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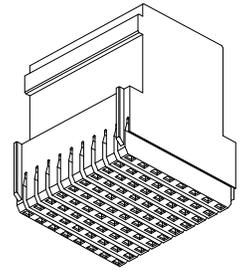
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***VHDM® and VHDM-HSD™ Backplane
Signal Insertion Module
Application Tooling Specification
Press-In Tool
Order No. 62202-0205**



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, (80 Circuits), 74060, 74061, 74062, and 74078 Series, 8 Rows by 10 Columns Assemblies.

2.00mm (.079") Pitch *VHDM-HSD™ Signal Module Assembly, (80 Circuits), 74649, 74650, 74651, 4658, and 74659 Series, 8 Rows by 10 Columns Assemblies. See Product List below for specific part numbers. *VHDM® is a registered trademark of Teradyne, Inc.

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.

74060 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	10	74060-1001	74060-1002	74060-1003	74060-1004	74060-1006	74060-1007
		74060-1008	74060-1009				
		74060-1101	74060-1102	74060-1103	74060-1104	74060-1106	74060-1107
		74060-1108	74060-1109				
		74060-9001	74060-9002	74060-9003	74060-9004	74060-9006	74060-9007
		74060-9008	74060-9009				
		74060-9101	74060-9102	74060-9103	74060-9104	74060-9106	74060-9107
		74060-9108	74060-9109				

74061 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	10	74061-1001	74061-1002	74061-1003	74061-1004	74061-1006	74061-1007
		74061-1008	74061-1009	74061-1011	74061-1012	74061-1013	74061-1014
		74061-1016	74061-1017	74061-1018	74061-1019	74061-1021	74061-1022
		74061-1023	74061-1024	74061-1026	74061-1027	74061-1028	74061-1029
		74061-1031	74061-1032	74061-1033	74061-1034	74061-1036	74061-1037
		74061-1038	74061-1039	74061-1041	74061-1042	74061-1043	74061-1044
		74061-1046	74061-1047	74061-1048	74061-1049	74061-1051	74061-1052
		74061-1053	74061-1054	74061-1056	74061-1057	74061-1058	74061-1059
		74061-1061	74061-1062	74061-1063	74061-1064	74061-1066	74061-1067
		74061-1068	74061-1069	74061-1071	74061-1072	74061-1073	74061-1074
		74061-1076	74061-1077	74061-1078	74061-1079	74061-1081	74061-1082
		74061-1083	74061-1084	74061-1086	74061-1087	74061-1088	74061-1089
		74061-1101	74061-1102	74061-1103	74061-1104	74061-1106	74061-1107
		74061-1108	74061-1109	74061-1111	74061-1112	74061-1113	74061-1114
				74061-1116	74061-1117	74061-1118	74061-1119
						74061-1121	74061-1122

