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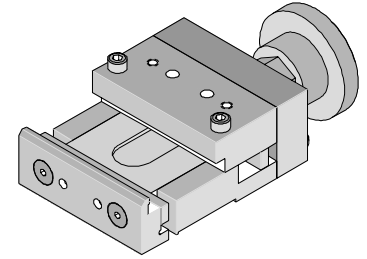
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**VHDM-HSD™ Daughter Card  
Stiffener Removal Tool  
Instruction Sheet  
Part No. 62201-6215**



**FEATURES**

- This tool is designed for removal and reinstallation of the metal stiffeners to the connector module for the purpose of repairing a wafer or power module. Refer to VHDM-HSD™\* Tooling Manual 62201-0999 for the other repair tools and full repair procedure.

**SCOPE**

Products: VHDM-HSD™\* Connector System for (5-Row) 74670 series. See Product List below for specific part numbers.

\*VHDM-HSD™ is a registered trademark of Amphenol Corporation.

**Product List**

The following is a partial list of the product order numbers and their specifications this tool is designed to run. Updates to this list are available on [www.molex.com](http://www.molex.com).

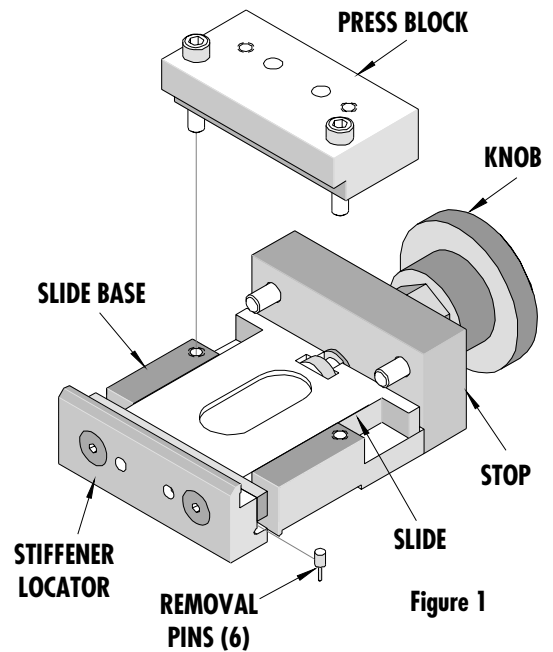
Assembly Series No. And Description	Assembly Order No.							
74670 5-Row VHDM-HSD™ Daughtercard	74670-0001	74670-0074	74670-0120	74670-0205	74670-0263	74670-0322	74670-0373	74670-0434
	74670-0003	74670-0075	74670-0121	74670-0206	74670-0264	74670-0323	74670-0374	74670-0435
	74670-0008	74670-0076	74670-0122	74670-0207	74670-0266	74670-0324	74670-0375	74670-0438
	74670-0009	74670-0077	74670-0123	74670-0208	74670-0267	74670-0325	74670-0376	74670-0439
	74670-0010	74670-0078	74670-0124	74670-0212	74670-0268	74670-0326	74670-0377	74670-0440
	74670-0011	74670-0079	74670-0125	74670-0213	74670-0269	74670-0327	74670-0378	74670-9954
	74670-0012	74670-0080	74670-0128	74670-0214	74670-0270	74670-0328	74670-0379	74670-9955
	74670-0013	74670-0081	74670-0129	74670-0215	74670-0272	74670-0329	74670-0382	74670-9956
	74670-0014	74670-0082	74670-0135	74670-0226	74670-0278	74670-0330	74670-0384	74670-9977
	74670-0022	74670-0084	74670-0137	74670-0227	74670-0282	74670-0331	74670-0385	74670-9979
	74670-0023	74670-0086	74670-0138	74670-0228	74670-0285	74670-0332	74670-0390	74670-9981
	74670-0024	74670-0087	74670-0144	74670-0229	74670-0286	74670-0333	74670-0392	74670-9982
	74670-0025	74670-0090	74670-0145	74670-0230	74670-0288	74670-0335	74670-0393	74670-9983
	74670-0027	74670-0091	74670-0152	74670-0231	74670-0289	74670-0336	74670-0394	74670-9984
	74670-0029	74670-0092	74670-0156	74670-0232	74670-0291	74670-0338	74670-0395	74670-9985
	74670-0033	74670-0093	74670-0162	74670-0233	74670-0292	74670-0341	74670-0396	74670-9986
	74670-0034	74670-0100	74670-0163	74670-0234	74670-0293	74670-0342	74670-0397	74670-9987
	74670-0036	74670-0101	74670-0164	74670-0235	74670-0294	74670-0344	74670-0398	74670-9988
	74670-0037	74670-0102	74670-0167	74670-0236	74670-0295	74670-0345	74670-0399	74670-9989
	74670-0041	74670-0103	74670-0169	74670-0239	74670-0300	74670-0346	74670-0406	74670-9991
	74670-0042	74670-0104	74670-0170	74670-0240	74670-0301	74670-0347	74670-0407	74670-9992
	74670-0043	74670-0106	74670-0171	74670-0243	74670-0302	74670-0348	74670-0408	74670-9993
	74670-0044	74670-0107	74670-0172	74670-0244	74670-0303	74670-0349	74670-0410	74670-9995
	74670-0045	74670-0108	74670-0178	74670-0245	74670-0304	74670-0350	74670-0411	
	74670-0046	74670-0109	74670-0179	74670-0246	74670-0305	74670-0351	74670-0412	
	74670-0054	74670-0110	74670-0180	74670-0247	74670-0306	74670-0352	74670-0417	
	74670-0059	74670-0111	74670-0181	74670-0248	74670-0307	74670-0353	74670-0418	
	74670-0060	74670-0112	74670-0182	74670-0249	74670-0308	74670-0355	74670-0419	
	74670-0061	74670-0113	74670-0184	74670-0250	74670-0309	74670-0363	74670-0420	
	74670-0062	74670-0114	74670-0185	74670-0256	74670-0310	74670-0364	74670-0422	
	74670-0063	74670-0115	74670-0186	74670-0257	74670-0317	74670-0365	74670-0423	

