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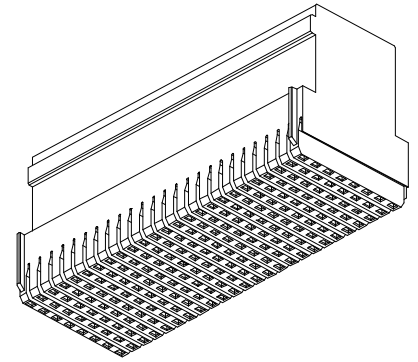
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***VHDM® and VHDM-HSD™ Backplane
Signal Insertion Module
Application Tooling Specification
Press-In Tool
Order No. 62202-0206**



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, (200 Circuits), 74060, 74061, and 74062 Series. 2.00mm (.079") Pitch *VHDM-HSD™ Signal Module Assembly, (200 Circuits), 74649, 74650, 74651, 74658, and 74659 Series 8 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.

74060 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	8	74060-2501	74060-2502	74060-2503	74060-2504	74060-2506	74060-2507
		74060-2508	74060-2509				
		74060-2601	74060-2602	74060-2603	74060-2604	74060-2606	74060-2607
		74060-2608	74060-2609				
		74060-8501	74060-8502	74060-8503	74060-8504	74060-8506	74060-8507
		74060-8508	74060-8509				
		74060-8601	74060-8602	74060-8603	74060-8604	74060-8606	74060-8607
		74060-8608	74060-8609				

74061 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	8	74061-2501	74061-2502	74061-2503	74061-2504	74061-2506	74061-2507
		74061-2508	74061-2509	74061-2511	74061-2512	74061-2513	74061-2514
		74061-2516	74061-2517	74061-2518	74061-2519	74061-2521	74061-2522
		74061-2523	74061-2524	74061-2526	74061-2527	74061-2528	74061-2529
		74061-2531	74061-2532	74061-2533	74061-2534	74061-2536	74061-2537
		74061-2538	74061-2539	74061-2541	74061-2542	74061-2543	74061-2544
		74061-2546	74061-2547	74061-2548	74061-2549	74061-2551	74061-2552
		74061-2553	74061-2554	74061-2556	74061-2557	74061-2558	74061-2559
		74061-2561	74061-2562	74061-2563	74061-2564	74061-2566	74061-2567
		74061-2568	74061-2569	74061-2571	74061-2572	74061-2573	74061-2574
		74061-2576	74061-2577	74061-2578	74061-2579	74061-2581	74061-2582
		74061-2583	74061-2584	74061-2586	74061-2587	74061-2588	74061-2589
		74061-2601	74061-2602	74061-2603	74061-2604	74061-2606	74061-2607
		74061-2608	74061-2609	74061-2611	74061-2612	74061-2613	74061-2614
		74061-2616	74061-2617	74061-2618	74061-2619	74061-2621	74061-2622