74061 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	10	74061-1123	74061-1124	74061-1126	74061-1127	74061-1128	74061-1129
		74061-1131	74061-1132	74061-1133	74061-1134	74061-1136	74061-1137
		74061-1138	74061-1139	74061-1141	74061-1142	74061-1143	74061-1144
		74061-1146	74061-1147	74061-1148	74061-1149	74061-1151	74061-1152
		74061-1153	74061-1154	74061-1156	74061-1157	74061-1158	74061-1159
		74061-1161	74061-1162	74061-1163	74061-1164	74061-1166	74061-1167
		74061-1168	74061-1169	74061-1171	74061-1172	74061-1173	74061-1174
		74061-1176	74061-1177	74061-1178	74061-1179	74061-1181	74061-1182
		74061-1183	74061-1184	74061-1186	74061-1187	74061-1188	74061-1189
		74061-9001	74061-9002	74061-9003	74061-9004	74061-9006	74061-9007
		74061-9008	74061-9009	74061-9011	74061-9012	74061-9013	74061-9014
		74061-9016	74061-9017	74061-9018	74061-9019	74061-9021	74061-9022
		74061-9023	74061-9024	74061-9026	74061-9027	74061-9028	74061-9029
		74061-9031	74061-9032	74061-9033	74061-9034	74061-9036	74061-9037
		74061-9038	74061-9039	74061-9041	74061-9042	74061-9043	74061-9044
		74061-9046	74061-9047	74061-9048	74061-9049	74061-9051	74061-9052
		74061-9053	74061-9054	74061-9056	74061-9057	74061-9058	74061-9059
		74061-9061	74061-9062	74061-9063	74061-9064	74061-9066	74061-9067
		74061-9068	74061-9069	74061-9071	74061-9072	74061-9073	74061-9074
		74061-9076	74061-9077	74061-9078	74061-9079	74061-9081	74061-9082
		74061-9083	74061-9084	74061-9086	74061-9087	74061-9088	74061-9089
		74061-9101	74061-9102	74061-9103	74061-9104	74061-9106	74061-9107
		74061-9108	74061-9109	74061-9111	74061-9112	74061-9113	74061-9114
		74061-9116	74061-9117	74061-9118	74061-9119	74061-9121	74061-9122
		74061-9123	74061-9124	74061-9126	74061-9127	74061-9128	74061-9129
		74061-9131	74061-9132	74061-9133	74061-9134	74061-9136	74061-9137
		74061-9138	74061-9139	74061-9141	74061-9142	74061-9143	74061-9144
		74061-9146	74061-9147	74061-9148	74061-9149	74061-9151	74061-9152
		74061-9153	74061-9154	74061-9156	74061-9157	74061-9158	74061-9159
		74061-9161	74061-9162	74061-9163	74061-9164	74061-9166	74061-9167
		74061-9168	74061-9169	74061-9171	74061-9172	74061-9173	74061-9174
		74061-9176	74061-9177	74061-9178	74061-9179	74061-9181	74061-9182
		74061-9183	74061-9184	74061-9186	74061-9187	74061-9188	74061-9189

74062 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	10	74062-1001	74062-1002	74062-1003	74062-1004	74062-1006	74062-1007
		74062-1008	74062-1009	74062-1011	74062-1012	74062-1013	74062-1014
		74062-1016	74062-1017	74062-1018	74062-1019	74062-1021	74062-1022
		74062-1023	74062-1024	74062-1026	74062-1027	74062-1028	74062-1029
		74062-1031	74062-1032	74062-1033	74062-1034	74062-1036	74062-1037
		74062-1038	74062-1039	74062-1041	74062-1042	74062-1043	74062-1044
		74062-1046	74062-1047	74062-1048	74062-1049	74062-1051	74062-1052
		74062-1053	74062-1054	74062-1056	74062-1057	74062-1058	74062-1059
		74062-1061	74062-1062	74062-1063	74062-1064	74062-1066	74062-1067
		74062-1068	74062-1069	74062-1071	74062-1072	74062-1073	74062-1074
		74062-1076	74062-1077	74062-1078	74062-1079	74062-1081	74062-1082
		74062-1083	74062-1084	74062-1086	74062-1087	74062-1088	74062-1089
		74062-1101	74062-1102	74062-1103	74062-1104	74062-1106	74062-1107
		74062-1108	74062-1109	74062-1111	74062-1112	74062-1113	74062-1114
		74062-1116	74062-1117	74062-1118	74062-1119	74062-1121	74062-1122
		74062-1123	74062-1124	74062-1126	74062-1127	74062-1128	74062-1129
		74062-1131	74062-1132	74062-1133	74062-1134	74062-1136	74062-1137
		74062-1138	74062-1139	74062-1141	74062-1142	74062-1143	74062-1144

