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1. Introduction

This instruction sheet explains the assembly process of
3M MDR Straight Receptacle Press Fit Type.

102XX-R2XX XX

Wire termination procedure for the connector is
explained by another manual.



2. Components

The Insertion Tools for 3M MDR Straight Receptacle
Press Fit Type consists of the following components.

(Need for each connector pin count)

See Fig-1.

① Press Block (10992-XX) 1 each

(drawing No.; 3U-0010-1595-8)

② Stopper Block (10991-XX) 1 each

(drawing No.; 3U-0010-1596-6)

(XX ; CONNECTOR'S PIN QUANTITY)

Please prepare for the Base Plate for seating under the Printed Wiring Board based on the drawing; 3U-0010-1637-8.



Fig-1

3. Preparation

The followings are needed for assembling.

(1) Press Machine (Ability 1.5 to 3.0 ton)

4. Assembly procedure

4-1 Set the Connector

See Fig-2.

Place the Printed Wiring Board on to the Base Plate.

Next, place the Connector on to the Printed Wiring Board.

(Please check the correct position between Connector and
Printed Wiring Board.)

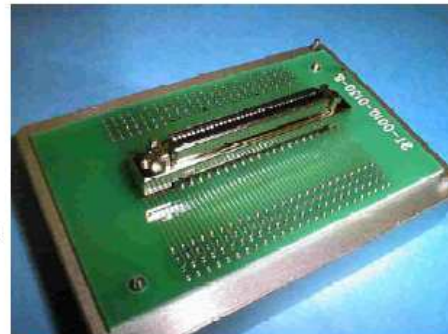


Fig-2

4-2 Set the Stopper Block

See Fig-3.

Locate the Stopper Block on to the Printed Wiring Board.

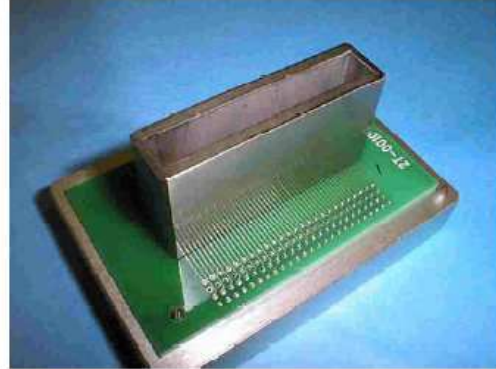


Fig-3

4-3 Set the Press Block

See Fig-4.

Place the Press Block on to the Stopper Block.

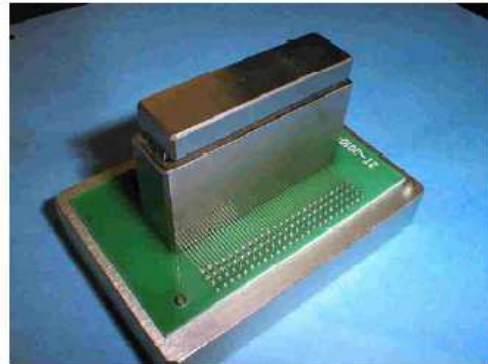


Fig-4

4-4 Press in

See Fig-5.

Press the top surface of Press Block by Press Machine.

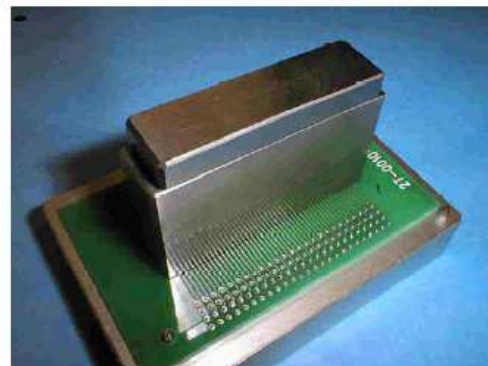


Fig-5

4-5 Final Process & Observation

See Fig-6.

Detach the Press Block and Stopper Block from Printed Wiring Board.

Next please make observation.

- (1) The clearance between bottom surface of Connector and top surface of Printed Wiring Board shall be 0.2 [mm] maximum. (see the arrows in Fig-6)
(Observation of press height)
- (2) The Contact Tails shall be outstanding from bottom surface of Printed Wiring Board uniformly.
It is depends on the thickness of Printed Wiring Board.
- (3) No mechanical damage shall occur on the Connector.
The traces of Press Block are not considered as damage.

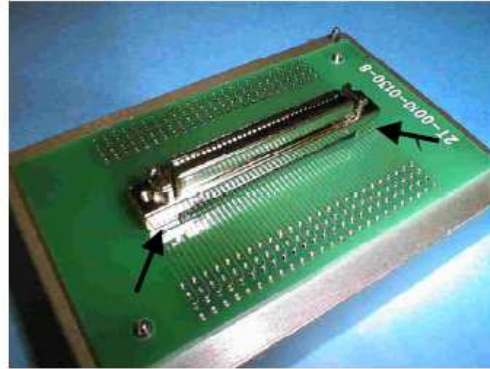


Fig-6