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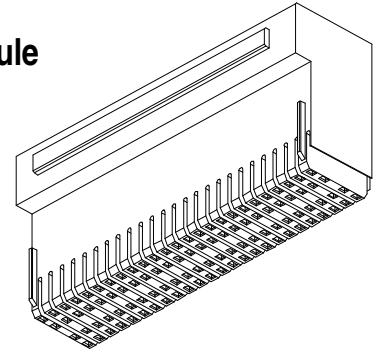
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***VHDM-HSD™ Backplane Signal Insertion Module
Application Tooling Specification
Press-In Tool
Order No. 62202-0202**



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 tooling holder with other Molex press-in tools.

SCOPE

Products: *VHDM-HSD™ Standard Shield Signal Module Assembly, (100 Circuits), 74695, 74696, 74697, and 74702 Series 5 Rows by 25 Columns 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.

74695 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	5	74695-2501	74695-2502	74695-2503	74695-2504	74695-2506	74695-2507
		74695-2508	74695-2509				
		74695-2601	74695-2602	74695-2603	74695-2604	74695-2606	74695-2607
		74695-2608	74695-2609				
		74695-8501	74695-8502	74695-8503	74695-8504	74695-8506	74695-8507
		74695-8508	74695-8509				

74696 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	5	74696-2501	74696-2502	74696-2503	74696-2504	74696-2506	74696-2507
		74696-2508	74696-2509	74696-2511	74696-2512	74696-2513	74696-2514
		74696-2516	74696-2517	74696-2518	74696-2519	74696-2521	74696-2522
		74696-2523	74696-2524	74696-2526	74696-2527	74696-2528	74696-2529
		74696-2531	74696-2532	74696-2533	74696-2534	74696-2536	74696-2537
		74696-2538	74696-2539	74696-2541	74696-2542	74696-2543	74696-2544
		74696-2546	74696-2547	74696-2548	74696-2549	74696-2551	74696-2552
		74696-2553	74696-2554	74696-2556	74696-2557	74696-2558	74696-2559
		74696-2561	74696-2562	74696-2563	74696-2564	74696-2566	74696-2567
		74696-2568	74696-2569	74696-2571	74696-2572	74696-2573	74696-2574
		74696-2576	74696-2577	74696-2578	74696-2579	74696-2581	74696-2582
		74696-2583	74696-2584	74696-2586	74696-2587	74696-2588	74696-2589
		74696-2601	74696-2602	74696-2603	74696-2604	74696-2606	74696-2607
		74696-2608	74696-2609	74696-2611	74696-2612	74696-2613	74696-2614
		74696-2616	74696-2617	74696-2618	74696-2619	74696-2621	74696-2622
		74696-2623	74696-2624	74696-2626	74696-2627	74696-2628	74696-2629
		74696-2631	74696-2632	74696-2633	74696-2634	74696-2636	74696-2637
		74696-2638	74696-2639	74696-2641	74696-2642	74696-2643	74696-2644
		74696-2646	74696-2647	74696-2648	74696-2649	74696-2651	74696-2652
		74696-2653	74696-2654	74696-2656	74696-2657	74696-2658	74696-2659

74696 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	5	74696-2661	74696-2662	74696-2663	74696-2664	74696-2666	74696-2667
		74696-2668	74696-2669	74696-2671	74696-2672	74696-2673	74696-2674
		74696-2676	74696-2677	74696-2678	74696-2679	74696-2681	74696-2682
		74696-2683	74696-2684	74696-2686	74696-2687	74696-2688	74696-2689
		74696-8501	74696-8502	74696-8503	74696-8504	74696-8506	74696-8507
		74696-8508	74696-8509	74696-8511	74696-8512	74696-8513	74696-8514
		74696-8516	74696-8517	74696-8518	74696-8519	74696-8521	74696-8522
		74696-8523	74696-8524	74696-8526	74696-8527	74696-8528	74696-8529
		74696-8531	74696-8532	74696-8533	74696-8534	74696-8536	74696-8537
		74696-8538	74696-8539	74696-8541	74696-8542	74696-8543	74696-8544
		74696-8546	74696-8547	74696-8548	74696-8549	74696-8551	74696-8552
		74696-8553	74696-8554	74696-8556	74696-8557	74696-8558	74696-8559
		74696-8561	74696-8562	74696-8563	74696-8564	74696-8566	74696-8567
		74696-8568	74696-8569	74696-8571	74696-8572	74696-8573	74696-8574
		74696-8576	74696-8577	74696-8578	74696-8579	74696-8581	74696-8582
		74696-8583	74696-8584	74696-8586	74696-8587	74696-8588	74696-8589