74670 5-Row VHDM-HSD™ Daughtercard	74670-0064	74670-0116	74670-0198	74670-0258	74670-0318	74670-0366	74670-0427	
	74670-0071	74670-0117	74670-0199	74670-0259	74670-0319	74670-0367	74670-0429	
	74670-0072	74670-0118	74670-0200	74670-0260	74670-0320	74670-0370	74670-0430	
	74670-0073	74670-0119	74670-0201	74670-0262	74670-0321	74670-0371	74670-0433	

## DESCRIPTION

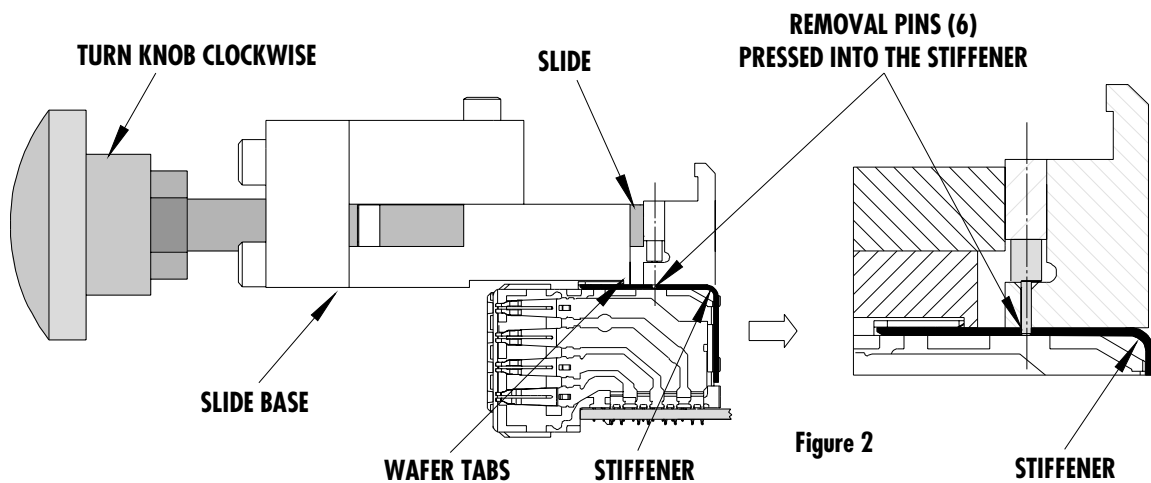
The VHDM-HSD™ Daughter Card Connector consists of a metal stiffener that combines modular signal wafers, power modules, and guidance modules to create one custom assembly that is assigned a custom part.

