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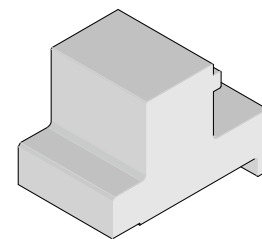
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**Impel
Daughtercard
Module Installation
Press-In Tool**

**Application Tooling
Specification Sheet**



Order No. 62201-8961

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: Impel 2.35mm Orthogonal Daughtercard Assembly, Orthogonal Direct RAM Assembly, and standard RAM Assembly (6-Pair by 12 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					
171500	Unguided	12	171500-1022					
	Left	12	171500-3022	171500-3122	171500-3222	171500-3322	171500-3422	171500-3522
			171500-3622	171500-3722	171500-3822			
	Right	12	171500-5022	171500-5122	171500-5222	171500-5322	171500-5422	171500-5522
			171500-5622	171500-5722	171500-5822			
	171740	Unguided	12	171740-1207	171740-1208			
172130	Unguided	12	172130-1207	172130-1208				
	Left	12	172130-3207	172130-3208	172130-3217	172130-3218	172130-3227	172130-3228
			172130-3237	172130-3238	172130-3247	172130-3248	172130-3257	172130-3258
			172130-3267	172130-3268	172130-3277	172130-3278	172130-3287	172130-3288
	Right	12	172130-5207	172130-5208	172130-5217	172130-5218	172130-5227	172130-5228
			172130-5237	172130-5238	172130-5247	172130-5248	172130-5257	172130-5258
172130-5267			172130-5268	172130-5277	172130-5278	172130-5287	172130-5288	

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.

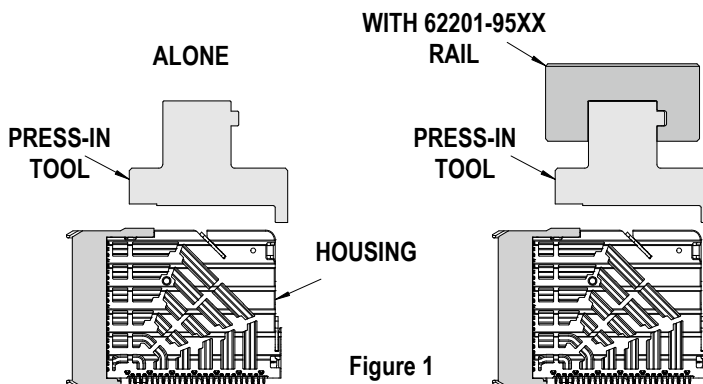


Figure 1

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 28mm (1.10 in.) long.

Printed Circuit Board (PCB) Support

The Impel 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.

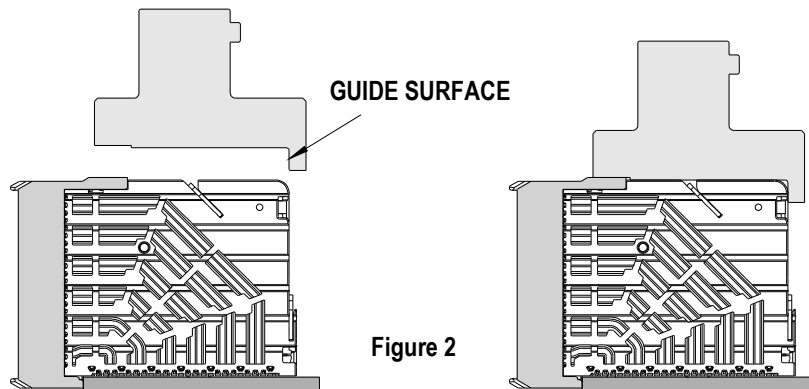
Press Equipment Recommendations

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

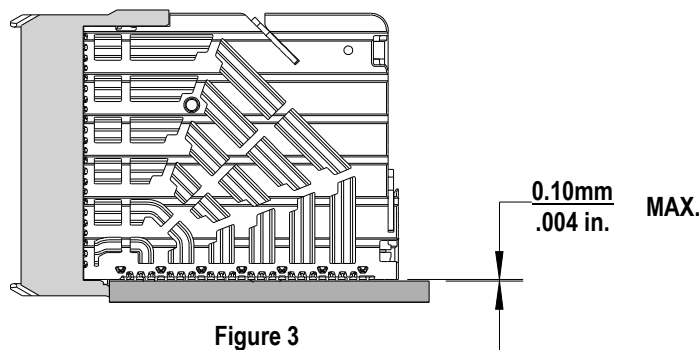
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press 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 0.10mm (.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.

Contact Information

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

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