



Title of Document:	HANDLING MANUAL	Issue No. CHM-1-2458	Rev. 1
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This handling manual describes the points of assembling and mounting on the PC board for further connector's reliability and making the most of the connector's features.

C O N T E N T S

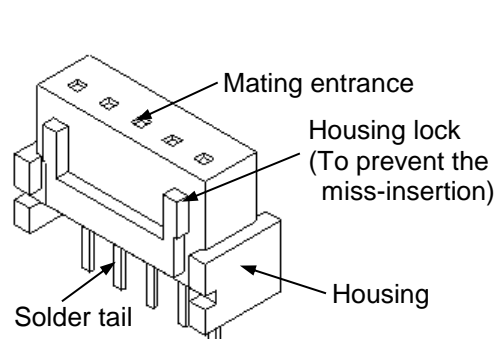
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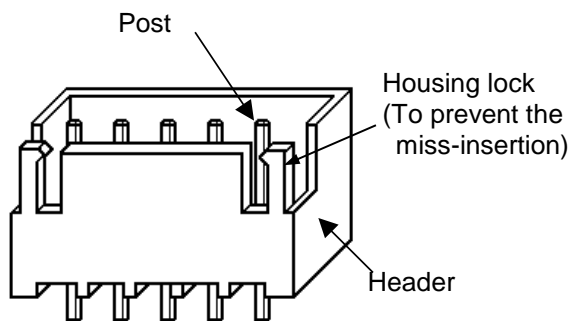
1. Mechanism and Part Name

The JQ connector is composed of the socket and the header.

In processing and assembling, understand the mechanism and the names of each part.



Socket for top entry type



Header for top entry type

2. Model Number

Product Name		Model Number
Socket	Top entry type	*JQ-BT
	Side entry type	*JQ-ST
Header	Top entry type	B*B-XH-A (LF)(SN)
	Side entry type	S*B-XH-A-1 (LF)(SN)

Note₁: "*" denotes the circuit number.

Note₂: Other headers for the XH connectors also are applicable as the JQ connector's socket.

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3. Applicable PC Board

3-1 Thickness

1.6 mm in thickness

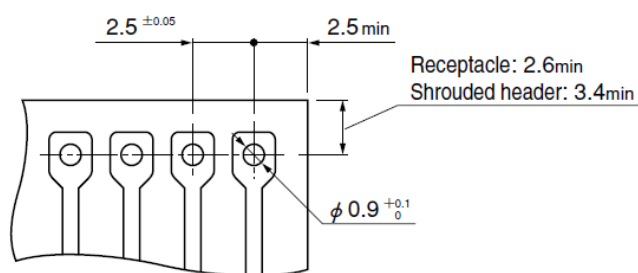
3-2 PC board's layout

Refer to the following PC board's layout. (Common to the socket and the header)

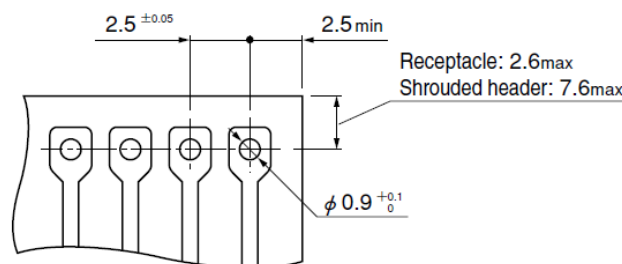
The tolerances for the PC board are non-cumulative ± 0.05 mm for all centers.

Note₃: The PC board's hole diameter is the reference value of the drilling hole for paper-base epoxy resin PC board.

The proper hole diameter depends on the material, etc. of the PC board.



Top entry type



Side entry type

4. Soldering

① Floating from the PC board

The JQ connector's socket and header have the mechanism that they are not come off of the PC board in inserting. But, if the header floats due to an external load and vibration, softly push the connector in before soldering so that it closely touches the PC board's surface.

② Flux

Use the activated one.

Do not dip the connector in the flux.

③ Dip-soldering

Solder the connector within 5 seconds at the temperature of 245 to 265 °C.

④ Hand soldering and repairing

In soldering by a soldering iron or repairing for solder bridge, etc., following, keep in mind the following points, to prevent the housing resin from the deterioration due to heating.

Soldering iron:	Maximum 40W of heat capacity
Soldering time:	Within 3 seconds as quick as possible
Soldering method:	Do not apply an external load, such as pressing down the pin with the aid of the iron's tip, to the pin during soldering.

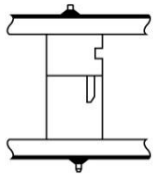
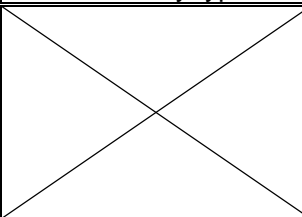
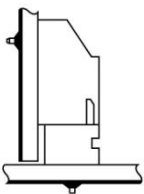
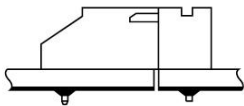
⑤ Cleaning

The cleaning solvent, which is used for normal flux cleaning, does not affect the socket and the header. But, in case that the cleaning solvent stays behind on the socket and the header, there is a possibility to cause poor contact and other defects.

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5. Assembly Layout

The side entry type socket is used only for the connection with the PC board, which is on the same flat surface. (When the side entry type socket and header are assembled)

Combination		Socket	
		Top entry type	Side entry type
Header	Top entry type		
	Side entry type		

6. Assembly Points

When the JQ connector is assembled, it has to hold the PC board, so a large load becomes easy to apply to the connector.

The following consideration is necessary in assembling.

① Mating on the same axis

Mate the connector on the same axis. If it is difficult to mate and unmate the connector on the same axis due to the setting of the connector, do the operation within 10 degrees. In case of the mating at a larger degree than 10° (which is called as prying), there is a risk of the deformation of the contact and the post, which may affect the connector's performance.

② Do not apply an external load to the PC board before fixing.

After mating the connector, fix the PC board as quickly as possible. If the heavy PC board is allowed to sit without fixing, the weights of the PC board and the mounted components or an external load work as prying operation.

As the countermeasure, there is the way that the PC board is temporarily fastened with something like molding hook, and then it is fastened with secure.