74061 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	8	74061-2623	74061-2624	74061-2626	74061-2627	74061-2628	74061-2629
		74061-2631	74061-2632	74061-2633	74061-2634	74061-2636	74061-2637
		74061-2638	74061-2639	74061-2641	74061-2642	74061-2643	74061-2644
		74061-2646	74061-2647	74061-2648	74061-2649	74061-2651	74061-2652
		74061-2653	74061-2654	74061-2656	74061-2657	74061-2658	74061-2659
		74061-2661	74061-2662	74061-2663	74061-2664	74061-2666	74061-2667
		74061-2668	74061-2669	74061-2671	74061-2672	74061-2673	74061-2674
		74061-2676	74061-2677	74061-2678	74061-2679	74061-2681	74061-2682
		74061-2683	74061-2684	74061-2686	74061-2687	74061-2688	74061-2689
		74061-8501	74061-8502	74061-8503	74061-8504	74061-8506	74061-8507
		74061-8508	74061-8509	74061-8511	74061-8512	74061-8513	74061-8514
		74061-8516	74061-8517	74061-8518	74061-8519	74061-8521	74061-8522
		74061-8523	74061-8524	74061-8526	74061-8527	74061-8528	74061-8529
		74061-8531	74061-8532	74061-8533	74061-8534	74061-8536	74061-8537
		74061-8538	74061-8539	74061-8541	74061-8542	74061-8543	74061-8544
		74061-8546	74061-8547	74061-8548	74061-8549	74061-8551	74061-8552
		74061-8553	74061-8554	74061-8556	74061-8557	74061-8558	74061-8559
		74061-8561	74061-8562	74061-8563	74061-8564	74061-8566	74061-8567
		74061-8568	74061-8569	74061-8571	74061-8572	74061-8573	74061-8574
		74061-8576	74061-8577	74061-8578	74061-8579	74061-8581	74061-8582
		74061-8583	74061-8584	74061-8586	74061-8587	74061-8588	74061-8589
		74061-8601	74061-8602	74061-8603	74061-8604	74061-8606	74061-8607
		74061-8608	74061-8609	74061-8611	74061-8612	74061-8613	74061-8614
		74061-8616	74061-8617	74061-8618	74061-8619	74061-8621	74061-8622
		74061-8623	74061-8624	74061-8626	74061-8627	74061-8628	74061-8629
		74061-8631	74061-8632	74061-8633	74061-8634	74061-8636	74061-8637
		74061-8638	74061-8639	74061-8641	74061-8642	74061-8643	74061-8644
		74061-8646	74061-8647	74061-8648	74061-8649	74061-8651	74061-8652
		74061-8653	74061-8654	74061-8656	74061-8657	74061-8658	74061-8659
		74061-8661	74061-8662	74061-8663	74061-8664	74061-8666	74061-8667
74061-8668	74061-8669	74061-8671	74061-8672	74061-8673	74061-8674		
74061-8676	74061-8677	74061-8678	74061-8679	74061-8681	74061-8682		
74061-8683	74061-8684	74061-8686	74061-8687	74061-8688	74061-8689		

74062 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	8	74062-2501	74062-2502	74062-2503	74062-2504	74062-2506	74062-2507
		74062-2508	74062-2509	74062-2511	74062-2512	74062-2513	74062-2514
		74062-2516	74062-2517	74062-2518	74062-2519	74062-2521	74062-2522
		74062-2523	74062-2524	74062-2526	74062-2527	74062-2528	74062-2529
		74062-2531	74062-2532	74062-2533	74062-2534	74062-2536	74062-2537
		74062-2538	74062-2539	74062-2541	74062-2542	74062-2543	74062-2544
		74062-2546	74062-2547	74062-2548	74062-2549	74062-2551	74062-2552
		74062-2553	74062-2554	74062-2556	74062-2557	74062-2558	74062-2559
		74062-2561	74062-2562	74062-2563	74062-2564	74062-2566	74062-2567
		74062-2568	74062-2569	74062-2571	74062-2572	74062-2573	74062-2574
		74062-2576	74062-2577	74062-2578	74062-2579	74062-2581	74062-2582
		74062-2583	74062-2584	74062-2586	74062-2587	74062-2588	74062-2589
		74062-2601	74062-2602	74062-2603	74062-2604	74062-2606	74062-2607
		74062-2608	74062-2609	74062-2611	74062-2612	74062-2613	74062-2614
		74062-2616	74062-2617	74062-2618	74062-2619	74062-2621	74062-2622
		74062-2623	74062-2624	74062-2626	74062-2627	74062-2628	74062-2629
		74062-2631	74062-2632	74062-2633	74062-2634	74062-2636	74062-2637

