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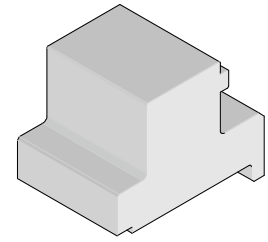
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**Impact™
Daughtercard
Module Installation
Press-In Tool**

molex

**Application Tooling
Specification Sheet**



Order No. 62201-8893

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™ Daughtercard Signal Module Assembly and Daughtercard Orthogonal Assembly, (5-Pair by 8 Column Assemblies). See Product List below for specific part numbers.

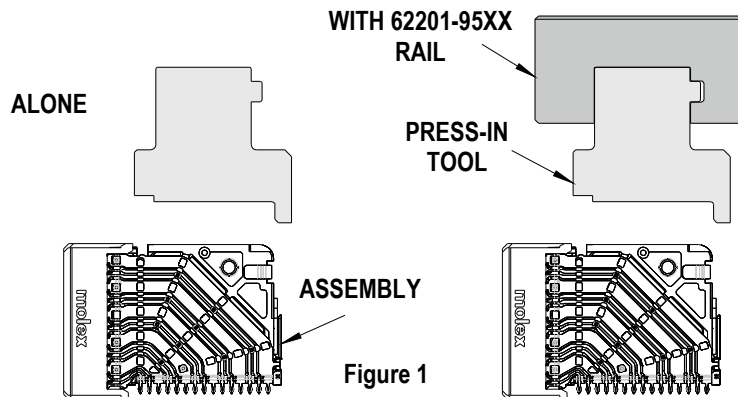
Product List

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	5 Pair Assembly Order Number					
170480	Unguided	8	170480-1008	170480-1038				
	Left	8	170480-3008	170480-3038	170480-3058	170480-3068	170480-3108	170480-3138
			170480-3158	170480-3168	170480-3208	170480-3238	170480-3258	170480-3268
			170480-3308	170480-3338	170480-3358	170480-3368	170480-3408	170480-3438
			170480-3458	170480-3468	170480-3508	170480-3538	170480-3558	170480-3568
			170480-3608	170480-3638	170480-3658	170480-3668	170480-3708	170480-3738
			170480-3758	170480-3768	170480-3808	170480-3838	170480-3858	170480-3868
	Right	8	170480-5008	170480-5038	170480-5058	170480-5068	170480-5108	170480-5138
			170480-5158	170480-5168	170480-5208	170480-5238	170480-5258	170480-5268
			170480-5308	170480-5338	170480-5358	170480-5368	170480-5408	170480-5438
			170480-5458	170480-5468	170480-5508	170480-5538	170480-5558	170480-5568
			170480-5608	170480-5638	170480-5658	170480-5668	170480-5708	170480-5738
			170480-5758	170480-5768	170480-5808	170480-5838	170480-5858	170480-5868

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 (08.0 in)
62201-9511	305mm (12.0 in)

Reference: This Press-In Tool is 15mm (0.59 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.

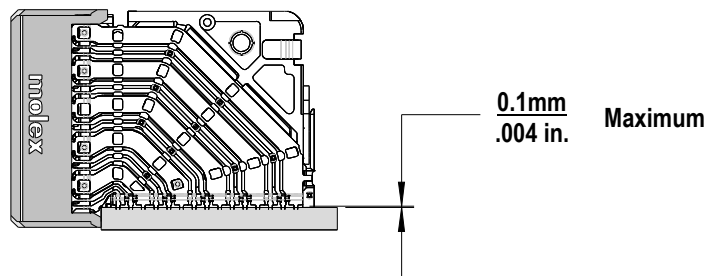
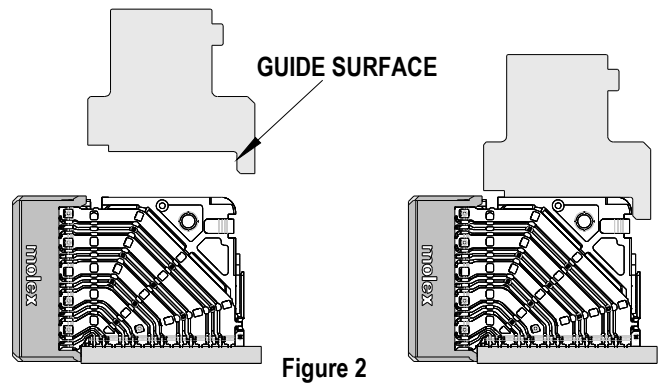
Press Equipment Recommendations

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 (08 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 (0.008 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 0.1mm (.004 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.

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