74062 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	10	74062-1146	74062-1147	74062-1148	74062-1149	74062-1151	74062-1152
		74062-1153	74062-1154	74062-1156	74062-1157	74062-1158	74062-1159
		74062-1161	74062-1162	74062-1163	74062-1164	74062-1166	74062-1167
		74062-1168	74062-1169	74062-1171	74062-1172	74062-1173	74062-1174
		74062-1176	74062-1177	74062-1178	74062-1179	74062-1181	74062-1182
		74062-1183	74062-1184	74062-1186	74062-1187	74062-1188	74062-1189
		74062-9001	74062-9002	74062-9003	74062-9004	74062-9006	74062-9007
		74062-9008	74062-9009	74062-9011	74062-9012	74062-9013	74062-9014
		74062-9016	74062-9017	74062-9018	74062-9019	74062-9021	74062-9022
		74062-9023	74062-9024	74062-9026	74062-9027	74062-9028	74062-9029
		74062-9031	74062-9032	74062-9033	74062-9034	74062-9036	74062-9037
		74062-9038	74062-9039	74062-9041	74062-9042	74062-9043	74062-9044
		74062-9046	74062-9047	74062-9048	74062-9049	74062-9051	74062-9052
		74062-9053	74062-9054	74062-9056	74062-9057	74062-9058	74062-9059
		74062-9061	74062-9062	74062-9063	74062-9064	74062-9066	74062-9067
		74062-9068	74062-9069	74062-9071	74062-9072	74062-9073	74062-9074
		74062-9076	74062-9077	74062-9078	74062-9079	74062-9081	74062-9082
		74062-9083	74062-9084	74062-9086	74062-9087	74062-9088	74062-9089
		74062-9101	74062-9102	74062-9103	74062-9104	74062-9106	74062-9107
		74062-9108	74062-9109	74062-9111	74062-9112	74062-9113	74062-9114
		74062-9116	74062-9117	74062-9118	74062-9119	74062-9121	74062-9122
		74062-9123	74062-9124	74062-9126	74062-9127	74062-9128	74062-9129
		74062-9131	74062-9132	74062-9133	74062-9134	74062-9136	74062-9137
		74062-9138	74062-9139	74062-9141	74062-9142	74062-9143	74062-9144
		74062-9146	74062-9147	74062-9148	74062-9149	74062-9151	74062-9152
		74062-9153	74062-9154	74062-9156	74062-9157	74062-9158	74062-9159
		74062-9161	74062-9162	74062-9163	74062-9164	74062-9166	74062-9167
		74062-9168	74062-9169	74062-9171	74062-9172	74062-9173	74062-9174
		74062-9176	74062-9177	74062-9178	74062-9179	74062-9181	74062-9182
		74062-9183	74062-9184	74062-9186	74062-9187	74062-9188	74062-9189

74649 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	10	74649-1001	74649-1002	74649-1003	74649-1004	74649-1006	74649-1007
		74649-1008	74649-1009				
		74649-1101	74649-1102	74649-1103	74649-1104	74649-1106	74649-1107
		74649-1108	74649-1109				
		74649-9001	74649-9002	74649-9003	74649-9004	74649-9006	74649-9007
		74649-9008	74649-9009				
		74649-9101	74649-9102	74649-9103	74649-9104	74649-9106	74649-9107
		74649-9108	74649-9109				

74650 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	10	74650-1001	74650-1002	74650-1003	74650-1004	74650-1006	74650-1007
		74650-1008	74650-1009	74650-1011	74650-1012	74650-1013	74650-1014
		74650-1016	74650-1017	74650-1018	74650-1019	74650-1021	74650-1022
		74650-1023	74650-1024	74650-1026	74650-1027	74650-1028	74650-1029
		74650-1031	74650-1032	74650-1033	74650-1034	74650-1036	74650-1037
		74650-1038	74650-1039	74650-1041	74650-1042	74650-1043	74650-1044
		74650-1046	74650-1047	74650-1048	74650-1049	74650-1051	74650-1052
		74650-1053	74650-1054	74650-1056	74650-1057	74650-1058	74650-1059
		74650-1061	74650-1062	74650-1063	74650-1064	74650-1066	74650-1067