74062 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	8	74062-2638	74062-2639	74062-2641	74062-2642	74062-2643	74062-2644
		74062-2646	74062-2647	74062-2648	74062-2649	74062-2651	74062-2652
		74062-2653	74062-2654	74062-2656	74062-2657	74062-2658	74062-2659
		74062-2661	74062-2662	74062-2663	74062-2664	74062-2666	74062-2667
		74062-2668	74062-2669	74062-2671	74062-2672	74062-2673	74062-2674
		74062-2676	74062-2677	74062-2678	74062-2679	74062-2681	74062-2682
		74062-2683	74062-2684	74062-2686	74062-2687	74062-2688	74062-2689
		74062-8501	74062-8502	74062-8503	74062-8504	74062-8506	74062-8507
		74062-8508	74062-8509	74062-8511	74062-8512	74062-8513	74062-8514
		74062-8516	74062-8517	74062-8518	74062-8519	74062-8521	74062-8522
		74062-8523	74062-8524	74062-8526	74062-8527	74062-8528	74062-8529
		74062-8531	74062-8532	74062-8533	74062-8534	74062-8536	74062-8537
		74062-8538	74062-8539	74062-8541	74062-8542	74062-8543	74062-8544
		74062-8546	74062-8547	74062-8548	74062-8549	74062-8551	74062-8552
		74062-8553	74062-8554	74062-8556	74062-8557	74062-8558	74062-8559
		74062-8561	74062-8562	74062-8563	74062-8564	74062-8566	74062-8567
		74062-8568	74062-8569	74062-8571	74062-8572	74062-8573	74062-8574
		74062-8576	74062-8577	74062-8578	74062-8579	74062-8581	74062-8582
		74062-8583	74062-8584	74062-8586	74062-8587	74062-8588	74062-8589
		74062-8601	74062-8602	74062-8603	74062-8604	74062-8606	74062-8607
		74062-8608	74062-8609	74062-8611	74062-8612	74062-8613	74062-8614
		74062-8616	74062-8617	74062-8618	74062-8619	74062-8621	74062-8622
		74062-8623	74062-8624	74062-8626	74062-8627	74062-8628	74062-8629
		74062-8631	74062-8632	74062-8633	74062-8634	74062-8636	74062-8637
		74062-8638	74062-8639	74062-8641	74062-8642	74062-8643	74062-8644
		74062-8646	74062-8647	74062-8648	74062-8649	74062-8651	74062-8652
		74062-8653	74062-8654	74062-8656	74062-8657	74062-8658	74062-8659
		74062-8661	74062-8662	74062-8663	74062-8664	74062-8666	74062-8667
74062-8668	74062-8669	74062-8671	74062-8672	74062-8673	74062-8674		
74062-8676	74062-8677	74062-8678	74062-8679	74062-8681	74062-8682		
74062-8683	74062-8684	74062-8686	74062-8687	74062-8688	74062-8689		

74649 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	8	74649-2501	74649-2502	74649-2503	74649-2504	74649-2506	74649-2507
		74649-2508	74649-2509				
		74649-2601	74649-2602	74649-2603	74649-2604	74649-2606	74649-2607
		74649-2608	74649-2609				
		74649-8501	74649-8502	74649-8503	74649-8504	74649-8506	74649-8507
		74649-8508	74649-8509				
		74649-8601	74649-8602	74649-8603	74649-8604	74649-8606	74649-8607
		74649-8608	74649-8609				

74650 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	8	74650-2501	74650-2502	74650-2503	74650-2504	74650-2506	74650-2507
		74650-2508	74650-2509	74650-2511	74650-2512	74650-2513	74650-2514
		74650-2516	74650-2517	74650-2518	74650-2519	74650-2521	74650-2522
		74650-2523	74650-2524	74650-2526	74650-2527	74650-2528	74650-2529
		74650-2531	74650-2532	74650-2533	74650-2534	74650-2536	74650-2537
		74650-2538	74650-2539	74650-2541	74650-2542	74650-2543	74650-2544
		74650-2546	74650-2547	74650-2548	74650-2549	74650-2551	74650-2552
		74650-2553	74650-2554	74650-2556	74650-2557	74650-2558	74650-2559

