



NOTE

All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters. Unless otherwise specified, dimensions have a tolerance of ± 0.13 and angles have a tolerance of $\pm 2^\circ$. Figures and illustrations are for identification only and are not drawn to scale.

1. INTRODUCTION

This specification covers the requirements for application of Z-PACK HMZd-LE 2-, 3-, and 4-pair connector systems. The connector systems use a modular concept and interconnects two printed circuit (pc) boards or cable-to-pc boards. The connectors are available in vertical press-fit pin headers and right-angle press-fit receptacles. Each module has a width of 24.99 mm. The three available versions are: 2-signal contact pairs per column (20 pairs per module), 3-signal contact pairs per column (30 pairs per module), and 4-signal contact pairs per column (40 pairs per module).

The connectors are designed to be seated onto the pc board via eye-of-needle compliant pin contacts. Each connector has polarization/alignment slots and lugs with a guide-in feature that helps position the contacts prior to engagement of the circuits. Universal, universal keyed, and Advanced Telecommunications Computing Architecture (AdvancedTCA) guide pins and modules (available separately) can be used with these connectors to provide error-free mating and prevent damage to the connector and contacts during mating. The receptacles and pin headers are designed to mate together.

When corresponding with TE Connectivity Personnel, use the terminology provided in this specification to facilitate your inquiries for information. Basic terms and features of this product are provided in Figure 1.

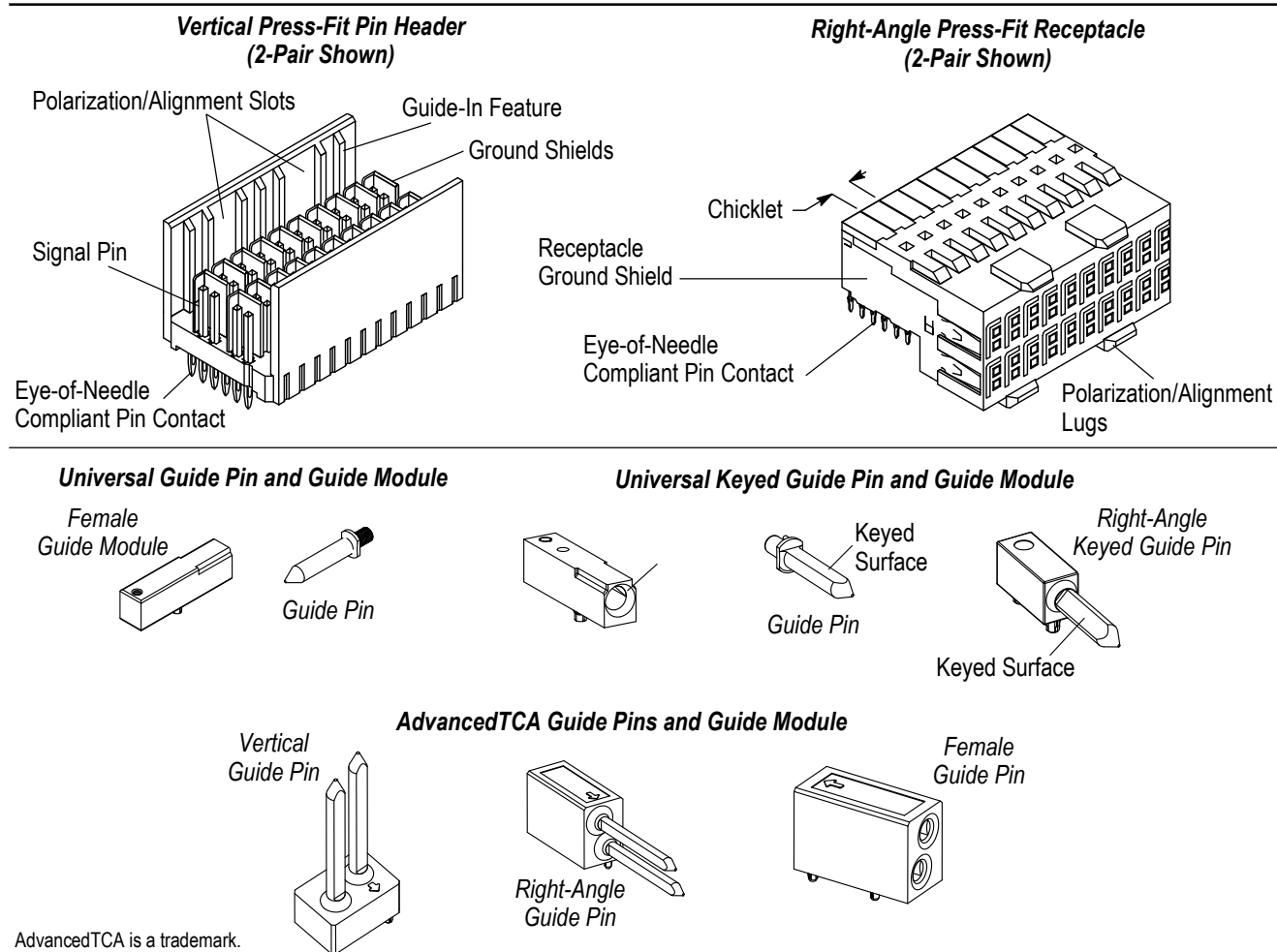


Figure 1

2. REFERENCE MATERIAL

2.1. Revision Summary

- Initial release of document

2.2. Customer Assistance

Reference Product Base Part Numbers 1645695 (2-pair HMZd pin header), and 1645694 (2-pair HMZd-LE receptacle), and Product Codes F269 and F270 are representative of these connectors. Use of these numbers will identify the product line and help you to obtain product and tooling information when visiting www.te.com or calling the PRODUCT INFORMATION number at the bottom of page 1.

2.3. Drawings

Customer drawings for product part numbers are available from www.te.com. Information contained in the customer drawing takes priority.

2.4. Specifications

Product Specification [108-32120](#) and Qualification Test Report [501-134045](#) provides product performance and test information for HM Zd connectors.

Product Specification [108-32120](#) provides product performance and test information for HM Zd Plus connectors.

Application Specification [114-1103](#) provides product description and application requirements for universal power modules (UPM), vertical receptacles, and right-angle pin headers used with HM Zd connectors.

2.5. Instructional Material

Instruction sheets (408-series) provide product assembly instructions or tooling setup and operation procedures. Instructional material available that pertains to this product are:

408-8500	Seating Tools 91347-[], 91350-[], and 91376-1 for HMZd-LE Receptacle Connectors
408-8501	Seating Tools 91348-1, 91349-1, and 91375-1 for HMZd-LE Header Connectors
408-8644	HMZd Receptacle Housing Removal Tool 1583224-1
408-8645	HMZd Header Removal Tools 1583220-1, 1583234-1, and 1673951-1
408-8646	HMZd Pin (Post) Extraction Tool 1583237-1
408-8647	HMZd Chicklet Removal Tools 1583248-1, 1583249-1, and 1673952-1
408-8648	HMZd Pin (Post) Insertion Tool 1583255-1
408-8785	Seating Tools 91372-1 and 91373-1 for HMZd-LE Header Connectors

3. REQUIREMENTS

3.1. Storage

The product should remain in the shipping containers until ready for use to prevent deformation to components. The product should be used on a first in, first out basis to avoid storage contamination that could adversely affect performance.

3.2. Material

The housings and chicklets are molded of high-temperature rated (UL 94V-0) polyesters.

The signal pin contacts are phosphor bronze and plated at the contact interface with gold. The signal receptacle contacts are copper alloy and plated at the contact interface with gold. All contacts have a nickel underplate and tin or tin-lead plated press-fit leads. Ground contacts are phosphor bronze and plated at the contact interface with gold. All contacts have a nickel underplate and tin or tin-lead plated press-fit leads.

Universal guide modules and universal keyed guide pins are made of zinc alloy. Un-keyed guide pins are made of stainless steel. AdvancedTCA guide hardware is made of a zinc alloy casting with a nickel finish.

