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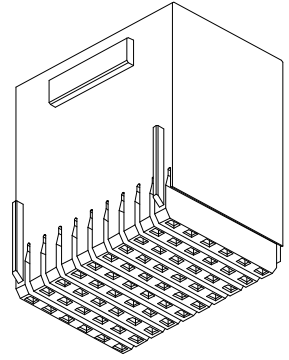
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***VHDM® Backplane Signal Insertion Module
Application Tooling Specification
Press-In Tool
Order No. 62202-0203**



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® Advanced Mate Signal Module Assembly, (60 Circuits), 74057, 74058, 74059, 74077, 74335 and 74336 Series 6 Rows by 10 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.

74057 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	6	74057-1001	74057-1002	74057-1003	74057-1004	74057-1006	74057-1007
		74057-1008	74057-1009				
		74057-1101	74057-1102	74057-1103	74057-1104	74057-1106	74057-1107
		74057-1108	74057-1109				
		74057-9001	74057-9002	74057-9003	74057-9004	74057-9006	74057-9007
		74057-9008	74057-9009				
		74057-9101	74057-9102	74057-9103	74057-9104	74057-9106	74057-9107
		74057-9108	74057-9109				

74058 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	6	74058-1001	74058-1002	74058-1003	74058-1004	74058-1006	74058-1007
		74058-1008	74058-1009	74058-1011	74058-1012	74058-1013	74058-1014
		74058-1016	74058-1017	74058-1018	74058-1019	74058-1021	74058-1022
		74058-1023	74058-1024	74058-1026	74058-1027	74058-1028	74058-1029
		74058-1031	74058-1032	74058-1033	74058-1034	74058-1036	74058-1037
		74058-1038	74058-1039	74058-1041	74058-1042	74058-1043	74058-1044
		74058-1046	74058-1047	74058-1048	74058-1049	74058-1051	74058-1052
		74058-1053	74058-1054	74058-1056	74058-1057	74058-1058	74058-1059
		74058-1061	74058-1062	74058-1063	74058-1064	74058-1066	74058-1067
		74058-1068	74058-1069	74058-1071	74058-1072	74058-1073	74058-1074
		74058-1076	74058-1077	74058-1078	74058-1079	74058-1081	74058-1082
		74058-1083	74058-1084	74058-1086	74058-1087	74058-1088	74058-1089
		74058-1101	74058-1102	74058-1103	74058-1104	74058-1106	74058-1107
		74058-1108	74058-1109	74058-1111	74058-1112	74058-1113	74058-1114
		74058-1116	74058-1117	74058-1118	74058-1119	74058-1121	74058-1122
		74058-1123	74058-1124	74058-1126	74058-1127	74058-1128	74058-1129
		74058-1131	74058-1132	74058-1133	74058-1134	74058-1136	74058-1137

74058 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	6	74058-1138	74058-1139	74058-1141	74058-1142	74058-1143	74058-1144
		74058-1146	74058-1147	74058-1148	74058-1149	74058-1151	74058-1152
		74058-1153	74058-1154	74058-1156	74058-1157	74058-1158	74058-1159
		74058-1161	74058-1162	74058-1163	74058-1164	74058-1166	74058-1167
		74058-1168	74058-1169	74058-1171	74058-1172	74058-1173	74058-1174
		74058-1176	74058-1177	74058-1178	74058-1179	74058-1181	74058-1182
		74058-1183	74058-1184	74058-1186	74058-1187	74058-1188	74058-1189
		74058-9001	74058-9002	74058-9003	74058-9004	74058-9006	74058-9007
		74058-9008	74058-9009	74058-9011	74058-9012	74058-9013	74058-9014
		74058-9016	74058-9017	74058-9018	74058-9019	74058-9021	74058-9022
		74058-9023	74058-9024	74058-9026	74058-9027	74058-9028	74058-9029
		74058-9031	74058-9032	74058-9033	74058-9034	74058-9036	74058-9037
		74058-9038	74058-9039	74058-9041	74058-9042	74058-9043	74058-9044
		74058-9046	74058-9047	74058-9048	74058-9049	74058-9051	74058-9052
		74058-9053	74058-9054	74058-9056	74058-9057	74058-9058	74058-9059
		74058-9061	74058-9062	74058-9063	74058-9064	74058-9066	74058-9067
		74058-9068	74058-9069	74058-9071	74058-9072	74058-9073	74058-9074
		74058-9076	74058-9077	74058-9078	74058-9079	74058-9081	74058-9082
		74058-9083	74058-9084	74058-9086	74058-9087	74058-9088	74058-9089
		74058-9101	74058-9102	74058-9103	74058-9104	74058-9106	74058-9107
		74058-9108	74058-9109	74058-9111	74058-9112	74058-9113	74058-9114
		74058-9116	74058-9117	74058-9118	74058-9119	74058-9121	74058-9122
		74058-9123	74058-9124	74058-9126	74058-9127	74058-9128	74058-9129
		74058-9131	74058-9132	74058-9133	74058-9134	74058-9136	74058-9137
		74058-9138	74058-9139	74058-9141	74058-9142	74058-9143	74058-9144
		74058-9146	74058-9147	74058-9148	74058-9149	74058-9151	74058-9152
		74058-9153	74058-9154	74058-9156	74058-9157	74058-9158	74058-9159
		74058-9161	74058-9162	74058-9163	74058-9164	74058-9166	74058-9167
		74058-9168	74058-9169	74058-9171	74058-9172	74058-9173	74058-9174
		74058-9176	74058-9177	74058-9178	74058-9179	74058-9181	74058-9182
74058-9183	74058-9184	74058-9186	74058-9187	74058-9188	74058-9189		