74650 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	8	74650-2561	74650-2562	74650-2563	74650-2564	74650-2566	74650-2567
		74650-2568	74650-2569	74650-2571	74650-2572	74650-2573	74650-2574
		74650-2576	74650-2577	74650-2578	74650-2579	74650-2581	74650-2582
		74650-2583	74650-2584	74650-2586	74650-2587	74650-2588	74650-2589
		74650-2601	74650-2602	74650-2603	74650-2604	74650-2606	74650-2607
		74650-2608	74650-2609	74650-2611	74650-2612	74650-2613	74650-2614
		74650-2616	74650-2617	74650-2618	74650-2619	74650-2621	74650-2622
		74650-2623	74650-2624	74650-2626	74650-2627	74650-2628	74650-2629
		74650-2631	74650-2632	74650-2633	74650-2634	74650-2636	74650-2637
		74650-2638	74650-2639	74650-2641	74650-2642	74650-2643	74650-2644
		74650-2646	74650-2647	74650-2648	74650-2649	74650-2651	74650-2652
		74650-2653	74650-2654	74650-2656	74650-2657	74650-2658	74650-2659
		74650-2661	74650-2662	74650-2663	74650-2664	74650-2666	74650-2667
		74650-2668	74650-2669	74650-2671	74650-2672	74650-2673	74650-2674
		74650-2676	74650-2677	74650-2678	74650-2679	74650-2681	74650-2682
		74650-2683	74650-2684	74650-2686	74650-2687	74650-2688	74650-2689
		74650-8501	74650-8502	74650-8503	74650-8504	74650-8506	74650-8507
		74650-8508	74650-8509	74650-8511	74650-8512	74650-8513	74650-8514
		74650-8516	74650-8517	74650-8518	74650-8519	74650-8521	74650-8522
		74650-8523	74650-8524	74650-8526	74650-8527	74650-8528	74650-8529
		74650-8531	74650-8532	74650-8533	74650-8534	74650-8536	74650-8537
		74650-8538	74650-8539	74650-8541	74650-8542	74650-8543	74650-8544
		74650-8546	74650-8547	74650-8548	74650-8549	74650-8551	74650-8552
		74650-8553	74650-8554	74650-8556	74650-8557	74650-8558	74650-8559
		74650-8561	74650-8562	74650-8563	74650-8564	74650-8566	74650-8567
		74650-8568	74650-8569	74650-8571	74650-8572	74650-8573	74650-8574
		74650-8576	74650-8577	74650-8578	74650-8579	74650-8581	74650-8582
		74650-8583	74650-8584	74650-8586	74650-8587	74650-8588	74650-8589
		74650-8601	74650-8602	74650-8603	74650-8604	74650-8606	74650-8607
		74650-8608	74650-8609	74650-8611	74650-8612	74650-8613	74650-8614
		74650-8616	74650-8617	74650-8618	74650-8619	74650-8621	74650-8622
		74650-8623	74650-8624	74650-8626	74650-8627	74650-8628	74650-8629
		74650-8631	74650-8632	74650-8633	74650-8634	74650-8636	74650-8637
		74650-8638	74650-8639	74650-8641	74650-8642	74650-8643	74650-8644
74650-8646	74650-8647	74650-8648	74650-8649	74650-8651	74650-8652		
74650-8653	74650-8654	74650-8656	74650-8657	74650-8658	74650-8659		
74650-8661	74650-8662	74650-8663	74650-8664	74650-8666	74650-8667		
74650-8668	74650-8669	74650-8671	74650-8672	74650-8673	74650-8674		
74650-8676	74650-8677	74650-8678	74650-8679	74650-8681	74650-8682		
74650-8683	74650-8684	74650-8686	74650-8687	74650-8688	74650-8689		

74651 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	8	74651-2501	74651-2502	74651-2503	74651-2504	74651-2506	74651-2507
		74651-2508	74651-2509	74651-2511	74651-2512	74651-2513	74651-2514
		74651-2516	74651-2517	74651-2518	74651-2519	74651-2521	74651-2522
		74651-2523	74651-2524	74651-2526	74651-2527	74651-2528	74651-2529
		74651-2531	74651-2532	74651-2533	74651-2534	74651-2536	74651-2537
		74651-2538	74651-2539	74651-2541	74651-2542	74651-2543	74651-2544
		74651-2546	74651-2547	74651-2548	74651-2549	74651-2551	74651-2552
		74651-2553	74651-2554	74651-2556	74651-2557	74651-2558	74651-2559
		74651-2561	74651-2562	74651-2563	74651-2564	74651-2566	74651-2567
		74651-2568	74651-2569	74651-2571	74651-2572	74651-2573	74651-2574