3.3. Selection Criteria

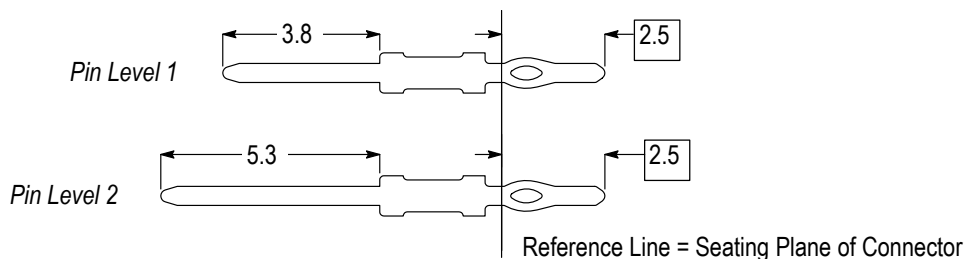
A. Size

Length of each pin is given in Figure 2.

B. Guide Modules and Pins

The guides modules and pins are recommended for multi-connector, large and heavy daughter card applications and conditions where misalignment tolerances (given in Paragraph 3.7,A) cannot be met.

Signal Pin Post Length and Tail Length



NOTE: Contact area lubricated with Bellcore-approved lubricant. Technical Reference: GR-1217-CORE. Issue 1. November 1995.

Figure 2

3.4. PC Board Requirements

A. Material and Thickness

Right-angle receptacles require a daughter card having a minimum thickness of 1.40 mm. The maximum allowable thickness is 3.5 mm. A special pin header is required for a daughter card thicker than 3.5 mm (contact PRODUCT INFORMATION at the number at the bottom of page 1 for recommendation). For suitability of other daughter card thicknesses, contact PRODUCT INFORMATION at the number at the bottom of page 1.

Vertical pin headers require a minimum backplane thickness of 1.40 mm to allow for positive retention of the compliant pin contacts. Midplane applications require a minimum backplane thickness of 3.8 mm. Thicker backplanes will not affect the retention of the compliant pin contact.



NOTE

For circuit routing concerns, contact **PRODUCT INFORMATION** at the number at the bottom of page 1.

B. Layout

The pc board hole pattern for the placement of these connectors is provided in Figure 3. Datums and basic dimensions are established by the customer.

Recommended PC Board Layouts

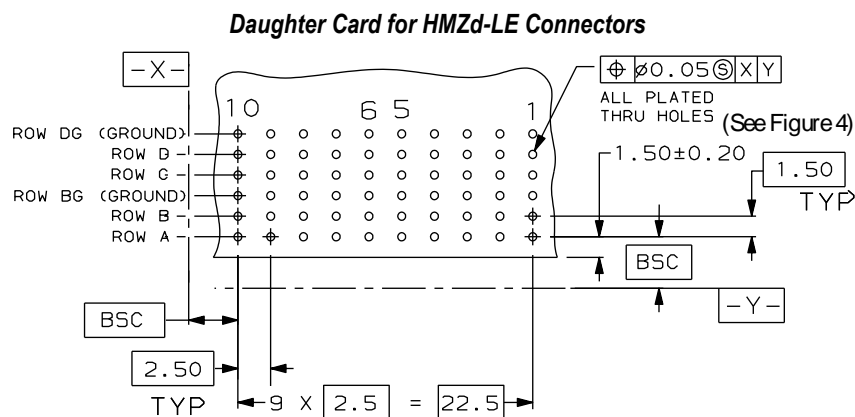


Figure 3 (cont'd)

Recommended PC Board Layouts

Backplane for HMZd-LE Connectors

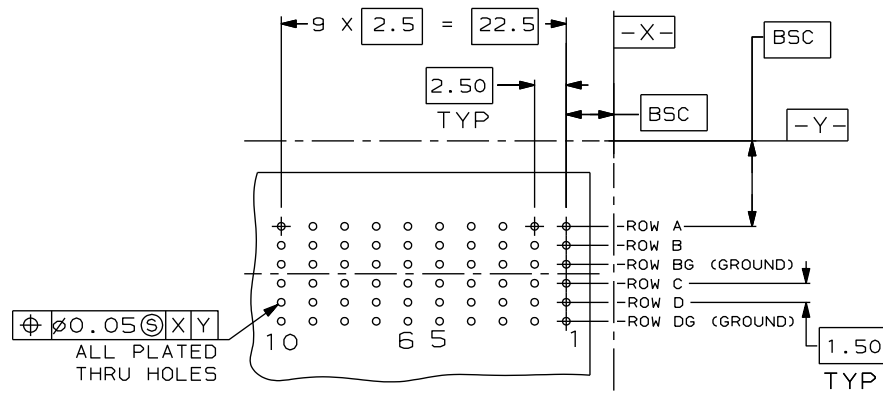
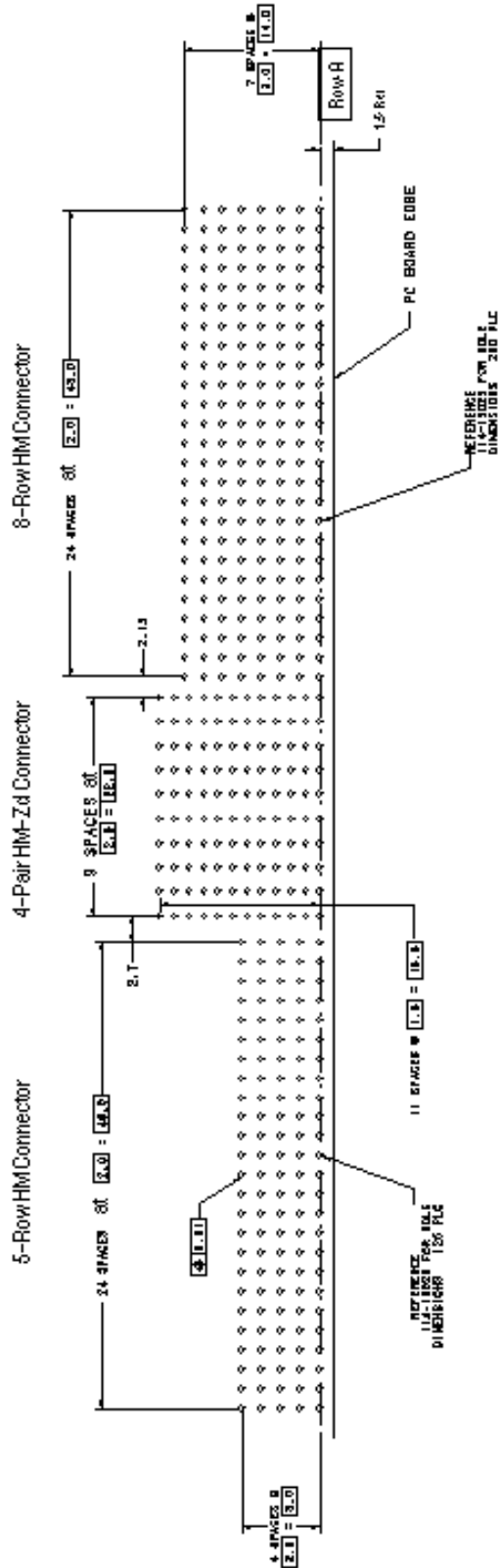


Figure 3 (cont'd)

**Daughter Card for
HMZd-LE 4-Pair Connector and 2-mm HM Connector (Ref)**



**Backplane for
HMZd-LE 4-Pair Connector and 2-mm HM Connector (Ref)**

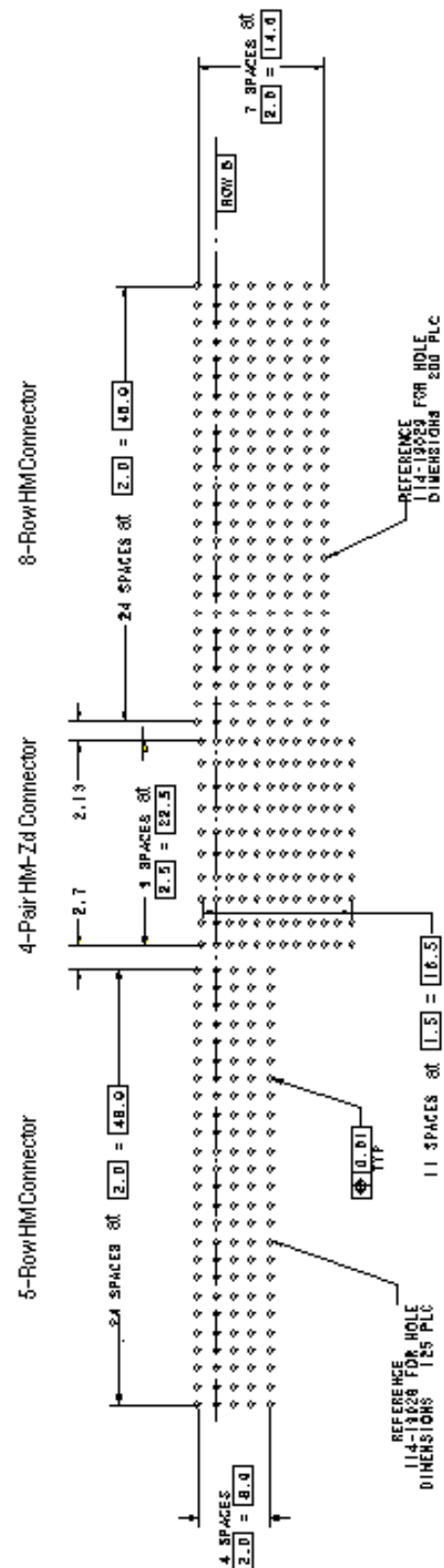


Figure 3 (cont'd)

