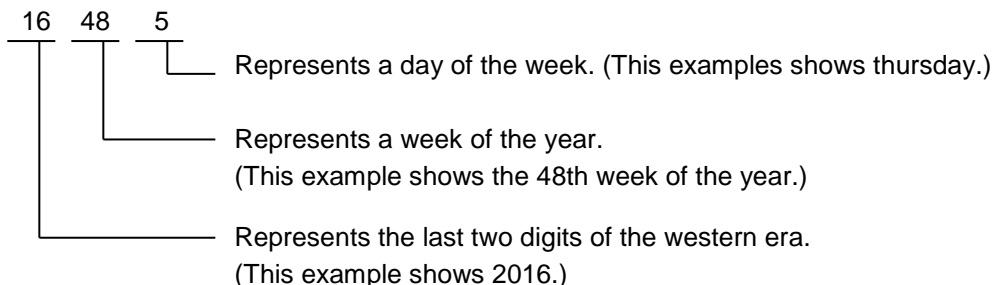


Fig.1

## 2. CUSTOMER RECEIVING INSPECTION

### 2.1. Reshipment Inspection by TYCO Electronics Japan G.K.

All the reshipment inspection by TYCO Electronics Japan G.K. are carried put for each shipment lot based on the quality control rules and applicable standards by means of the statistical control method. As a general rule, the manufacturing date is shown on each of the comparisons with the inspection records, manufacturing records, and adjustment records for the machines and measurement instruments. Note that the manufacturing date is shown using a date code specified below.



### 2.2. Customer’s Receiving Inspection:

Although, the products are thoroughly inspected before delivery, it is recommended that the customer be attentive to confirm the status of products, to check out if the products incurred any damage during transit.

Item	Check Points	Measuring Apparatus
Appearance Inspection	(1)Burs, Discoloration & Deformation	Visual
	(2)Cracks, Breakage & Chipping off	
Functional Inspection	(1)Mating Check to see if the connector mate and unmate smoothly with suitable housing.	Tactual

The product housings submitted to inspection, are classified by manufacturing date codes and put under the inspection in accordance with the inspection level II of MIL-STD –105 at acceptable quality level of 4.0%, visually and functionally to the randomly selected five pieced out of the lot.

Acceptable of the products is verified by proving the products meeting the specified requirements.

## 3. STORAGE AND CARRYING

- (1) Avoid storing the contact reel in a moist or dusty place. Stock the reel in a comparatively dry and clean place (5~35°C, 45~85%RH) away from direct sunlight.
- (2) Please do not apply load to the packing tube. The lead solder peg it becomes the cause becoming deformed.
- (3) Avoid leaving or carrying the contact reel in an open area without wrapping it in proper material.
- (4) Do not drop or shock the housing when carrying it.

#### 4. INSTALLATION OF MALE CONNECTOR TO P.C.B.

4.1. Check the following item before installation.

(1) Soldering Process

Reflow soldering

(2) Recommendation attachment P.C.B. dimension.

Refer to the drawing of an appropriate product.

(3) P.C.B.

In the case of curvature large to P.C.B, soldering may become poor.

Be careful of reflow condition and material of P.C.B.

(4) Solder paste thickness

0.15mm Min. In the case of less than 0.15mm, soldering may become poor.

4.2. Be careful of the following points in the case of work.

(1) The extraction process from packing tube

Be careful of deformation of lead, solder-peg. Please discard, When a form changes.

(2) P.C.B. arrangement process

Please arrange so that the boss for positioning goes into the hole for bosses of P.C.B.

In case you separate a connector from mount, be careful for lead solder-peg deformation by shock.

(3) Reflow soldering process

Be careful of discoloration of a connector, deformation, etc by heat.

If the temperature of housing is heated at 260°C Min, housing has the fusion possibility.

Reflow is restricted at one time.

<Reference conditions>

1. 『Sn-Pb Solder Paste』

Pre-Heat : 140~180°C 40~100sec

Soldering : 200°C 50sec Max.

Peak Temperature: 230°C 5sec

Solder: Sn-Pb Solder Paste

2. 『Sn-Ag-Cu Solder Paste』

Pre-Heat : 170~190°C 110sec

Soldering : 200°C 70sec Max.

Peak Temperature: 245°C

Solder: Sn-Ag-Cu Solder Paste

(4) After reflow

Check that there are not discoloration of a connector, deformation, etc.

Please check being soldered of all leads and pegs.

(5) Others

Please be careful of deformation and damage of lead (matting side, P.C.B side)

and solder-peg housing. and Mixing of a substance, adhesion in mating points.