74651 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	8	74651-2576	74651-2577	74651-2578	74651-2579	74651-2581	74651-2582
		74651-2583	74651-2584	74651-2586	74651-2587	74651-2588	74651-2589
		74651-2601	74651-2602	74651-2603	74651-2604	74651-2606	74651-2607
		74651-2608	74651-2609	74651-2611	74651-2612	74651-2613	74651-2614
		74651-2616	74651-2617	74651-2618	74651-2619	74651-2621	74651-2622
		74651-2623	74651-2624	74651-2626	74651-2627	74651-2628	74651-2629
		74651-2631	74651-2632	74651-2633	74651-2634	74651-2636	74651-2637
		74651-2638	74651-2639	74651-2641	74651-2642	74651-2643	74651-2644
		74651-2646	74651-2647	74651-2648	74651-2649	74651-2651	74651-2652
		74651-2653	74651-2654	74651-2656	74651-2657	74651-2658	74651-2659
		74651-2661	74651-2662	74651-2663	74651-2664	74651-2666	74651-2667
		74651-2668	74651-2669	74651-2671	74651-2672	74651-2673	74651-2674
		74651-2676	74651-2677	74651-2678	74651-2679	74651-2681	74651-2682
		74651-2683	74651-2684	74651-2686	74651-2687	74651-2688	74651-2689
		74651-8501	74651-8502	74651-8503	74651-8504	74651-8506	74651-8507
		74651-8508	74651-8509	74651-8511	74651-8512	74651-8513	74651-8514
		74651-8516	74651-8517	74651-8518	74651-8519	74651-8521	74651-8522
		74651-8523	74651-8524	74651-8526	74651-8527	74651-8528	74651-8529
		74651-8531	74651-8532	74651-8533	74651-8534	74651-8536	74651-8537
		74651-8538	74651-8539	74651-8541	74651-8542	74651-8543	74651-8544
		74651-8546	74651-8547	74651-8548	74651-8549	74651-8551	74651-8552
		74651-8553	74651-8554	74651-8556	74651-8557	74651-8558	74651-8559
		74651-8561	74651-8562	74651-8563	74651-8564	74651-8566	74651-8567
		74651-8568	74651-8569	74651-8571	74651-8572	74651-8573	74651-8574
		74651-8576	74651-8577	74651-8578	74651-8579	74651-8581	74651-8582
		74651-8583	74651-8584	74651-8586	74651-8587	74651-8588	74651-8589
		74651-8601	74651-8602	74651-8603	74651-8604	74651-8606	74651-8607
		74651-8608	74651-8609	74651-8611	74651-8612	74651-8613	74651-8614
		74651-8616	74651-8617	74651-8618	74651-8619	74651-8621	74651-8622
		74651-8623	74651-8624	74651-8626	74651-8627	74651-8628	74651-8629
		74651-8631	74651-8632	74651-8633	74651-8634	74651-8636	74651-8637
		74651-8638	74651-8639	74651-8641	74651-8642	74651-8643	74651-8644
		74651-8646	74651-8647	74651-8648	74651-8649	74651-8651	74651-8652
		74651-8653	74651-8654	74651-8656	74651-8657	74651-8658	74651-8659
74651-8661	74651-8662	74651-8663	74651-8664	74651-8666	74651-8667		
74651-8668	74651-8669	74651-8671	74651-8672	74651-8673	74651-8674		
74651-8676	74651-8677	74651-8678	74651-8679	74651-8681	74651-8682		
74651-8683	74651-8684	74651-8686	74651-8687	74651-8688	74651-8689		

74659 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	8	74659-0005	74659-0007	74659-0008	74659-0009	74659-0019	74659-0020
		74659-0021	74659-0022	74659-0023	74659-0024	74659-0030	74659-0031
		74659-0032	74659-0033	74659-0040	74659-0041	74659-0050	74659-0051
		74659-0053	74659-0055	74659-0056	74659-0057	74659-0058	74659-0067
		74659-0068	74659-0070	74659-0073	74659-0074	74659-0075	74659-0080
		74659-0083	74659-0092	74659-0093	74659-0095	74659-0100	74659-0104
		74659-0121	74659-9115	74659-9116	74659-9979	74659-9980	74659-9981
		74659-9990	74659-9991	74659-9992	74659-9993	74659-9994	

74658 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	8	74658-0004	74658-0009	74658-0011	74658-0012	74658-0014	74658-0015
		74658-0017					

*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.

