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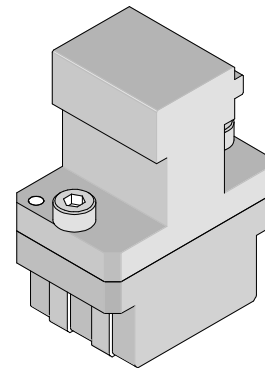
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**Impact™ Backplane Module Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8731**



FEATURES

- Polarized tool prevents product damage
- Tool provides uniform distribution of press force across entire pin array
- May be used as a stand-alone tool or mounted in an optional holder with other Molex press-in tools

SCOPE

Products: Impact™ Backplane Signal Module Assembly, 76775 Series, (5-Pair by 10 Column 85 Ohm Assemblies). See Product List below for specific part numbers.

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.

5 Pair 76775 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open Wall	10	76775-0104	76775-0105	76775-0107	76775-0108		
		76775-1104	76775-1105	76775-1107	76775-1108		
		76775-1133	76775-1134	76775-1135	76775-1135	76775-1137	76775-1138
Left Guided	10	76775-2104	76775-2105	76775-2107	76775-2108	76775-2114	76775-2115
		76775-2117	76775-2118	76775-2124	76775-2125	76775-2127	76775-2128
		76775-2134	76775-2135	76775-2137	76775-2138	76775-2144	76775-2145
		76775-2147	76775-2148	76775-2154	76775-2155	76775-2157	76775-2158
		76775-2164	76775-2165	76775-2167	76775-2168	76775-2174	76775-2175
		76775-2177	76775-2178	76775-2184	76775-2185	76775-2187	76775-2188
		76775-3104	76775-3105	76775-3107	76775-3108	76775-3114	76775-3115
		76775-3117	76775-3118	76775-3124	76775-3125	76775-3127	76775-3128
		76775-3134	76775-3135	76775-3137	76775-3138	76775-3144	76775-3145
		76775-3147	76775-3148	76775-3154	76775-3155	76775-3157	76775-3158
		76775-3164	76775-3165	76775-3167	76775-3168	76775-3174	76775-3175
		76775-3177	76775-3178	76775-3184	76775-3185	76775-3187	76775-3188
		76775-6104	76775-6105	76775-6107	76775-6108	76775-6114	76775-6115
		76775-6117	76775-6118	76775-6124	76775-6125	76775-6127	76775-6128
		76775-6134	76775-6135	76775-6137	76775-6138	76775-6144	76775-6145
		76775-6147	76775-6148	76775-6154	76775-6155	76775-6157	76775-6158
		76775-6164	76775-6165	76775-6167	76775-6168	76775-6174	76775-6175
		76775-6177	76775-6178	76775-6184	76775-6185	76775-6187	76775-6188
		76775-7104	76775-7105	76775-7107	76775-7108	76775-7114	76775-7115
		76775-7117	76775-7118	76775-7124	76775-7125	76775-7127	76775-7128
		76775-7134	76775-7135	76775-7137	76775-7138	76775-7144	76775-7145
76775-7147	76775-7148	76775-7154	76775-7155	76775-7157	76775-7158		
76775-7164	76775-7165	76775-7167	76775-7168	76775-7174	76775-7175		
76775-7177	76775-7178	76775-7184	76775-7185	76775-7187	76775-7188		
Right Guided	10	76775-4104	76775-4105	76775-4107	76775-4108	76775-4114	76775-4115

5 Pair 76775 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Right Guided	10	76775-4117	76775-4118	76775-4124	76775-4125	76775-4127	76775-4128
		76775-4134	76775-4135	76775-4137	76775-4138	76775-4144	76775-4145
		76775-4147	76775-4148	76775-4154	76775-4155	76775-4157	76775-4158
		76775-4164	76775-4165	76775-4167	76775-4168	76775-4174	76775-4175
		76775-4177	76775-4178	76775-4184	76775-4185	76775-4187	76775-4188
		76775-5104	76775-5105	76775-5107	76775-5108	76775-5114	76775-5115
		76775-5117	76775-5118	76775-5124	76775-5125	76775-5127	76775-5128
		76775-5134	76775-5135	76775-5137	76775-5138	76775-5144	76775-5145
		76775-5147	76775-5148	76775-5154	76775-5155	76775-5157	76775-5158
		76775-5164	76775-5165	76775-5167	76775-5168	76775-5174	76775-5175
		76775-5177	76775-5178	76775-5184	76775-5185	76775-5187	76775-5188
		76775-8104	76775-8105	76775-8107	76775-8108	76775-8114	76775-8115
		76775-8117	76775-8118	76775-8124	76775-8125	76775-8127	76775-8128
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		76775-9104	76775-9105	76775-9107	76775-9108	76775-9114	76775-9115
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		76775-9134	76775-9135	76775-9137	76775-9138	76775-9144	76775-9145
		76775-9147	76775-9148	76775-9154	76775-9155	76775-9157	76775-9158
		76775-9164	76775-9165	76775-9167	76775-9168	76775-9174	76775-9175
		76775-9177	76775-9178	76775-9184	76775-9185	76775-9187	76775-9188

Tool Setup

Depending on the number of connectors to be installed and/or the press used, this tool can be used alone or with a group of press-in tools, mounted in a 62201-95XX rail (ordered separately). See Figure 1.