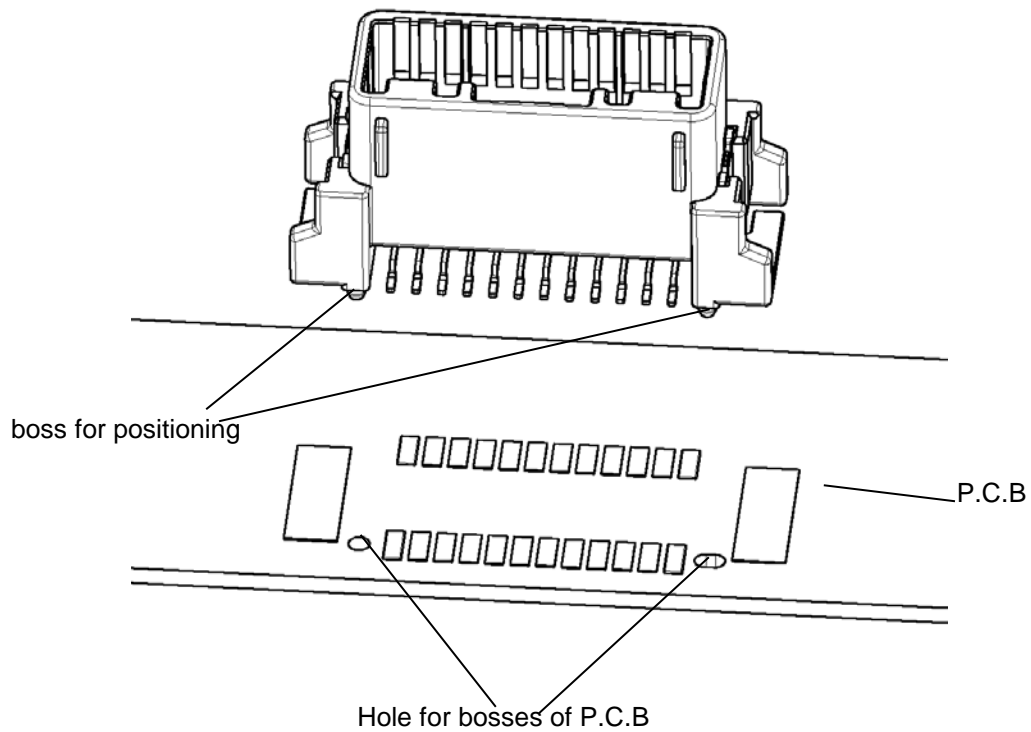


Fig.2

## 5. CRIMPING OPERATION

### 5.1. Female Housing

TE Part Number*	Part Name
1717103	0.64IIIseries 8Pos. Plug Assembly (Female Housing)
1376352	0.64 series 8Pos. Plug Assembly (Female Housing)
1473802	0.64 series 8Pos. Plug Assembly IDC (Female Housing)
1981471	0.64IIIseries 8Pos. Plug Assembly Keying (Female Housing)
1717109	0.64IIIseries 16Pos. Plug Assembly (Female Housing)
1318386	0.64 series 16Pos. Plug Assembly (Female Housing)
1318692	0.64 series 16Pos. Plug Assembly IDC (Female Housing)
1717112	0.64IIIseries 24Pos. Plug Assembly (Female Housing)
1318917	0.64 series 24Pos. Plug Assembly (Female Housing)
1473803	0.64 series 24Pos. Plug Assembly IDC (Female Housing)
1674312	0.64IIIseries 40Pos. Plug Assembly (Female Housing)
1318389	0.64 series 40Pos. Plug Assembly (Female Housing)
1318693	0.64 series 40Pos. Plug Assembly IDC (Female Housing)

\*Note : Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.  
 Instruction manual NO.411-78080 reference concerning handling the female housing.

### 5.2. Mating of Connector

(1)Check to make sure that the contact is inserted into the housing in proper condition, the wire is taped up from proper position, and the retainer is in final lock condition. If the retainer is in pre-assembled condition, it must be changed to be in final lock condition.

(2)And then check the contact and the housing into the male housing for defects, deformation, discoloration, damage, rust, crack, deficit, etc.

**NOTE** *The connector must be renewed if any defects are found.*

(3) Insert the proper female housing into the male housing straight with same direction as shown in Fig.3. The operation is finished when you hear the click sound and can not insert further. When you can not insert the housing, do not insert by force, and check the items in (1),(2).

**NOTE** *At the insertion operation, take care not to apply force except in the insertion direction.*

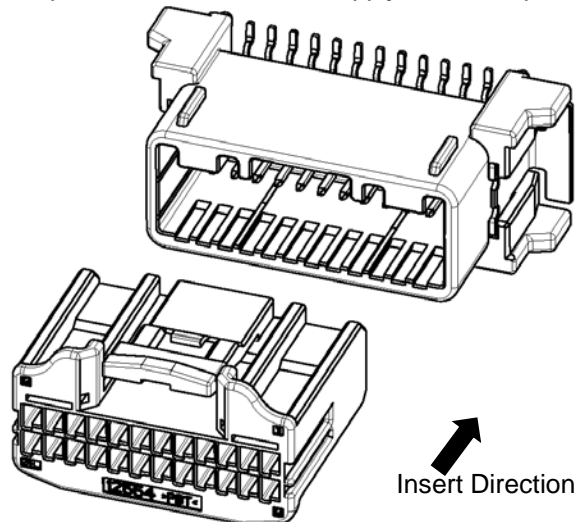


Fig.3

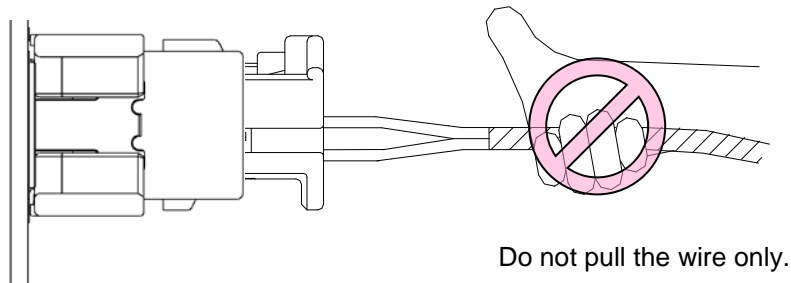
By pulling the female connector lightly, check to make sure that the connector can not be withdrawn.

### 5.3. Extraction of Connector

Grip the female housing, and then draw straight out while pressing down the locking lever. When the housing can not be drawn out, do not pull it by force but check to make sure if the locking mechanism is released.

**NOTE** *At the extraction operation, take care not to apply force except in the extraction direction.*

**NOTE** *Do not pull the wire only.*



### 5.4. General Attention Matters

- (1) Do not mate and extract the connector unnecessarily.
- (2) Do not insert any objects except the proper connector.
- (3) At mating/extraction operation, or after mating operation, take care not to apply unnecessary force or shock to the wire and the connector.