74059 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	6	74059-1001	74059-1002	74059-1003	74059-1004	74059-1006	74059-1007
		74059-1008	74059-1009	74059-1011	74059-1012	74059-1013	74059-1014
		74059-1016	74059-1017	74059-1018	74059-1019	74059-1021	74059-1022
		74059-1023	74059-1024	74059-1026	74059-1027	74059-1028	74059-1029
		74059-1031	74059-1032	74059-1033	74059-1034	74059-1036	74059-1037
		74059-1038	74059-1039	74059-1041	74059-1042	74059-1043	74059-1044
		74059-1046	74059-1047	74059-1048	74059-1049	74059-1051	74059-1052
		74059-1053	74059-1054	74059-1056	74059-1057	74059-1058	74059-1059
		74059-1061	74059-1062	74059-1063	74059-1064	74059-1066	74059-1067
		74059-1068	74059-1069	74059-1071	74059-1072	74059-1073	74059-1074
		74059-1076	74059-1077	74059-1078	74059-1079	74059-1081	74059-1082
		74059-1083	74059-1084	74059-1086	74059-1087	74059-1088	74059-1089
		74059-1101	74059-1102	74059-1103	74059-1104	74059-1106	74059-1107
		74059-1108	74059-1109	74059-1111	74059-1112	74059-1113	74059-1114
		74059-1116	74059-1117	74059-1118	74059-1119	74059-1121	74059-1122
		74059-1123	74059-1124	74059-1126	74059-1127	74059-1128	74059-1129
		74059-1131	74059-1132	74059-1133	74059-1134	74059-1136	74059-1137
		74059-1138	74059-1139	74059-1141	74059-1142	74059-1143	74059-1144
		74059-1146	74059-1147	74059-1148	74059-1149	74059-1151	74059-1152

74059 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	6	74059-1153	74059-1154	74059-1156	74059-1157	74059-1158	74059-1159
		74059-1161	74059-1162	74059-1163	74059-1164	74059-1166	74059-1167
		74059-1168	74059-1169	74059-1171	74059-1172	74059-1173	74059-1174
		74059-1176	74059-1177	74059-1178	74059-1179	74059-1181	74059-1182
		74059-1183	74059-1184	74059-1186	74059-1187	74059-1188	74059-1189
		74059-9001	74059-9002	74059-9003	74059-9004	74059-9006	74059-9007
		74059-9008	74059-9009	74059-9011	74059-9012	74059-9013	74059-9014
		74059-9016	74059-9017	74059-9018	74059-9019	74059-9021	74059-9022
		74059-9023	74059-9024	74059-9026	74059-9027	74059-9028	74059-9029
		74059-9031	74059-9032	74059-9033	74059-9034	74059-9036	74059-9037
		74059-9038	74059-9039	74059-9041	74059-9042	74059-9043	74059-9044
		74059-9046	74059-9047	74059-9048	74059-9049	74059-9051	74059-9052
		74059-9053	74059-9054	74059-9056	74059-9057	74059-9058	74059-9059
		74059-9061	74059-9062	74059-9063	74059-9064	74059-9066	74059-9067
		74059-9068	74059-9069	74059-9071	74059-9072	74059-9073	74059-9074
		74059-9076	74059-9077	74059-9078	74059-9079	74059-9081	74059-9082
		74059-9083	74059-9084	74059-9086	74059-9087	74059-9088	74059-9089
		74059-9101	74059-9102	74059-9103	74059-9104	74059-9106	74059-9107
		74059-9108	74059-9109	74059-9111	74059-9112	74059-9113	74059-9114
		74059-9116	74059-9117	74059-9118	74059-9119	74059-9121	74059-9122
		74059-9123	74059-9124	74059-9126	74059-9127	74059-9128	74059-9129
		74059-9131	74059-9132	74059-9133	74059-9134	74059-9136	74059-9137
		74059-9138	74059-9139	74059-9141	74059-9142	74059-9143	74059-9144
		74059-9146	74059-9147	74059-9148	74059-9149	74059-9151	74059-9152
		74059-9153	74059-9154	74059-9156	74059-9157	74059-9158	74059-9159
		74059-9161	74059-9162	74059-9163	74059-9164	74059-9166	74059-9167
		74059-9168	74059-9169	74059-9171	74059-9172	74059-9173	74059-9174
		74059-9176	74059-9177	74059-9178	74059-9179	74059-9181	74059-9182
		74059-9183	74059-9184	74059-9186	74059-9187	74059-9188	74059-9189