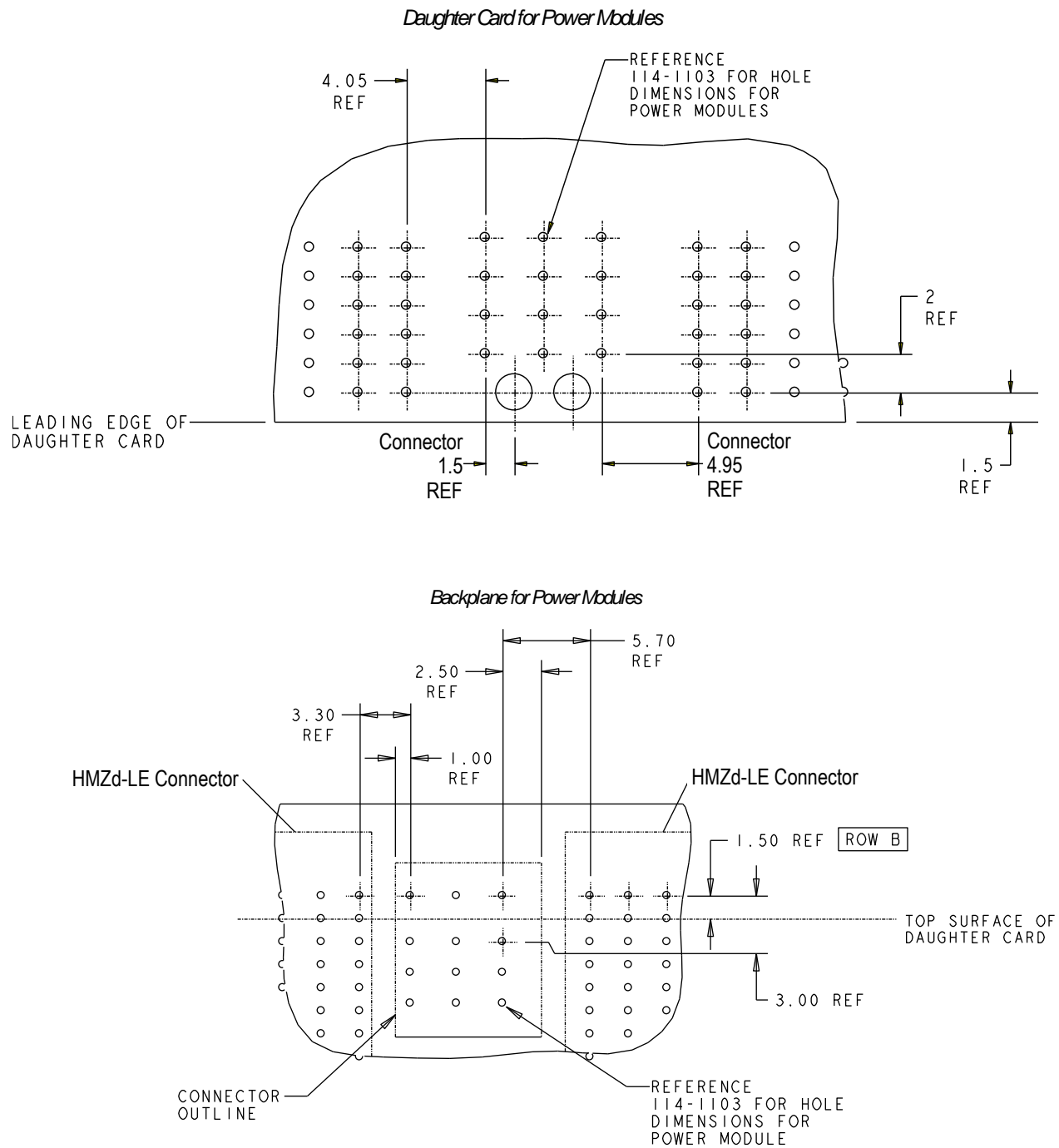
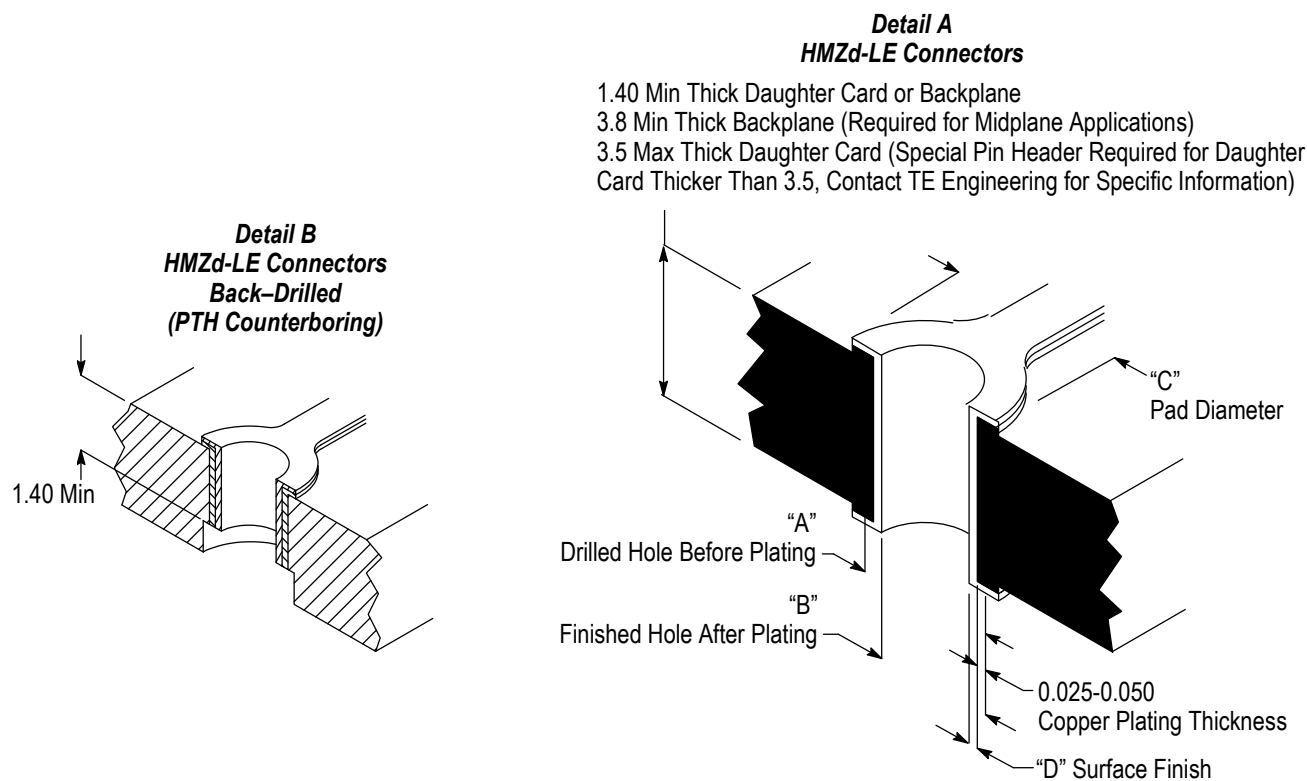


Figure 3 (end)

C. Hole Configuration

The holes in the pc board for all contacts must be drilled and plated through to the dimensions shown in Figure 4, Detail A.

For pc boards that are back-drilled-plated through hole (PTH) counter-bored-for signal integrity performance improvement, the depth of the plated hole must be no more than the dimensions given in Figure 4, Detail B.