74650 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	10	74650-1068	74650-1069	74650-1071	74650-1072	74650-1073	74650-1074
		74650-1076	74650-1077	74650-1078	74650-1079	74650-1081	74650-1082
		74650-1083	74650-1084	74650-1086	74650-1087	74650-1088	74650-1089
		74650-1101	74650-1102	74650-1103	74650-1104	74650-1106	74650-1107
		74650-1108	74650-1109	74650-1111	74650-1112	74650-1113	74650-1114
		74650-1116	74650-1117	74650-1118	74650-1119	74650-1121	74650-1122
		74650-1123	74650-1124	74650-1126	74650-1127	74650-1128	74650-1129
		74650-1131	74650-1132	74650-1133	74650-1134	74650-1136	74650-1137
		74650-1138	74650-1139	74650-1141	74650-1142	74650-1143	74650-1144
		74650-1146	74650-1147	74650-1148	74650-1149	74650-1151	74650-1152
		74650-1153	74650-1154	74650-1156	74650-1157	74650-1158	74650-1159
		74650-1161	74650-1162	74650-1163	74650-1164	74650-1166	74650-1167
		74650-1168	74650-1169	74650-1171	74650-1172	74650-1173	74650-1174
		74650-1176	74650-1177	74650-1178	74650-1179	74650-1181	74650-1182
		74650-1183	74650-1184	74650-1186	74650-1187	74650-1188	74650-1189
		74650-9001	74650-9002	74650-9003	74650-9004	74650-9006	74650-9007
		74650-9008	74650-9009	74650-9011	74650-9012	74650-9013	74650-9014
		74650-9016	74650-9017	74650-9018	74650-9019	74650-9021	74650-9022
		74650-9023	74650-9024	74650-9026	74650-9027	74650-9028	74650-9029
		74650-9031	74650-9032	74650-9033	74650-9034	74650-9036	74650-9037
		74650-9038	74650-9039	74650-9041	74650-9042	74650-9043	74650-9044
		74650-9046	74650-9047	74650-9048	74650-9049	74650-9051	74650-9052
		74650-9053	74650-9054	74650-9056	74650-9057	74650-9058	74650-9059
		74650-9061	74650-9062	74650-9063	74650-9064	74650-9066	74650-9067
		74650-9068	74650-9069	74650-9071	74650-9072	74650-9073	74650-9074
		74650-9076	74650-9077	74650-9078	74650-9079	74650-9081	74650-9082
		74650-9083	74650-9084	74650-9086	74650-9087	74650-9088	74650-9089
		74650-9101	74650-9102	74650-9103	74650-9104	74650-9106	74650-9107
		74650-9108	74650-9109	74650-9111	74650-9112	74650-9113	74650-9114
		74650-9116	74650-9117	74650-9118	74650-9119	74650-9121	74650-9122
		74650-9123	74650-9124	74650-9126	74650-9127	74650-9128	74650-9129
		74650-9131	74650-9132	74650-9133	74650-9134	74650-9136	74650-9137
		74650-9138	74650-9139	74650-9141	74650-9142	74650-9143	74650-9144
		74650-9146	74650-9147	74650-9148	74650-9149	74650-9151	74650-9152
74650-9153	74650-9154	74650-9156	74650-9157	74650-9158	74650-9159		
74650-9161	74650-9162	74650-9163	74650-9164	74650-9166	74650-9167		
74650-9168	74650-9169	74650-9171	74650-9172	74650-9173	74650-9174		
74650-9176	74650-9177	74650-9178	74650-9179	74650-9181	74650-9182		
74650-9183	74650-9184	74650-9186	74650-9187	74650-9188	74650-9189		

74651 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	10	74651-1001	74651-1002	74651-1003	74651-1004	74651-1006	74651-1007
		74651-1008	74651-1009	74651-1011	74651-1012	74651-1013	74651-1014
		74651-1016	74651-1017	74651-1018	74651-1019	74651-1021	74651-1022
		74651-1023	74651-1024	74651-1026	74651-1027	74651-1028	74651-1029
		74651-1031	74651-1032	74651-1033	74651-1034	74651-1036	74651-1037
		74651-1038	74651-1039	74651-1041	74651-1042	74651-1043	74651-1044
		74651-1046	74651-1047	74651-1048	74651-1049	74651-1051	74651-1052
		74651-1053	74651-1054	74651-1056	74651-1057	74651-1058	74651-1059
		74651-1061	74651-1062	74651-1063	74651-1064	74651-1066	74651-1067
		74651-1068	74651-1069	74651-1071	74651-1072	74651-1073	74651-1074
		74651-1076	74651-1077	74651-1078	74651-1079	74651-1081	74651-1082