74077 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	6	74077-0006	74077-0007	74077-0008	74077-0011	74077-0012	74077-0013
		74077-0014	74077-9997	74077-9998	74077-9999		

74335 Series Number							
Guide Style	Columns	Assembly Order Number					
Open	6	74335-1001	74335-1002	74335-1003	74335-1004	74335-1006	74335-1007
		74335-1008	74335-1009				

74336 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield end	6	74336-1001	74336-1002	74336-1003	74336-1004	74336-1006	74336-1007
		74336-1008	74336-1009				

*VHDM® 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.

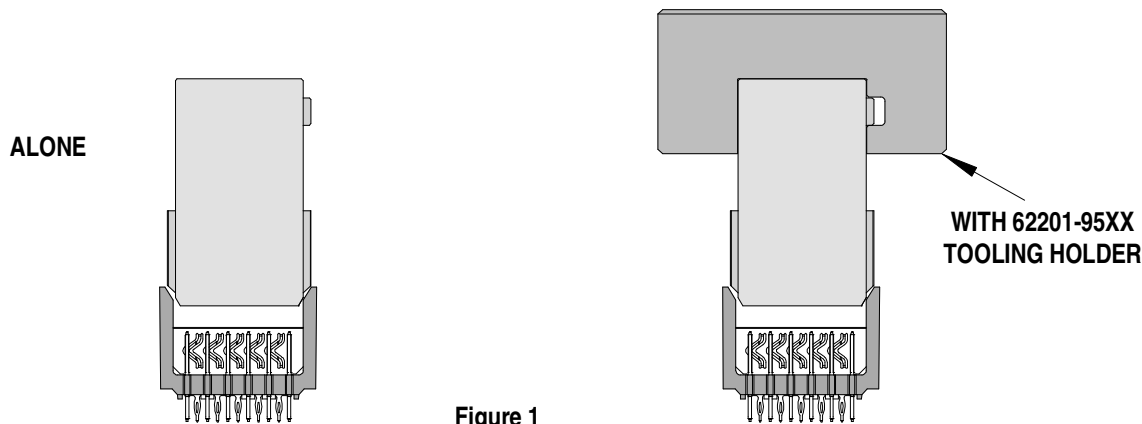


Figure 1

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 62202-0203 Press-In Tool is 19.9mm (.785 in.) long by 25.0mm (.984 in.) high.

Printed Circuit Board (PCB) Support

The *VHDM® 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.

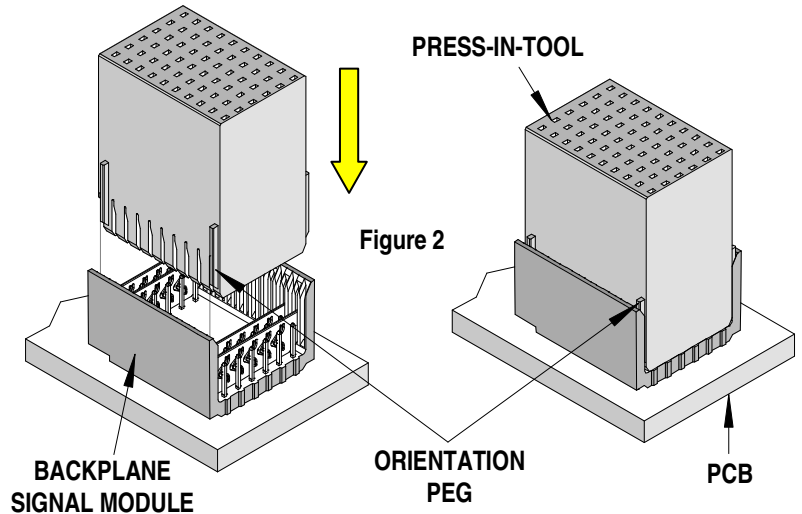
Press Equipment Recommendations

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

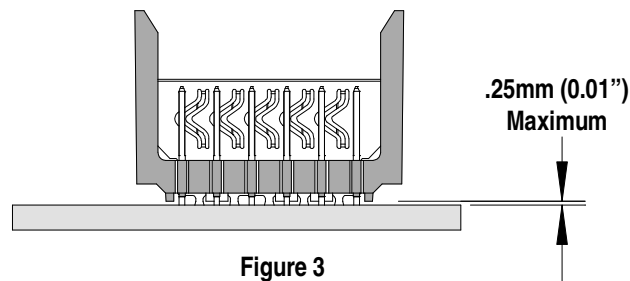
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press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