74697 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	5	74697-2501	74697-2502	74697-2503	74697-2504	74697-2506	74697-2507
		74697-2508	74697-2509	74697-2511	74697-2512	74697-2513	74697-2514
		74697-2516	74697-2517	74697-2518	74697-2519	74697-2521	74697-2522
		74697-2523	74697-2524	74697-2526	74697-2527	74697-2528	74697-2529
		74697-2531	74697-2532	74697-2533	74697-2534	74697-2536	74697-2537
		74697-2538	74697-2539	74697-2541	74697-2542	74697-2543	74697-2544
		74697-2546	74697-2547	74697-2548	74697-2549	74697-2551	74697-2552
		74697-2553	74697-2554	74697-2556	74697-2557	74697-2558	74697-2559
		74697-2561	74697-2562	74697-2563	74697-2564	74697-2566	74697-2567
		74697-2568	74697-2569	74697-2571	74697-2572	74697-2573	74697-2574
		74697-2576	74697-2577	74697-2578	74697-2579	74697-2581	74697-2582
		74697-2583	74697-2584	74697-2586	74697-2587	74697-2588	74697-2589
		74697-2601	74697-2602	74697-2603	74697-2604	74697-2606	74697-2607
		74697-2608	74697-2609	74697-2611	74697-2612	74697-2613	74697-2614
		74697-2616	74697-2617	74697-2618	74697-2619	74697-2621	74697-2622
		74697-2623	74697-2624	74697-2626	74697-2627	74697-2628	74697-2629
		74697-2631	74697-2632	74697-2633	74697-2634	74697-2636	74697-2637
		74697-2638	74697-2639	74697-2641	74697-2642	74697-2643	74697-2644
		74697-2646	74697-2647	74697-2648	74697-2649	74697-2651	74697-2652
		74697-2653	74697-2654	74697-2656	74697-2657	74697-2658	74697-2659
74697-2661	74697-2662	74697-2663	74697-2664	74697-2666	74697-2667		
74697-2668	74697-2669	74697-2671	74697-2672	74697-2673	74697-2674		
74697-2676	74697-2677	74697-2678	74697-2679	74697-2681	74697-2682		
74697-2683	74697-2684	74697-2686	74697-2687	74697-2688	74697-2689		
74697-8501	74697-8502	74697-8503	74697-8504	74697-8506	74697-8507		
74697-8508	74697-8509	74697-8511	74697-8512	74697-8513	74697-8514		
74697-8516	74697-8517	74697-8518	74697-8519	74697-8521	74697-8522		
74697-8523	74697-8524	74697-8526	74697-8527	74697-8528	74697-8529		
74697-8531	74697-8532	74697-8533	74697-8534	74697-8536	74697-8537		
74697-8538	74697-8539	74697-8541	74697-8542	74697-8543	74697-8544		
74697-8546	74697-8547	74697-8548	74697-8549	74697-8551	74697-8552		
74697-8553	74697-8554	74697-8556	74697-8557	74697-8558	74697-8559		
74697-8561	74697-8562	74697-8563	74697-8564	74697-8566	74697-8567		
74697-8568	74697-8569	74697-8571	74697-8572	74697-8573	74697-8574		

74697 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	5	74697-8576	74697-8577	74697-8578	74697-8579	74697-8581	74697-8582
		74697-8583	74697-8584	74697-8586	74697-8587	74697-8588	74697-8589

74702 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	5	74702-0008	74702-0009	74702-0010	74702-0020	74702-0021	74702-0022
		74702-0027	74702-0030				

*VHDM-HSD™ is a registered trademark of Teradyne, Inc.

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 tooling holder (ordered separately). See Figure 1.