74651 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	10	74651-1083	74651-1084	74651-1086	74651-1087	74651-1088	74651-1089
		74651-1101	74651-1102	74651-1103	74651-1104	74651-1106	74651-1107
		74651-1108	74651-1109	74651-1111	74651-1112	74651-1113	74651-1114
		74651-1116	74651-1117	74651-1118	74651-1119	74651-1121	74651-1122
		74651-1123	74651-1124	74651-1126	74651-1127	74651-1128	74651-1129
		74651-1131	74651-1132	74651-1133	74651-1134	74651-1136	74651-1137
		74651-1138	74651-1139	74651-1141	74651-1142	74651-1143	74651-1144
		74651-1146	74651-1147	74651-1148	74651-1149	74651-1151	74651-1152
		74651-1153	74651-1154	74651-1156	74651-1157	74651-1158	74651-1159
		74651-1161	74651-1162	74651-1163	74651-1164	74651-1166	74651-1167
		74651-1168	74651-1169	74651-1171	74651-1172	74651-1173	74651-1174
		74651-1176	74651-1177	74651-1178	74651-1179	74651-1181	74651-1182
		74651-1183	74651-1184	74651-1186	74651-1187	74651-1188	74651-1189
		74651-9001	74651-9002	74651-9003	74651-9004	74651-9006	74651-9007
		74651-9008	74651-9009	74651-9011	74651-9012	74651-9013	74651-9014
		74651-9016	74651-9017	74651-9018	74651-9019	74651-9021	74651-9022
		74651-9023	74651-9024	74651-9026	74651-9027	74651-9028	74651-9029
		74651-9031	74651-9032	74651-9033	74651-9034	74651-9036	74651-9037
		74651-9038	74651-9039	74651-9041	74651-9042	74651-9043	74651-9044
		74651-9046	74651-9047	74651-9048	74651-9049	74651-9051	74651-9052
		74651-9053	74651-9054	74651-9056	74651-9057	74651-9058	74651-9059
		74651-9061	74651-9062	74651-9063	74651-9064	74651-9066	74651-9067
		74651-9068	74651-9069	74651-9071	74651-9072	74651-9073	74651-9074
		74651-9076	74651-9077	74651-9078	74651-9079	74651-9081	74651-9082
		74651-9083	74651-9084	74651-9086	74651-9087	74651-9088	74651-9089
		74651-9101	74651-9102	74651-9103	74651-9104	74651-9106	74651-9107
		74651-9108	74651-9109	74651-9111	74651-9112	74651-9113	74651-9114
		74651-9116	74651-9117	74651-9118	74651-9119	74651-9121	74651-9122
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		74651-9131	74651-9132	74651-9133	74651-9134	74651-9136	74651-9137
		74651-9138	74651-9139	74651-9141	74651-9142	74651-9143	74651-9144
		74651-9146	74651-9147	74651-9148	74651-9149	74651-9151	74651-9152
		74651-9153	74651-9154	74651-9156	74651-9157	74651-9158	74651-9159
		74651-9161	74651-9162	74651-9163	74651-9164	74651-9166	74651-9167
74651-9168	74651-9169	74651-9171	74651-9172	74651-9173	74651-9174		
74651-9176	74651-9177	74651-9178	74651-9179	74651-9181	74651-9182		
74651-9183	74651-9184	74651-9186	74651-9187	74651-9188	74651-9189		

74658 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	10	74658-0001	74658-0002	74658-0003	74658-0007	74658-0008	74658-0010
		74658-0013	74658-0016				

