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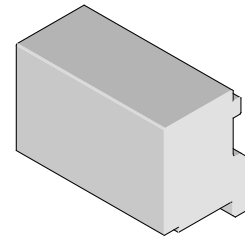
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**Impact™
Daughtercard
Module Installation
Press-In Tool**

molex

**Application Tooling
Specification Sheet**



Order No. 62201-8779

FEATURES

- Lip provided for positive alignment to connector assembly.
- 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™ 100Ω Right Angle Daughtercard Signal Module and Impact™ RAM Signal Module Assembly, (2-Pair by 16 Column Assemblies). See Product List below for specific part numbers.

Product List

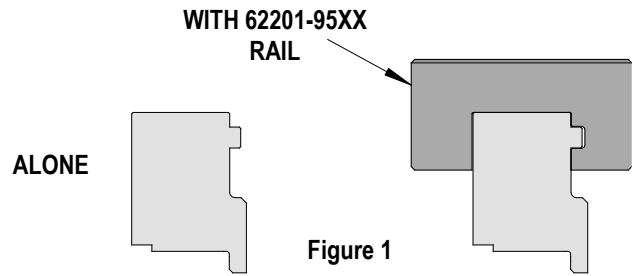
The following is a partial list of the product order numbers and their specifications this tool is designed to run. Updates to this list are available on www.molex.com.

Series No.	Guide Style	Columns	Assembly Order Number					
76450 Ram	Open	16	76450-0604	76450-0605	76450-0607	76450-0608	76450-1604	76450-1605
			76450-1607	76450-1608				
	Left	16	76450-0614	76450-0615	76450-0617	76450-0618	76450-1614	76450-1615
			76450-1617	76450-1618				
	Dual Wall	16	76450-0624	76450-0625	76450-0627	76450-0628	76450-1624	76450-1625
			76450-1627	76450-1628				
	Right	16	76450-0634	76450-0635	76450-0637	76450-0638	76450-1634	76450-1635
			76450-1637	76450-1638				
	Left Guided	16	76450-2604	76450-2605	76450-2607	76450-2608	76450-3104	76450-3105
			76450-3607	76450-3608	76450-6604	76450-6605	76450-6107	76450-6108
			76450-7604	76450-7605	76450-7607	76450-7608		
	Right Guided	16	76450-4604	76450-4605	76450-4607	76450-4608	76450-5604	76450-5605
76450-5607			76450-5608	76450-8604	76450-8605	76450-8607	76450-8608	
76450-9604			76450-9605	76450-9607	76450-9608			
76460 100Ω	Open	16	76460-0016	76460-0026	76460-1016	76460-1026		
	Left	16	76460-2016	76460-2026	76460-3016	76460-3026		
	Right	16	76460-4016	76460-4026	76460-5016	76460-5026		
170026 Ram	Custom	16	170026-2600	170026-2601	170026-3600	170026-3601	170026-6600	170026-6601
			170026-7600	170026-7601	170026-9003	170026-9960	170026-9980	
170470	Open	16	170470-1604	170470-1605	170470-1607	170470-1608		
	Left	16	170470-1614	170470-1615	170470-1617	170470-1618		
	Dual Wall	16	170470-1624	170470-1625	170470-1627	170470-1628		
			170470-1634	170470-1635	170470-1637	170470-1638		
	Left Guided	16	170470-3604	170470-3605	170470-3607	170470-3608		
			170470-7604	170470-7605	170470-7607	170470-7608		
	Right Guided	16	170470-5604	170470-5605	170470-5607	170470-5608		
			170470-9604	170470-9605	170470-9607	170470-9608		

Series No.	Guide Style	Columns	Assembly Order Number				
172101 Ram	Open	16	172101-1016	172101-1026			
	Left Guided		172101-3016	172101-3026			
	Right Guided		172101-5016	172101-5026			

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.



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 30.3mm (1.19 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.

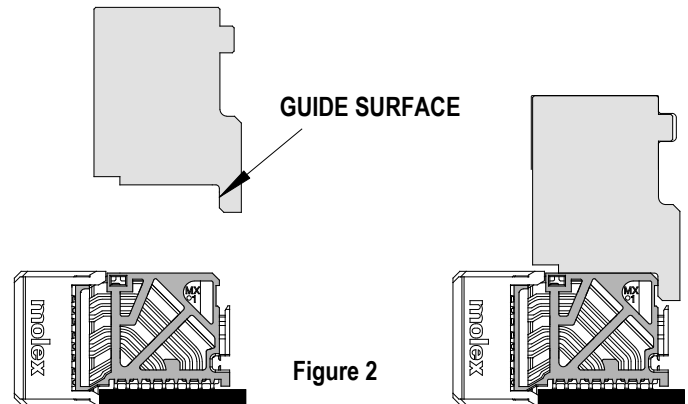
Press Equipment Recommendations

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

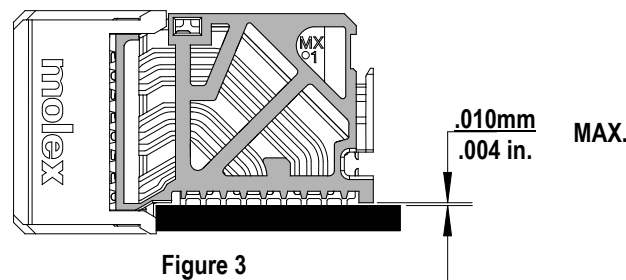
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press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

Tool Operation

1. Carefully insert, by hand, the Daughtercard module(s) into the PCB hole pattern.
2. Place the application tool on top of the Daughtercard module with the back guide surface of the tool against the back of the Daughtercard module. See Figure 2.



3. Using the application tool and an appropriate press, seat the Daughtercard module 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.



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.

Visit our Website at <http://www.molex.com>