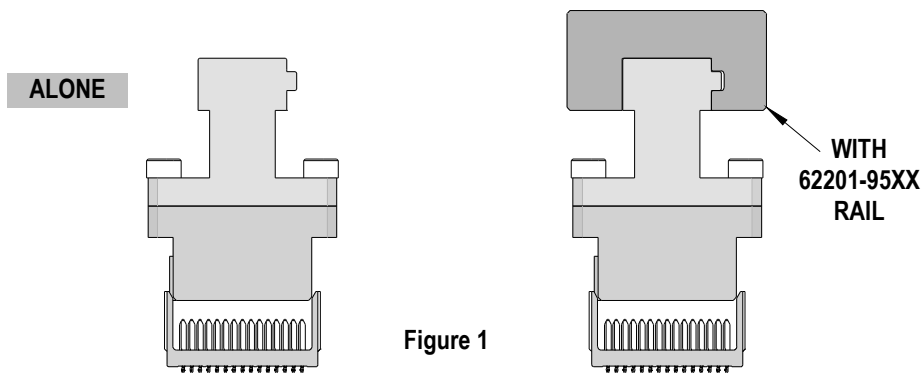


Figure 1

Tool Installation

The 62201-95XX rail is available in a variety of lengths to accommodate multiple press-in tools.

Rail Part Number	Rail Overall Length
62201-9501	24mm (0.94 in)
62201-9502	72mm (2.83 in)
62201-9503	156mm (6.14 in)
62201-9504	216mm (8.50 in)
62201-9509	254mm (10.0 in)
62201-9511	305mm (12.0 in)

Reference: This Press-In Tool is 18.8mm (0.74 in.) long.

Printed Circuit Board (PCB) Support

The Impact™ connectors require up to 3.6kg (8 lb) of force per pin to press into the PCB. To prevent excessive PCB flexure and/or damage to the PCB, a support plate is strongly recommended directly beneath the connector hole pattern.

Due to the custom nature of every application, Molex does not offer any PCB support plate. The customer must furnish their own support plate.

When creating the PCB support plate, remember to allow clearance for the connector pins as they pass through the PCB thickness.

Press Equipment Recommendations

Many types of presses can be used to install Impact™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press stroke must be at least 19mm (0.75 in).
5. For statistical purposes, automatic collection of force and distance data.

Tool Operation

1. Insert by hand the backplane signal module assembly (s) carefully into the PCB hole pattern. Make sure the connector(s) are oriented properly by confirming the location of the #1 circuit notch with respect to the PCB layout.
2. Insert the Press-In Tool making sure that the notch in this tool is inserted into the slot on top of the connector housing of the backplane signal module assembly. See Figure 2.
3. Using the application tool and an appropriate press, seat the header assembly until there is less than 0.25mm (0.01 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.

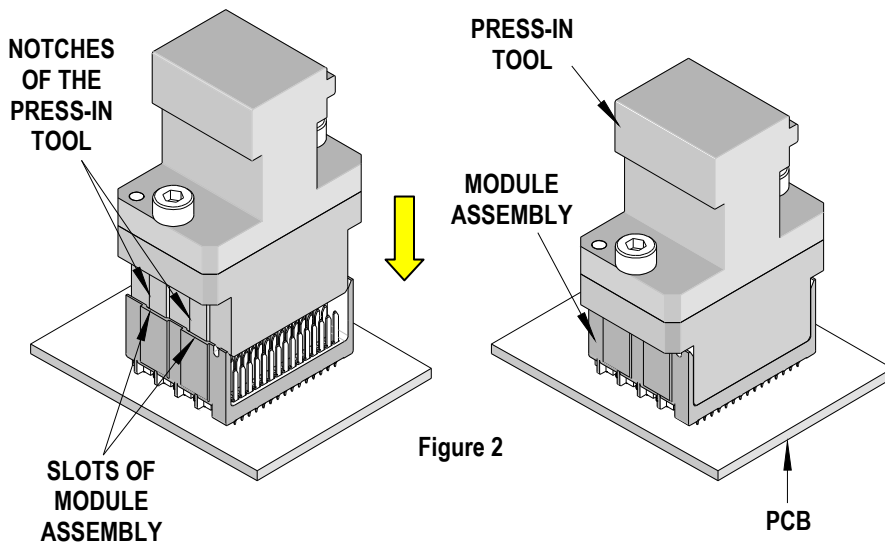
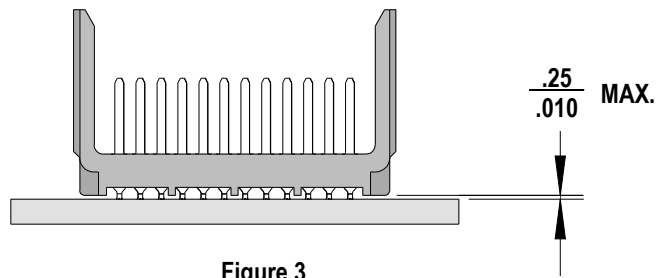


Figure 2



There should be no broken stand-offs along the perimeter of the part (an indication of over-pressing).

CAUTION: To prevent injury, never operate any press without the guards in place. Refer to the press manufacturer's instruction manual.

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

Contact Information

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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