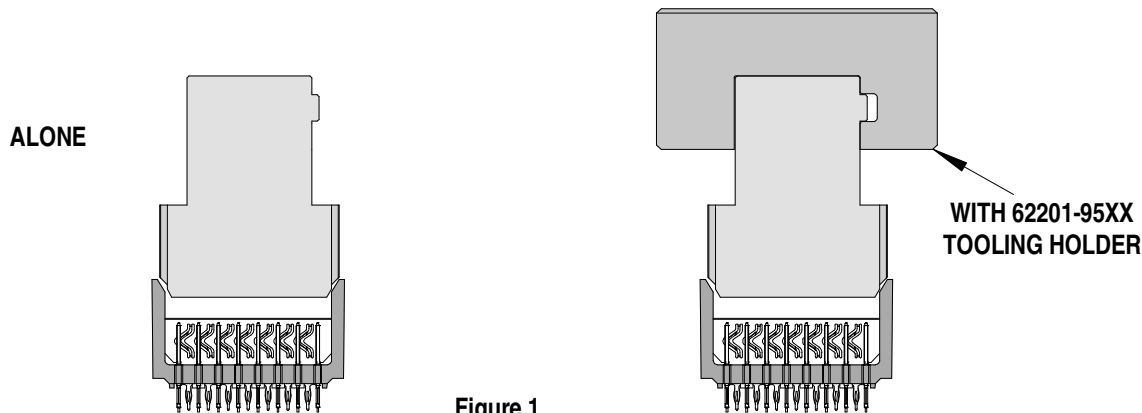


Figure 1

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 62202-0206 Press-In Tool is 49.9mm (1.97 in.) long by 25.0mm (.984 in.) high.

Printed Circuit Board (PCB) Support

The *VHDM® and 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.

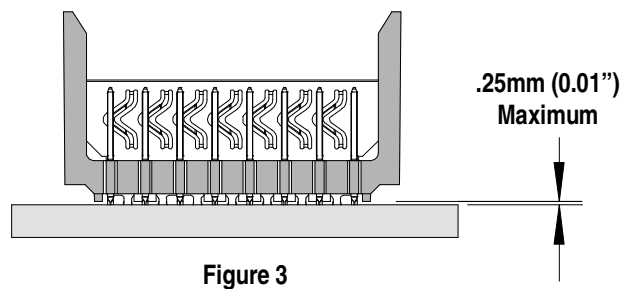
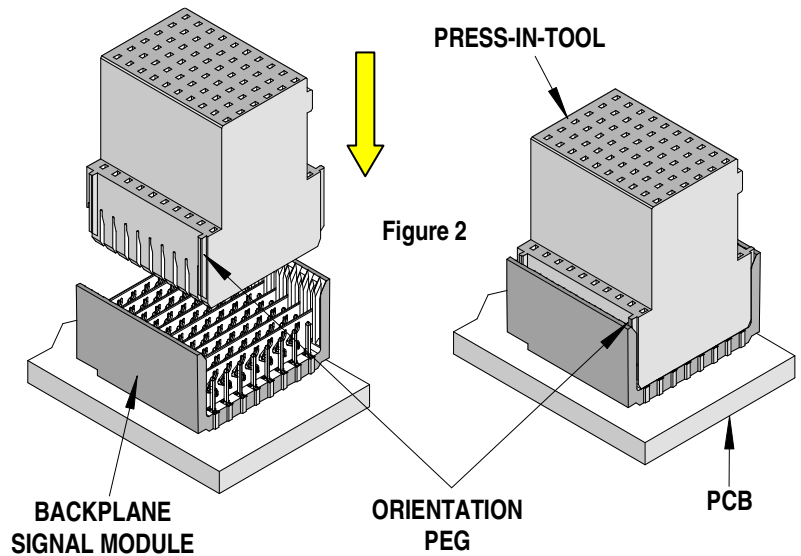
Press Equipment Recommendations

Many types of presses can be used to install *VHDM® 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.

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