

Installation Instructions

Edge Launch Connector (TSM P/N: 050-3251-001)

For PC board Applications

Tools and Materials Required for Assembly

Soldering Iron	Solder, Sn63 or Sn96
Rosin flux (ROLO)	Isopropyl Alcohol
Acid brush	Magnification, 10x min

1 Placement of connector on PC Board. Place the connector onto the PC board and lightly secure it using the supplied #2-56UNC x 0.25" long socket head cap screws (2 places). See figure 1 below.

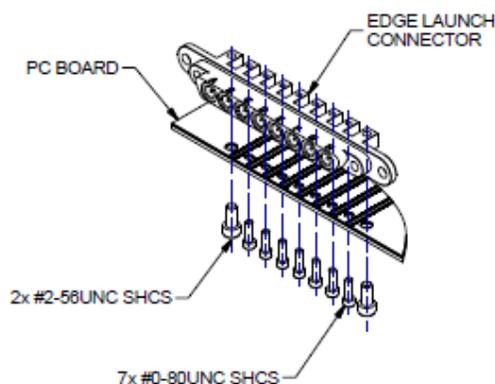


Figure 1

The connector should be able to move freely with light pressure. Under magnification, center the launch pins onto the traces. See Figure 2 Below.

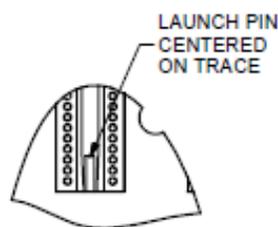


Figure 2

When all traces are centered, tighten the 2x #2-56UNC socket head cap screws. Under magnification, inspect the launch pin/trace locations. If the pins are centered on the

trace (Fig. 2), complete the installation of the connector onto the board by installing the #0-80UNC x 0.31" long socket head cap screws (7 places). Review the launch pin/trace alignment to ensure proper fit. If the connector shifted during this operation, slightly loosen all the fasteners, reposition the connector and re-tighten. Repeat this process until you achieved proper launch pin/trace alignment.

2 Soldering the connector onto the board. Note: Choose the right solder for your application. Apply a small drop of flux onto one of the launch pin. Place the soldering iron onto the launch pin and apply heat. Once the solder melting temperature is achieved (temperature varies per solder composition) apply the solder to the pin/board interface (see figure 3 below).

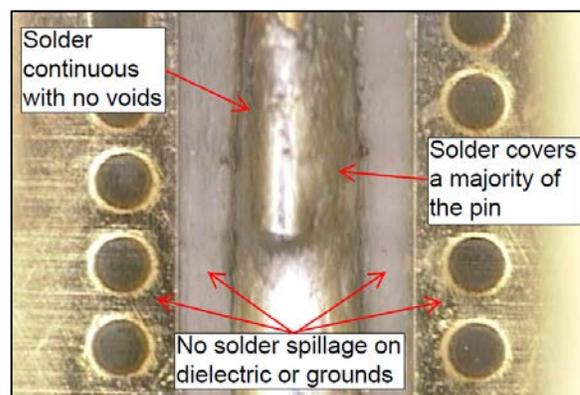


Figure 3

Repeat this process for the remaining launch pins until they all are soldered onto the PC board. Apply Isopropyl alcohol to each solder joint and clean using an acid brush. Under magnification, inspect the solder joints to ensure that the soldered interface is continuous and contains no voids. The inspection should also include viewing the PC board dielectric and surrounding ground planes to ensure that no solder has leached across this trace boundary. Excess solder can negatively affect electrical performance.

Installation Instructions

Vertical Launch Connector (TSM P/N: 050-3290-001)

For PC board Applications

Tools and Materials Required for Assembly

Soldering Iron Solder, Sn63 or Sn96

Rosin flux (ROLO) Isopropyl Alcohol

Acid brush Magnification, 10x min

Side cutters

1 Placement of connector on PC Board.

Locate the offset alignment hole on the PC board and the offset alignment pin of the connector. These items are used as a keying features and must be maintained during installation. See figure 1 below.

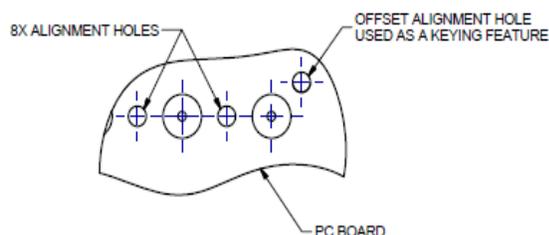


Figure 1

NOTE: Care must be taken to ensure that during assembly no excessive force is used to seat the connector onto the board. The pins are delicate and can be easily damaged. Place the connector onto the PC board paying close attention that all alignment and launch pins fit into the appropriate holes. Inspect the launch and alignment pins to ensure that they all are protruding out of the back of the PC board. Once the vertical launch connector is seated flush on the PC board secure it using the supplied #2-56UNC x 0.25" long socket head cap screws, #2 lock washer and #2-56UNC hex nut (2 places). See figure 2.

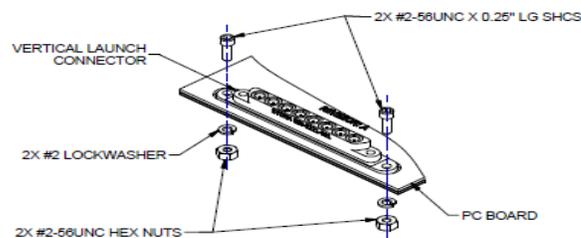


Figure 2

2 Soldering the connector onto the board. Note:

Choose the right solder for your application. Apply a small drop of flux onto one of the launch pin. Place the soldering iron onto the launch pin and apply heat. Once the solder melting temperature is achieved (temperature varies per solder composition) apply the solder to the pin/board interface (see figure 3 below).

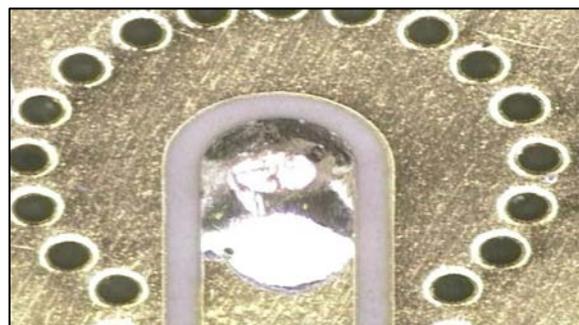


Figure 3

Repeat this process for the remaining launch pins until they all are soldered onto the PC board. Apply Isopropyl alcohol to each solder joint and clean using an acid brush. Under magnification, inspect the solder joints to ensure that the soldered interface is continuous and contains no voids. The inspection should also include viewing the PC board dielectric and surrounding ground planes to ensure that no solder has leached across this trace boundary. Excess solder can negatively affect electrical performance. Use the side cutter and trim the launch pins as close to the boards surface as possible. Excess launch pin length will result in degraded electrical performance.