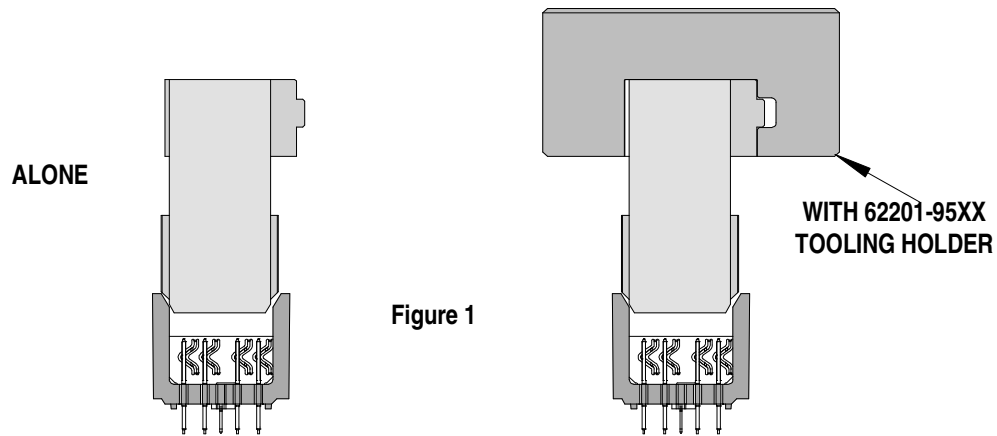


Figure 1

Tool Installation

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

Tooling Holder 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: The 62202-0201 Press-In Tool is 49.9mm (1.97 in.) long by 25.0mm (.984 in.) high.

Printed Circuit Board (PCB) Support

The *VHDM-HSD™ connectors requires a large amount 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.

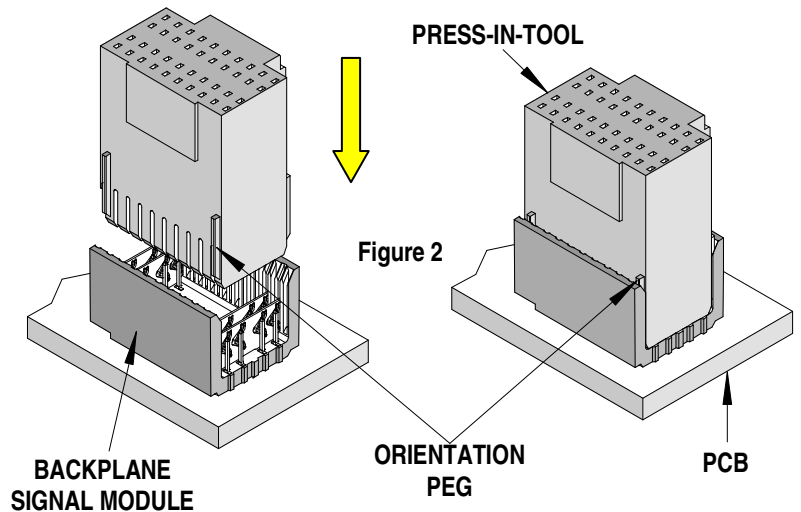
Press Equipment Recommendations

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

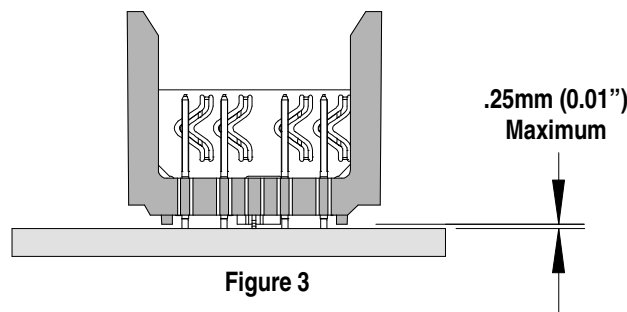
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press 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 backplane signal module(s) into the PCB hole pattern. Make sure the connector(s) are oriented properly.
2. Insert the press-in-tool into the backplane signal module assembly with the orientation peg on the tool entering the groove in the connector housing. Make sure all the pins and shields fit into the proper slots. 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.



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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