The VHDM-HSD™ 5 Row Daughter Card Stiffener Removal Tool consists of slide base, stiffener locator to push the metal stiffener away from the connector assembly, and a clamp knob to actuate the stiffener locator block so the metal stiffener can be removed from the module assembly



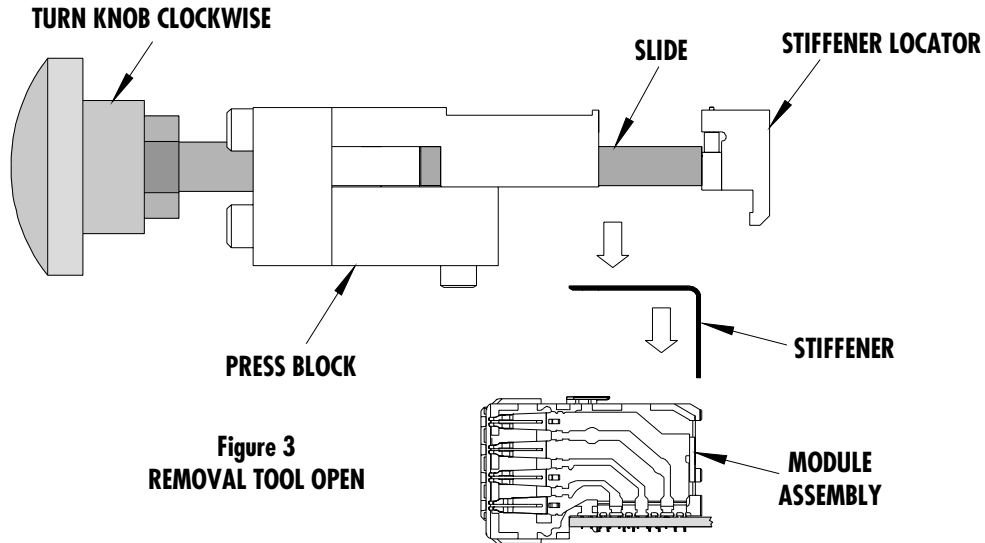
### Metal Stiffener Removal

1. Place the small removal pins that are in the stiffener locator into the round holes in the metal stiffener. Align the slide base with the step on the tool against the wafer tabs that protrude through the stiffener.
2. Rotate the knob clockwise (CW) to position the step on the slide base so it will push against the wafer tabs. Continue turning the knob so the metal stiffener will be pushed off the wafers. See Figure 2.
3. If the connector is long enough, it may be necessary to work the stiffener loose by moving the removal tool from one end of the connector to the other until the metal stiffener can be easily removed.
4. The metal stiffener should now be free of the wafer modules and any damaged wafer can be replaced.

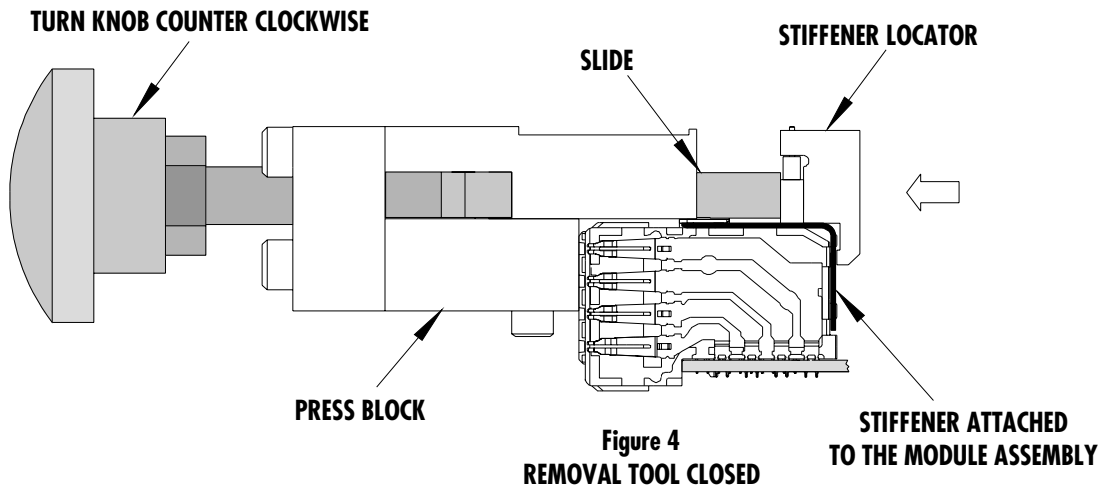


### Metal Stiffener Replacement

1. When all the damaged wafers have been repaired the metal stiffener can be reattached to the module assembly.
2. To do this, align the metal stiffener in the proper position with all individual modules. See Figure 3. Push metal stiffener onto the modules.



3. After the metal stiffener is positioned correctly on the module assembly, orient the Stiffener Removal Tool and rotate tool as shown in Figure 4. The installation of the metal stiffener utilizes the opposite side of the tool.
4. Position the tool so it will fit over the module assembly. Turn the knob in either direction allowing the tool to open or close enough so the module assembly fits between the press block and the stiffener locator. The stiffener locator should butt up against the metal stiffener. See Figure 4.



