

| SEATING TOOL ASSEMBLY | RJ POINT FIVE CONFIGURATION |
|-----------------------|-----------------------------|
| 2063000-1 | 2 X 8 |
| 2063000-2 | 2 X 12 |

Figure 1

1. INTRODUCTION

RJ Point Five Connector Seating Tool Assemblies 2063000-1 and -2, shown in Figure 1, are used to seat 2 X 8 and 2 X 12 (respectively) receptacle connectors onto the pc board. The receptacle connector contains compliant pin contacts to allow solderless pc board installation. Read these instructions thoroughly before using the seating tool.



NOTE

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

Reasons for reissue of this instruction sheet are provided in Section 8, REVISION SUMMARY.

2. DESCRIPTION (See Figure 1)

The seating tool consists of two sides, a back, and a top. It has cutouts (two located on each side and two located on the back) to accept the protruding part of the standoffs of the receptacle connector.

The top of the seating tool provides a surface to accept the force applied by the application tool to seat the receptacle connector onto the pc board. The seating tool is designed to position behind the panel ground springs of the receptacle connector. During seating, the back and sides of the seating tool protect the receptacle connector from damage.

3. REQUIREMENTS

3.1. PC Board Support Fixture (Customer Supplied)

A pc board support must be used to provide proper support for the pc board and to protect the pc board and receptacle connector from damage. The support fixture must be designed for specific needs using the following recommendations:

- it should be at least 25.4 mm [1 in.] longer and wider than the pc board
- it should have flat surfaces with holes or a channel large enough and deep enough to receive any protruding components of the receptacle connector

3.2. Application Tool

Power for seating tools must be provided by an application tool (with a ram) capable of supplying a downward force of 44.5 N [10 lb-force] per contact. For available application tools, call PRODUCT INFORMATION at the number at the bottom of Page 1.



CAUTION

Over-driving of the receptacle connector will deform parts critical to the quality of the connection. Maximum force occurs prior to the receptacle connector bottoming on the pc board.

4. SETUP

When setting up equipment to seat the receptacle connector, pay particular attention to the following:

- the seating tool must be properly aligned to the receptacle connector



CAUTION

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

- the seating tool, receptacle connector, and application tool ram must be properly aligned before cycling the application tool



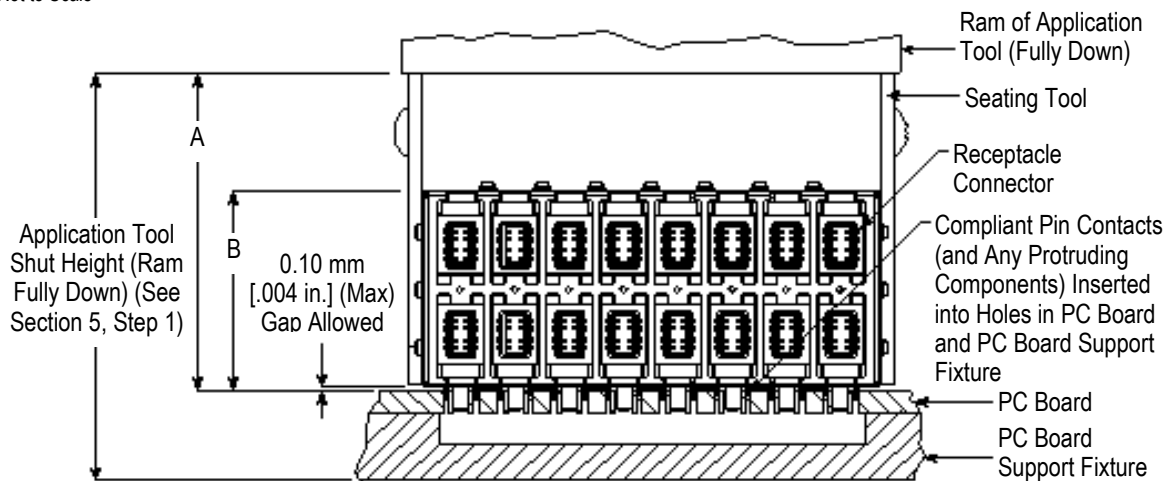
NOTE

Use the tool seating height as a reference starting point. This height may need to be adjusted to obtain the amount allowed (maximum of 0.10 mm [.004 in.]) between the standoffs of the receptacle connector and the pc board.

5. SEATING (Figure 2)

1. Set tool seating height to the dimension shown in Figure 2 (application tool shut height will equal the tool seating height PLUS the combined thicknesses of the pc board and support fixture). After seating, a gap of no more than 0.10 mm [.004 in.] between the receptacle connector standoffs and the pc board is allowed.
2. Place the pc board on the support fixture.
3. Orient the seating tool over the receptacle connector so that the back is aligned with the back of the receptacle connector. Then lower the seating tool onto the receptacle connector, making sure that the cutouts slide over the protruding components of the receptacle connector, until the seating tool bottoms on the top of the receptacle connector.

