

# Instructions for the Assembly of 3M™ Printed Circuit Board (PCB) Connectors

## 1.0 General

3M Printed Circuit Board Connectors can be terminated before or after being soldered. 3M™ Locator Plates 3443-15, 3443-16, 3443-19 and 3443-34 are drilled to relieve the solder contacts before being soldered. 3M™ Locator Plate 3443-8 has a rubber cushion to relieve the solder contacts and fillets after being soldered. These locator plates are used with 3M™ Manual or Pneumatic Assembly Presses and other convenient assembly tooling to reduce set-up time, provide easier and faster assembly, and reduce assembly error.

3M printed circuit board connectors are designed for production wave soldering, but hand soldering is acceptable. Avoid excessive or prolonged temperature. Connectors should be held down to prevent “floating” during wave soldering. When hand soldering, apply the soldering iron to the printed circuit pad, and bridge the solder round and onto the contact.

Number of Contacts	Product Part No.	3M Locator Plate No.	Shut Height Setting		Platen Part No.
			3640 Press	3335, 3339	
10	3474-0000	3443-15	2	2 1/2	3442-9
		† 3443-8	3*	3 1/2*	
	3474-0000T	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3474-0001T	3443-15	2	2 1/2	
		† 3443-8	4**	4 1/2**	
20	3422-0000	3443-16	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3422-0000T	3443-16	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3422-0001T	3443-16	2	2 1/2	
		† 3443-8	4**	4 1/2**	
26	3434-0000	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3434-0000T	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3434-0001T	3443-15	2	2 1/2	
		† 3443-8	4**	4 1/2**	
34	3402-0000	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3402-0000T	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3402-0001T	3443-15	2	2 1/2	
		† 3443-8	4**	4 1/2**	
40	3418-0000	3443-16	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3418-0000T	3443-16	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3418-0001T	3443-16	2	2 1/2	
		† 3443-8	4**	4 1/2**	
50	3426-0000	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3426-0000T	3443-15	2	2 1/2	
		† 3443-8	3*	3 1/2*	
	3426-0001T	3443-15	2	2 1/2	
		† 3443-8	4**	4 1/2**	

\* Connector soldered to 0.062" board  
\*\* Connector soldered to 0.125" board

† For assembly AFTER soldering  
Use 3M Locator Plate 3443-8

## 2.0 Assembly:

2.1 Remove the platen from the assembly press and adjust the press shut height to the appropriate setting. (Figure 1)

2.2 Position the locator plate on the assembly press table over the mounting studs for tight, left or front cable entry.

2.3 Replace the platen and position it parallel with the conductor length.

### 2.4 Unsoldered Connector

- Locate a connector body on the locator plate so the solder contacts are within the relief holes.

### Soldered Connector

- Locate a connector body to a PC board over the rubber cushion
- The connector body should be centered directly below the assembly press shaft.

2.5 Grasp a plug cover strip between thumb and forefinger of both hands, with the liner facing you. Rotate the outermost cover down against the adjacent cover on the strip, breaking it from the liner. Pull laterally away from the strip. Adhesive should be present on the cover. (Figure 2)

2.6 Firmly press ribbed side of cable into the alignment grooves on cover. The adhesive will help it to stay in place. Visually inspect to ensure that:

- Cable is properly aligned to cover grooves.
- Cable end is flush with the cover for end terminations or perpendicular to cover for bussing.

2.7 Place the connector cover and cable over the connector body, aligning the cover holes with the cover retaining posts. Push down firmly.

2.8 Complete the connection by lowering the assembly press handle fully.

2.9 Visually inspect to ensure that : (Figure 3)

- Cover is fully seated and parallel with the body.
- Cover is properly aligned with the cable.
- Connector is parallel with PC board.

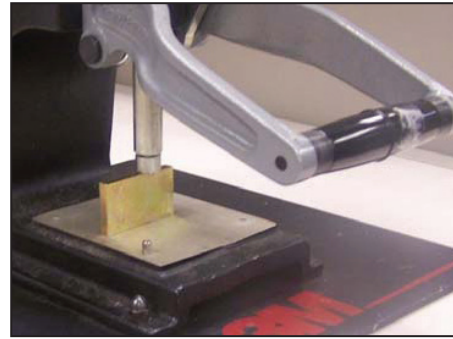


Figure 1



Figure 2

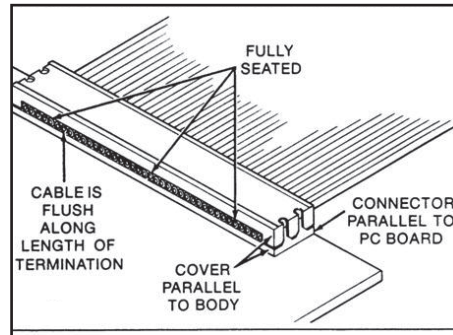


Figure 3

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### Electronic Solutions Division Interconnect Products

6801 River Place Blvd.  
Austin, TX 78726-9000  
800-225-5373  
www.3Mconnector.com

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