CONNECTOR	DIMENSION			DIMENSION D		
	A	B (Nominal)	C	SURFACE FINISH	THICKNESS	
					HMZd Connector	HMZd Plus Connector
HMZd	0.675-0.725	0.61●	1.00	Hot Air Solder Leveling (HASL) Tin-Lead (Sn Pb)	0.004-0.010	0.0037-0.0123
				Immersion Tin (Sn)	0.0005-0.004	
				Organic Solderability Preservative (OSP)	0.0002-0.0005	
---				Immersion Gold (Au) Over Nickel (Ni) (ENIG)	0.0001-0.0005 Au 0.00127-0.0076 Ni	
				Immersion Silver (Ag)	0.0001-0.0005	
				Gold (Au) Over Nickel	0.0001-0.0005 Au 0.00127-0.0076 Ni	
				Immersion tin (Sn)	0.0005-0.004	

● Tolerance or acceptable range of finished hole diameter is the sum of the plated through hole component tolerances.

All component tolerances must be achieved.

Min Finished Diameter = A (Min) - 2 x Copper Thickness (Max) - 2 x D (Max)

Max Finished Diameter = A (Max) - 2 x Copper Thickness (Min) - 2 x D (Min)

Figure 4

D. Placement

Location of the connector placement on the pc board in relationship to the keying guide modules and pins shall be as shown in Figure 5.

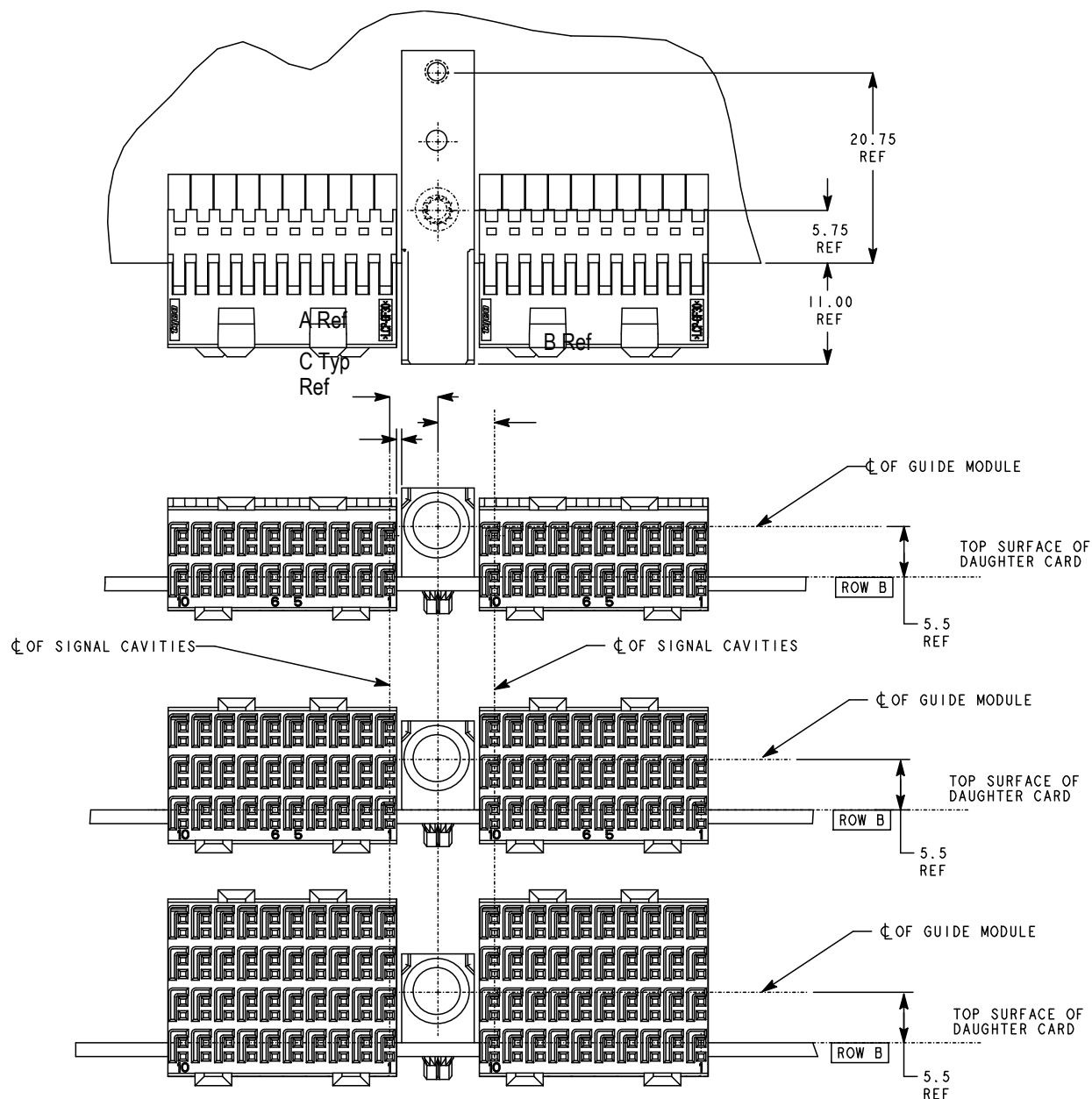
Connectors can be mounted end-to-end within specified spacing given in Figure 6.

When using these connectors with similar Z-PACK connectors or components, it is recommended to use the spacing given in Figure 3.


NOTE

Pattern of leads is shifted by 0.45 mm with respect to the connector housing. Column-to-column spacing between butted connectors is still 2.5 mm.

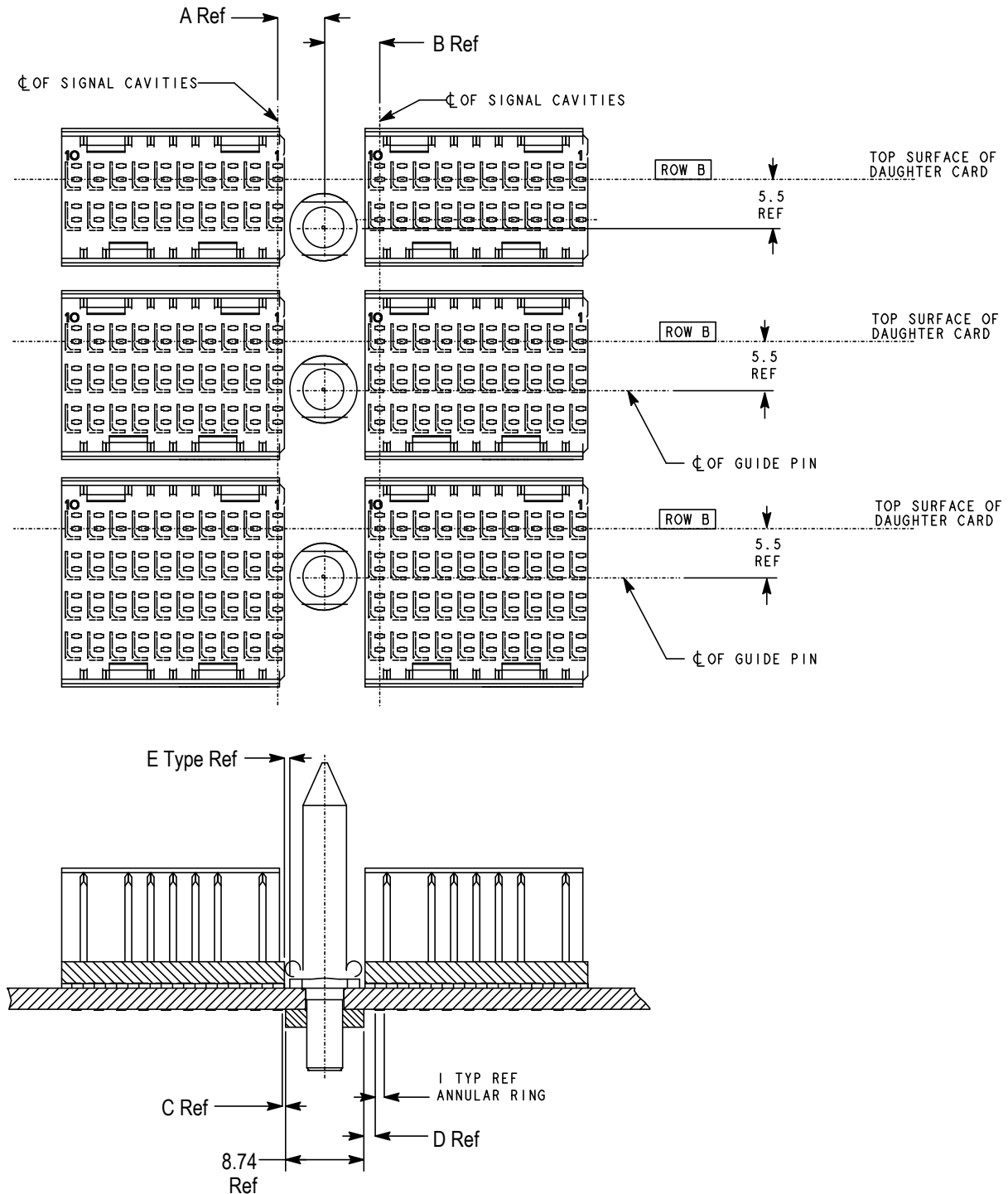
**Recommended Daughter Card PC Board Spacing Layout
HMZd-LE Connectors and Z-PACK 2 mm HM Guide Modules (Ref)**