5. Turn the knob on the tool counter clockwise (CCW) so the stiffener locator moves toward the press block. With the module assembly in between the two, the metal stiffener will be seat properly.
6. Do not turn knob excessively. When the knob becomes difficult to turn, this is an indication that the stiffener is seated fully

## Maintenance

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

1. Remove dust, moisture, and other contaminants with a clean brush, or soft, lint free cloth.
2. Do not use any abrasive materials that could damage the tool.
3. Make certain all pins; pivot points and bearing surfaces are protected with a thin coat of high quality machine oil. Do not oil excessively.
4. When tool is not in use, store in a clean, dry area.

**CAUTION:** Molex specifications are valid only when used with Molex connectors and tooling.

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**PARTS LIST**

Item	Order No	Description	Quantity
	62201-6215	VHDM-HSD™ Stiffener Removal Tool	(Figure 6)
1	62201-6202	Slide	1
2	62201-6203	Slide Base	1
3	62201-6204	Stop	1
4	62201-6405	Press Block	1
5	62201-6406	Press Screw	1
6	62201-6210	Stiffener Locator	1
7	62201-6211	Pin Spacer	1
8	62202-2624	Removal Pin	6
9	63700-1936	Knob, Plastic	1
10	N/A	#6-32 by 3/4" Long SHCS	**2
11	N/A	#6-32 by 1.0" Long FHCS	**2
12	N/A	#8-32 by 3/4" Long SHCS	**4
13	N/A	#5/16-18" Hex Nut	**1
14	N/A	1/8" by 1/2" Long Dowel Pin	**2

\*\* Available from an industrial supply company such as MSC (1-800-645-7270).

**Assembly Drawing**

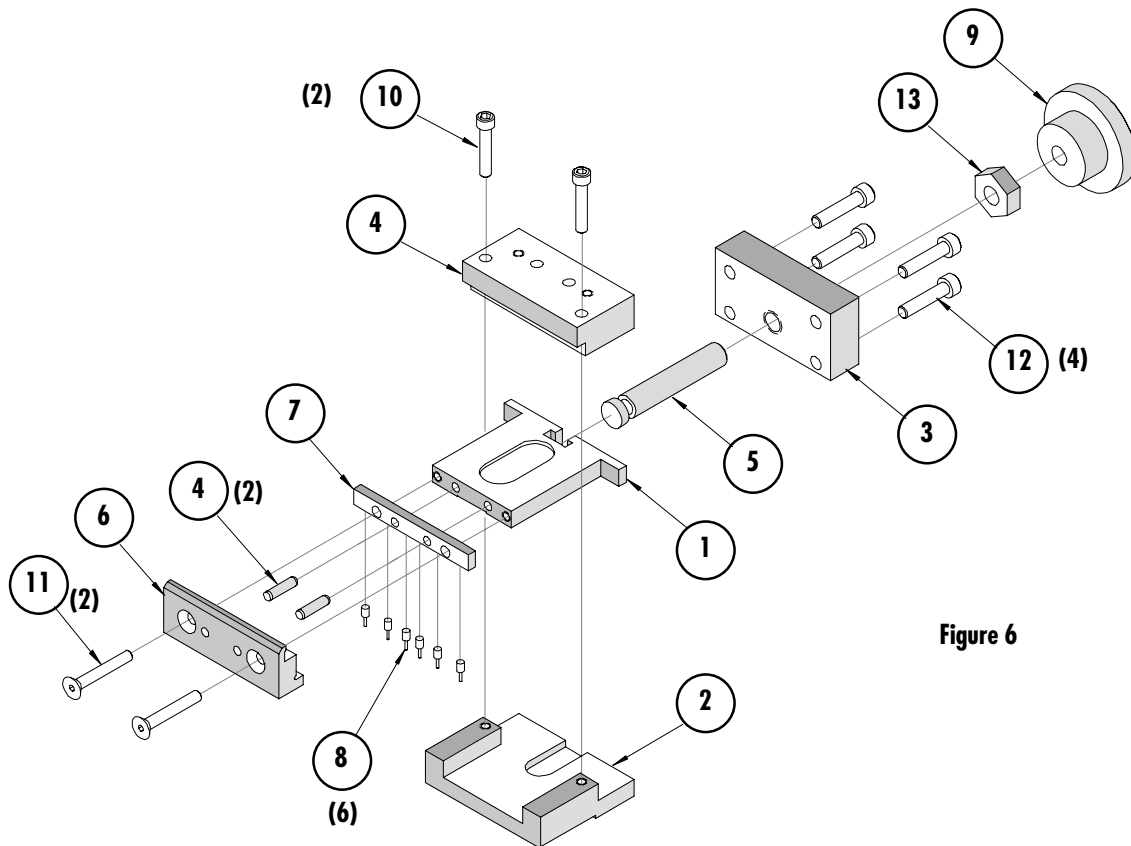


Figure 6