NOTE: Not to Scale



| DIMENSION A Tool Seating Height (Receptacle Connector Seated) | DIMENSION B Seating Height (Receptacle Connector Seated) |
|--|---|
| 40.64 mm [1.60 in.] | 25.4 mm [1.00 in.] |

Figure 2

4. Place the receptacle connector on the pc board so that the contacts and alignment posts are aligned and started into the matching holes in the pc board.
5. Center the seating tool (with the receptacle connector) under the ram of the application tool. Slowly lower the ram until it just meets the seating tool. Verify alignment of pc board support, pc board, receptacle connector, and seating tool.

**CAUTION**

Damage to the pc board, seating tool, or receptacle connector may occur if the seating tool is not properly seated on the receptacle connector before cycling the application tool.

6. Cycle the application tool to seat the receptacle connector on the pc board. Then retract the ram, and carefully remove the seating tool by pulling it straight from the receptacle connector.
7. Check the receptacle connector for proper seating according to the following:
 - a. the widest section of each compliant pin is inside its intended pc board hole
 - b. each alignment post is in its intended pc board hole
 - c. the receptacle connector is seated on the pc board with a maximum seating height- measured from the top of the receptacle connector (not including the panel ground springs) to the top of the pc board-given in Figure 2.
 - d. if present, the gap between the standoffs and the pc board is no more than 0.10 mm [.004 in.]

6. MAINTENANCE AND INSPECTION

The seating tool is assembled and inspected before shipment. It is recommended that the seating tool be inspected immediately upon arrival at your facility to ensure that it has not been damaged during shipment and that it conforms to the dimensions provided in Figure 3.

6.1. Daily Maintenance

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

1. Remove dust, moisture, and contaminants with a clean, soft brush or a lint-free cloth. DO NOT use objects that could damage the components.
2. When the seating tool is not in use, store it 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 seating tool or be supplied to personnel responsible for the seating tool kit. Inspection frequency should be based on amount of use, working conditions, operator training and skill, and established standards.

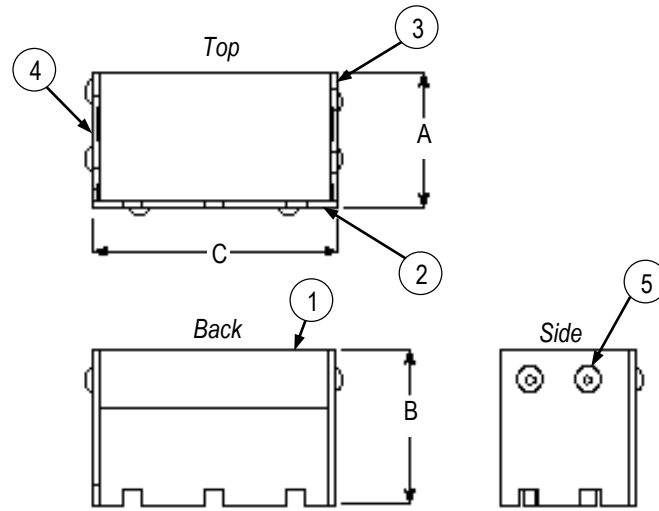
7. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 3. Parts other than those listed should be replaced by TE to ensure quality and reliability. For customer repair service or to order replacement parts, call 1-800-522-6752, or fax your purchase order to 717-986-7605, or write to: Customer Service (038-035), Tyco Electronics Corporation, PO Box 3608, Harrisburg, PA 17105-3608.

8. REVISION SUMMARY

- Updated document to corporate requirements
- Added tables to Figures 1 and 3

Seating Tool Dimensions



| REPLACEMENT PARTS | | | | SEATING TOOL KIT (By Product Configuration) | DIMENSION (mm [in.]) | | |
|-------------------|----------------------|-----------|-------------|--|----------------------|-----------------|-------------------|
| ITEM NO. | PART NUMBER FOR KITS | | QTY PER KIT | | A | B | C |
| | 2063000-1 | 2063000-2 | | | | | |
| 1 | 2063068-1 | 2063068-2 | 1 | 2 X 8 (Kit 2063000-1) | 34.59 [1.362] | 40.13 [1.58] | 62 [2.46] |
| 2 | 2063069-1 | 2018859-1 | 1 | | | | |
| 3 | 2063070-1 | 2063070-1 | 1 | 2 X 12 (Kit 2063000-2) | 34.59 [1.362] | 40.13 [1.58] | 90.475 [3.562] |
| 4 | 2063071-1 | 2063071-1 | 1 | | | | |
| 5 | 1-21002-7 | 1-21002-7 | 6 | | --- | | |

Figure 3