GUIDE MODULE	DIMENSION		
	A	B	C
Universal	5.25	6.15	0.56
Keyed	5.52	6.42	0.83

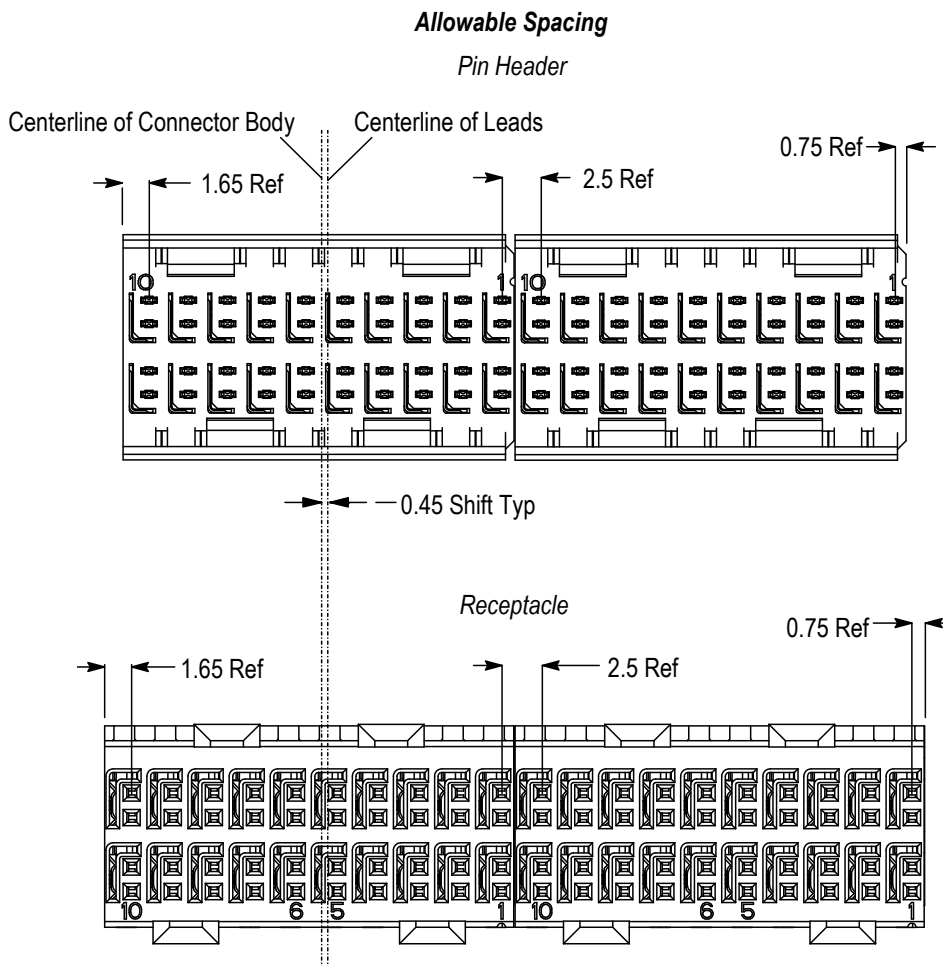
Figure 5 (cont'd)

Recommended Backplane PC Board Spacing Layout HMZd-LE and Z-PACK 2 mm HM Guide Modules



GUIDE PIN	DIMENSION				
	A	B	C	D	E
Universal	5.25	6.15	0.40	1.30	0.60
Keyed	5.52	6.42	0.65	1.55	0.42

Figure 5 (end)



NOTE: 2-pair connector shown; 3- and 4-pair connectors are the same for dimensioning purposes.

Figure 6

3.5. Connector Seating

A. Initial Positioning

These connectors are typically manually pre-applied to a pc board. Connectors should be gripped by the housing and/or chicklets only and not by the contacts. When placing a connector onto a pc board, all contact should be aligned and inserted into the pc board simultaneously to prevent twisting or bending of the contacts.

B. Seating Connectors

A suitable machine capable of supplying a minimum controllable downward force of 70 N [15.7 lbs] per contact must be used (insertion force will vary according to pc board variations and signal pin count). Force must be applied evenly on the connectors to prevent deformation or other damage to the contacts and housings. When installing vertical pin headers, the insertion force must be simultaneously applied to the shoulders of each contact. When seating right-angle receptacles and right-angle pin headers, the insertion force must be evenly applied to the assembly (top surface of the chicklets).

Pin headers and receptacles must be seated onto the pc board to the dimensions shown in Figure 7.



CAUTION

Correct seating of connectors is essential to interconnection performance. This includes correct seating height and force applied. Over-seating of connectors will deform parts critical to the quality of the connector.