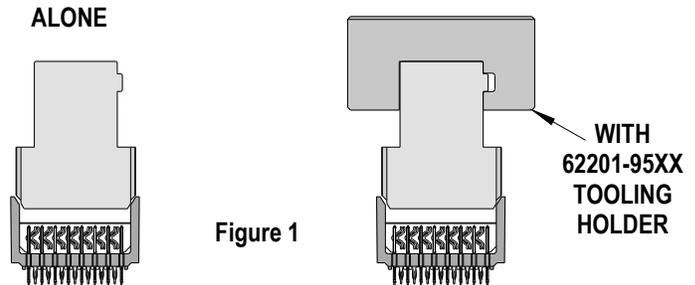
74659 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	10	74659-0001	74659-0002	74659-0003	74659-0004	74659-0006	74659-0010
		74659-0011	74659-0013	74659-0014	74659-0015	74659-0017	74659-0018
		74659-0029	74659-0036	74659-0039	74659-0042	74659-0043	74659-0044
		74659-0045	74659-0046	74659-0048	74659-0052	74659-0054	74659-0059
		74659-0060	74659-0061	74659-0062	74659-0063	74659-0064	74659-0065
		74659-0066	74659-0071	74659-0076	74659-0077	74659-0078	74659-0079
		74659-0081	74659-0082	74659-0084	74659-0085	74659-0086	74659-0087
		74659-0088	74659-0089	74659-0090	74659-0091	74659-0094	74659-0096

74659 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	10	74659-0097	74659-0098	74659-0099	74659-0101	74659-0102	74659-0103
		74659-0105	74659-0106	74659-0107	74659-0108	74659-0109	74659-0111
		74659-9982	74659-9983	74659-9984	74659-9985	74659-9986	74659-9987
		74659-9988	74659-9989	74659-0049			

74078 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	10	74078-0001	74078-0003	74078-0004	74078-0005	74078-0007	74078-0009
		74078-0016	74078-0017	74078-0018	74078-0019	74078-0020	74078-0021
		74078-0023	74078-0024	74078-0025			

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.



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: This 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

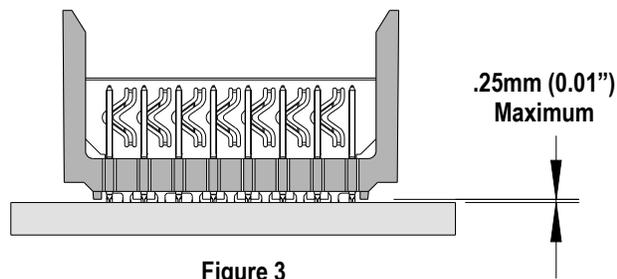
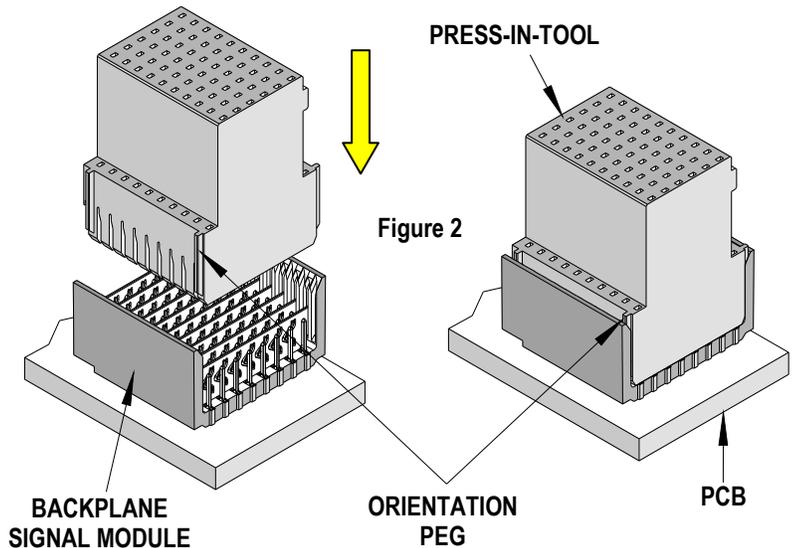
Many types of presses can be used to install *VHDM® connectors, but to assure consistent connector installation Molex recommends the following press criteria:

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

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