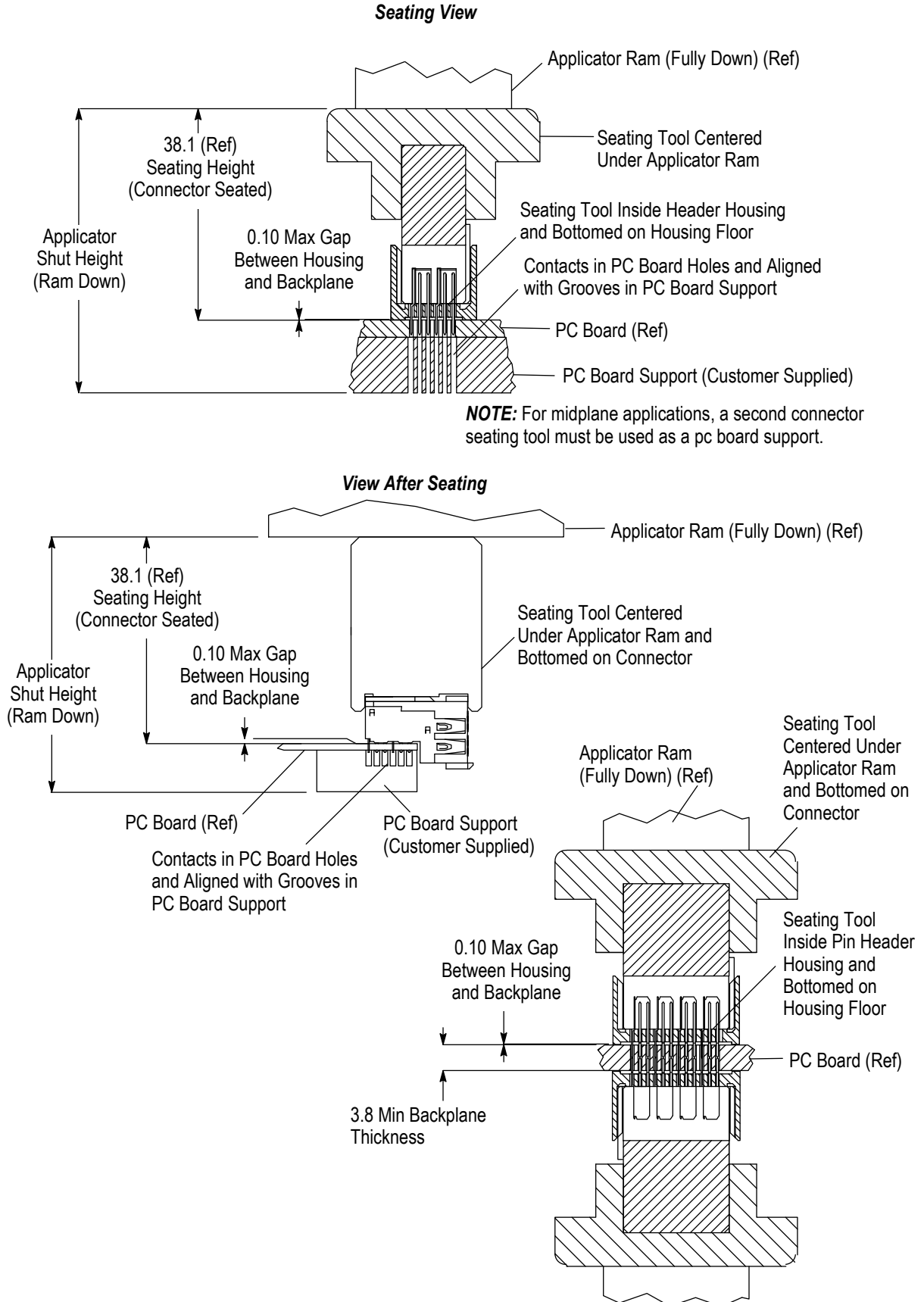


Figure 7

3.6. Solder Process Considerations

Since these connectors have press-fit compliant pin contacts, soldering is not required; however, when pc board repair or rework requires soldering after the connectors are seated on the pc board, the following applies:

A. Cleaning

After soldering, removal of fluxes, residues, and activators is necessary. Consult with the supplier of the solder and flux for recommended cleaning solvents.

Gold surfaces of contact tines must be re-lubricated with a Telcordia-approved lubricant.



CAUTION

Even when using "no clean" solder paste, it is imperative that the contact interface be kept clean of flux and residue, since it acts as an insulator.



DANGER

Consideration must be given to toxicity and other safety requirements recommended by the solvent manufacturer. Refer to the manufacturer's material safety data sheet (MSDS) for characteristics and handling of cleaners. Trichloroethylene and methylene chloride is not recommended because of harmful occupational and environmental effects. Both are carcinogenic (cancer-causing).

B. Drying

Air drying of cleaned connectors is recommended; however, temperature for the connectors should be within -65 and 105°C [-149 and 221°F]. Degradation of the housings could result from extreme temperatures.

3.7. Mating

A. Alignment

Proper alignment is essential to ensure full engagement of mating connectors, and to ensure that contacts are not bent or otherwise damaged during mating and unmating. For tolerance limitations, see Figure 8.

NOTE: 2-pair connector shown; 3- and 4-pair connectors are the same for dimensioning purposes.

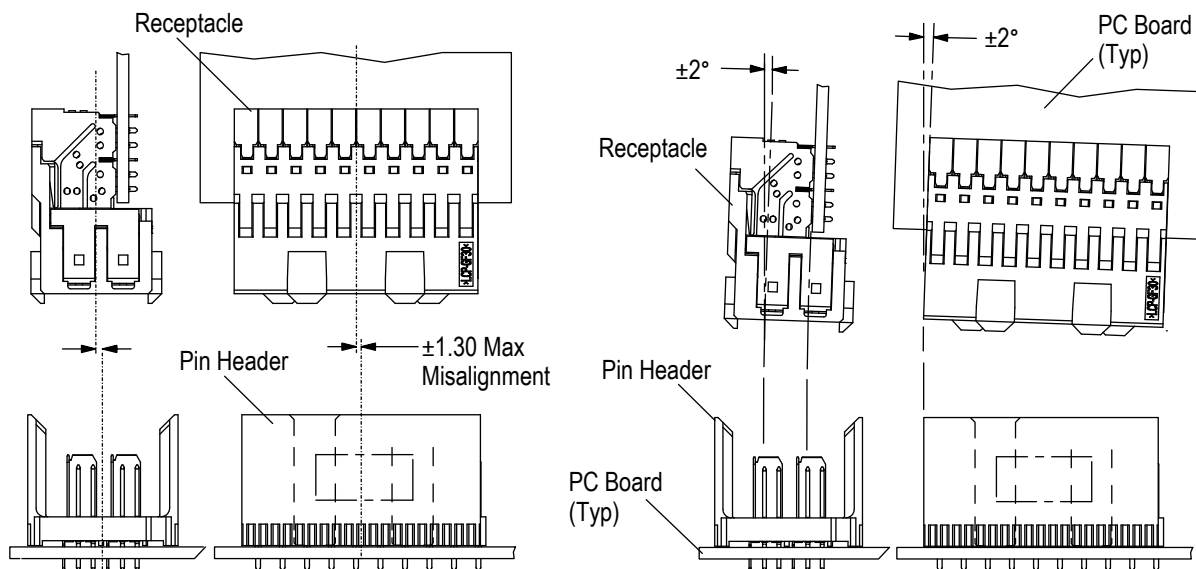


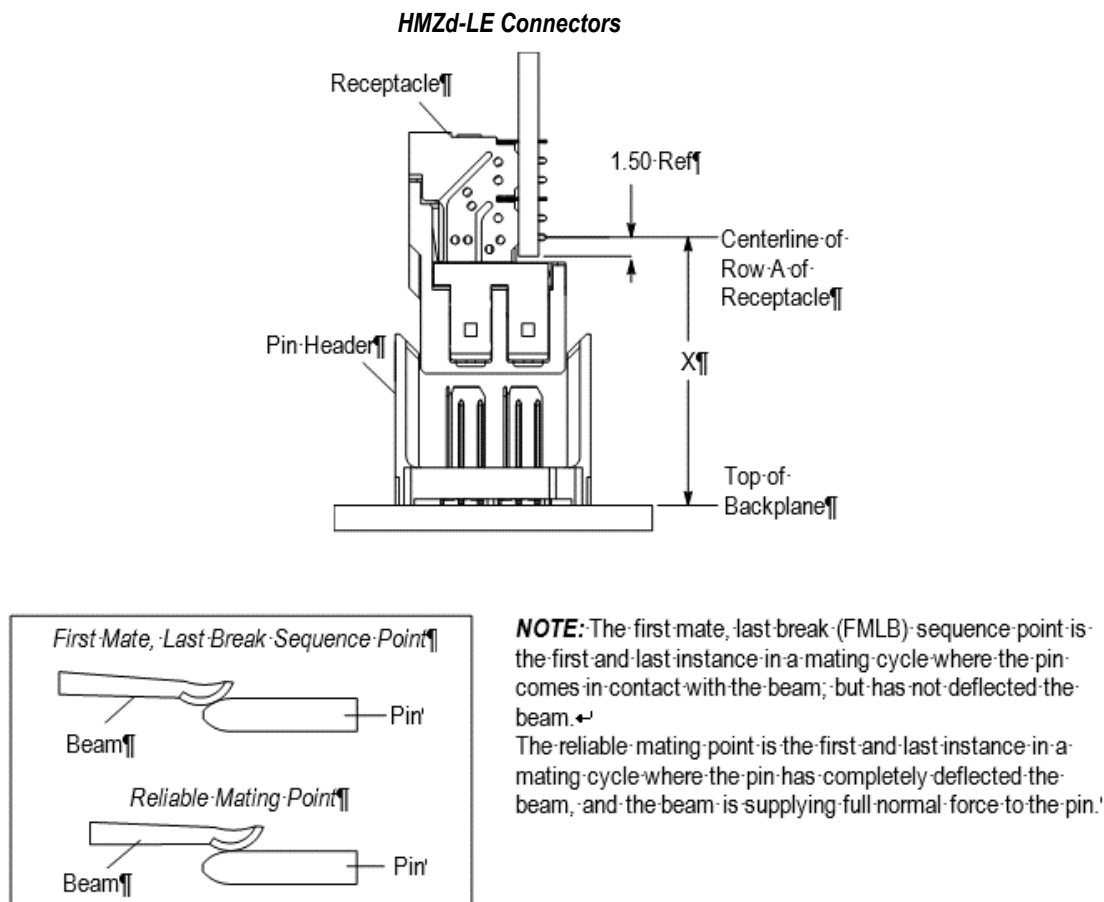
Figure 8

Telcordia is a trademark.

B. Sequencing

These connectors have three levels of sequencing during mating. The order of mating is: ground, signal pin Level 2, and signal pin Level 1. The mating sequences are the same throughout the 2-, 3-, and 4-pair connectors. The relative distances between sequencing events as a function of the distance between the top of the backplane and the centerline of Row A contact tails of the receptacle are given in Figure 9.

NOTE: 2-pair connectors shown; 3- and 4-pair connectors are the same for dimensioning purposes.



COMPONENT DESCRIPTION	DIMENSION X for HMZd-LE CONNECTORS	
	FMLB SEQUENCE POINT	RELIABLE MATING POINT
Ground Blades (Receptacle Ground Shield and Pin Header Ground Shield Engage)	19.05	18.28
Level 2 Signal Pins (Receptacle Twin Beam Contact and Pin Header Signal Pin Engage)	17.35	16.91
Level 1 Signal Pins (Receptacle Twin Beam Contact and Pin Header Signal Pin Engage)	15.85	15.41
Connector Fully Mated (Both Connectors are Fully Mated) See Figure 10	14.00	14.00

NOTE: All dimensions are calculated using nominal connector conditions. Connectors are assumed to be seated flush with the pc board.

Figure 9

C. Mating Dimensions

Full mating of connectors is necessary to ensure a good connection and to obtain the maximum signal transmission performance. The fully-mated dimension from the top surface of the pc board to which the pin header is mounted and the first row of contacts in the receptacle is given in Figure 10.

NOTE: 2-pair connectors shown; 3- and 4-pair connectors are the same for dimensioning purposes.

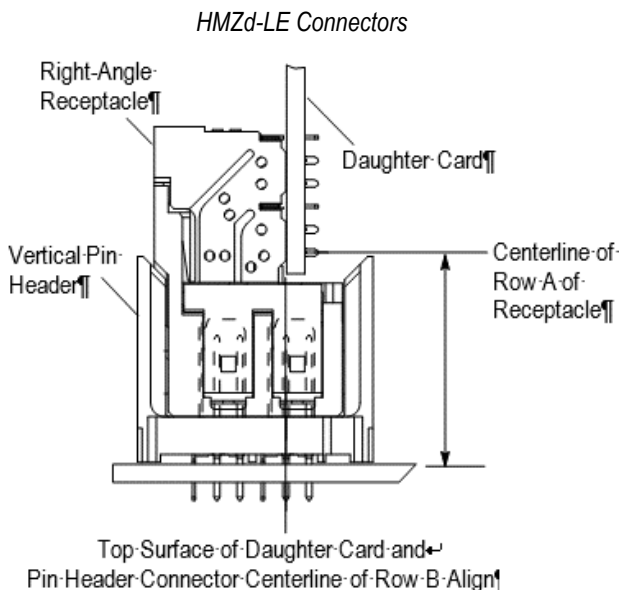


Figure 10

D. Contact Wipe Lengths

Connector contact wipe lengths are given in Figure 11.



NOTE

Wipe lengths are calculated by subtracting the reliable mating point data (given in Figure 9) from the fully mated connector condition (given in Figure 10).

COMPONENT	WIPE LENGTH (Dimension X = 14 Min or X = 14.6 Min)
Ground Blades	4.28
Level 2 Signal Pins	2.91
Level 1 Signal Pins	1.41

Figure 11

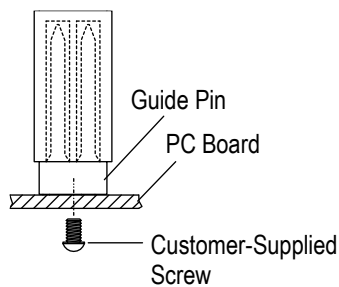
3.8. Accessories

Universal and universal keyed guide pins and modules and AdvancedTCA guide pins and modules are available for production and assembly needs.

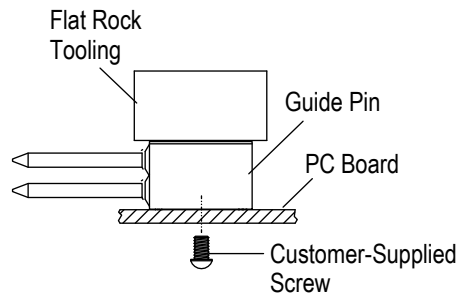
The guide pin and female guide module are designed to help connector alignment. Interaction of these two pieces of hardware provide error-free mating and prevents mating damage to the connector housings and contacts. They are also recommended for multi-connector, large and heavy daughter card applications and conditions where the misalignment tolerances shown in Figure 8 cannot be met. Insertion of the guide modules and pins into the pc boards must be applied with tooling capable of supplying a downward pressure between 222 and 667 N [50 and 150 lbs]. Refer to Figure 12 for customer-supplied seating tool dimensions.

Guide Pins

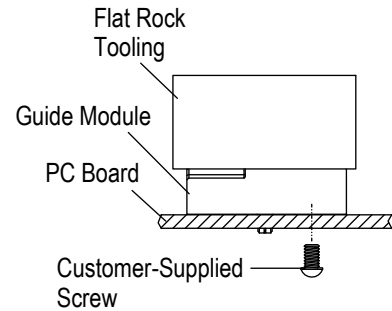
Vertical Guide Pin



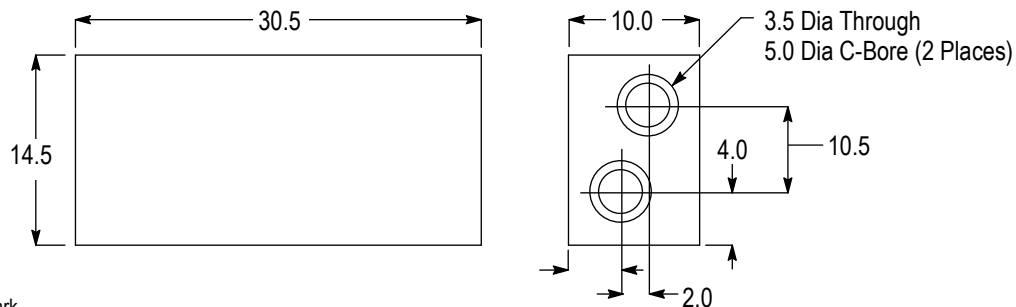
Right-Angle Guide Pin



Right-Angle Guide Module



Seating Tool Design Used for AdvancedTCA Vertical Guide Pin Module (Customer Supplied)



AdvancedTCA is a trademark.

Figure 12

3.9. Replacement and Repair



NOTE

To ensure plated through-hole integrity, connectors should only be replaced no more than two times or a max of three insertions per pc board. Tools for removing connectors from pc boards are provided in Section 5, TOOLING.

A. Pin Header

In cases where only signal pin contacts are in need of replacement, pin header assemblies can be repaired without removal from the pc board. For ground blade repair, the entire pin header must be removed from the backplane and replaced with a new pin header.

B. Receptacle

Receptacle construction does not allow for replacement of individual contacts or shields. Damaged receptacles must be completely replaced. Receptacles can be repaired by removing and replacing only the damaged connector module.

4. QUALIFICATIONS

Z-PACK HMZd-LE Connector Systems are Recognized by Underwriters Laboratories Inc. (UL) in File E28476, Vol. 54.

5. TOOLING

Tooling part numbers and instructional material packaged with the tooling are given in Figure 13.



NOTE

Tooling engineers have designed machines for a variety of application requirements. For assistance in setting up prototype and production line equipment, call the PRODUCT INFORMATION number at the bottom of page 1.

5.1. PC Board Support

A pc board support must be used to prevent bowing of the pc board during the seating of a connector onto the board. It should have a flat surface with holes or a channel wide and deep enough to receive any contacts that may protrude below the pc board surface during seating of the connector.

5.2. Seating Tools

Seating tools have been designed to push on the contacts and seat the connector on the pc board. The tool will prevent contacts from backing out of the housing and prevent damage to the housing. The seating tool must be used with application tool or power unit.

5.3. Power Units

Power units are automatic or semi-automatic machines used to assist in the application of a product. These power units supply the necessary force onto a seating tool used to seat the connector onto the pc board.

i NOTE
For application assistance concerning proper sizing of power units, contact the Automation Group at (215) 657-6202.

5.4. Arbor Frame Assembly

Manual arbor frame assemblies are used to exert a downward force onto a seating tool used to seat the connector onto the pc board.

5.5. Extraction Tools

Extraction tools and removal tools are designed to remove individual contacts from the connector or pc board, or housings from the pc board without damaging any other components.

5.6. Insertion Tools

Insertion tools are designed for inserting individual contacts into the connector or pc board, and seating tools are designed for seating guide pins and modules or connector assemblies onto the pc board without damaging or touching other components.

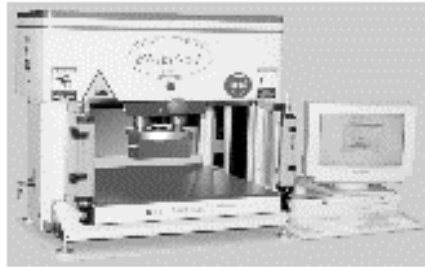
HMZd-LE CONNECTOR		BOARD-TO-BOARD TOOLING (Document)				
SIZE	TYPE	SEATING TOOL (Used in All Power Units Listed in Figure 13)	REPAIR TOOL			
			HOUSING REMOVAL	PIN EXTRACTION	PIN INSERTION	CHICKLET REMOVAL
2-Pair	Right-Angle Receptacle	91350-[] (408-8500)	1583224-[] (408-8644)	---	---	1583249-1 (408-8647)
	Vertical Pin Header	91348-[] (408-8501)	1583234-1 (408-8645)	1583237-1 (408-8646)	1583255-1 (408-8648)	---
3-Pair	Right-Angle Receptacle	91376-1 (408-8500)	1583224-[] (408-8644)	---	---	1673952-1
	Vertical Pin Header	91375-1 (408-8501)	1725634-1 (408-8645)	1583237-1 (408-8646)	1583255-1 (408-8648)	---
4-Pair	Right-Angle Receptacle	91347-1 (408-8500)	1583224-[] (408-8644)	---	---	1583248-1 (408-8647)
	Vertical Pin Header	91349-[] (408-8501)	1583220-1 (408-8645)	1583237-1 (408-8646)	1583255-1 (408-8648)	---

NOTE: All seating tools are interchangeable between HMZd and HMZd plus connectors. Housings and chicklet removal and repair tools may only be used for HMZd connectors.

Figure 13 (cont'd)



Model AP3 Machine
1585280-1



Model BMEP 5T Machine
1585696-1



Model MEP 6T Machine
1585699-1

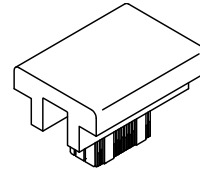
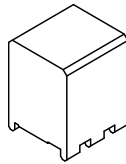
Not Shown:

Model BMEP 2K Machine 1585732-2

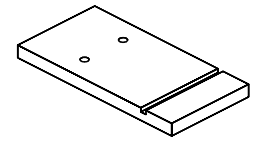
Model BMEP 3T Machine 1585697-1

Model MEP 12T Machine 1585698-1

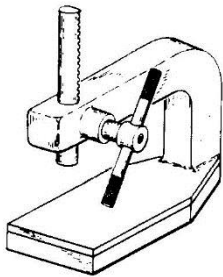
Model AEP 12T Machine 1-1399600-7



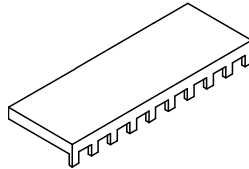
Typical Pin Header
Seating Tool
(See Table)



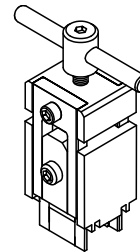
PC Board Support
(Must be Custom Made)



Manual Arbor Frame
Assembly
(Commercially Available)



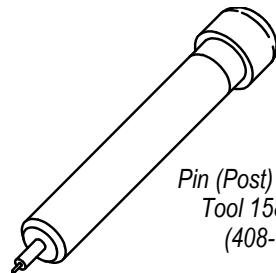
Receptacle Housing
Removal Tool 1583224-1
(408-8644)



Typical Pin Header
Removal Tool
(See Table)



Typical Chicklet Removal
Tool (See Table)



Pin (Post) Extraction
Tool 1583237-1
(408-8646)

Pin (Post) Insertion Tool
1583255-1
(408-8648)

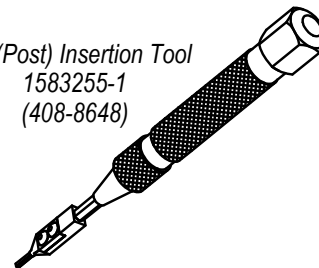


Figure 14 (end)

6. VISUAL AID

The illustration below shows a typical application of this product. This illustration should be used by production personnel to ensure a correctly applied product. Applications which do not appear correct should be inspected using the information in the preceding pages of this specification and in the instructional material shipped with the product or tooling.

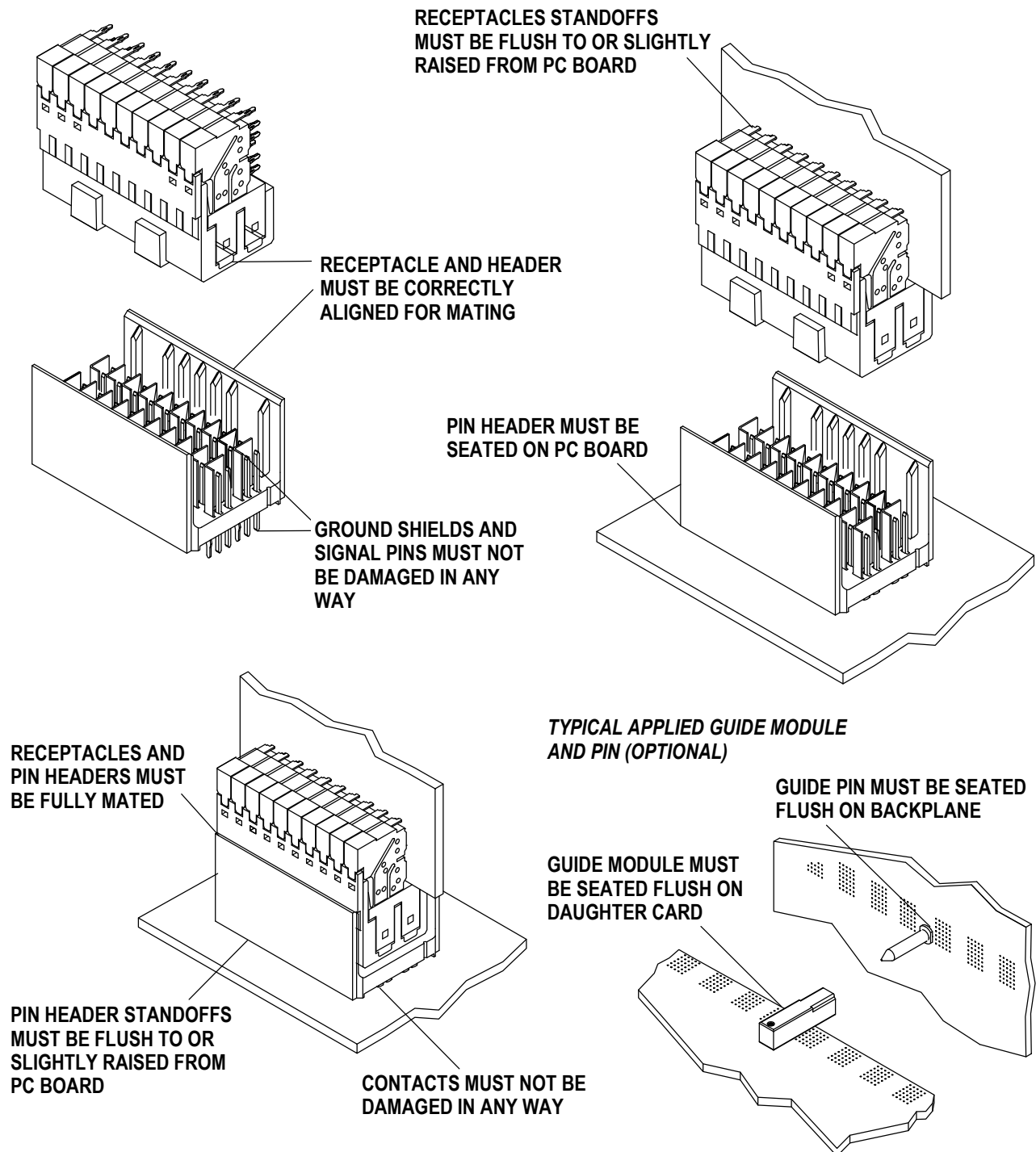


FIGURE 14. VISUAL AID