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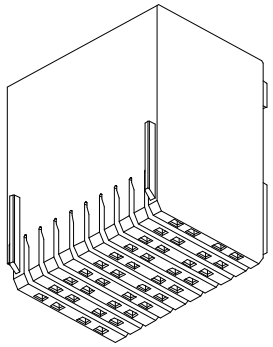
*VHDM-HSD™ Backplane Signal Insertion Module Application Tooling Specification Press-In Tool Order No. 62202-0216



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: 2.00mm (.079") Pitch *VHDM-HSD™ Standard Shield Signal Module Assembly, (60 Circuits), 74979, 74980, 74981, and 74984, 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.

74979 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	6	74979-1001	74979-1002	74979-1003	74979-1004	74979-1006	74979-1007
		74979-1008	74979-1009				
		74979-9001	74979-9002	74979-9003	74979-9004	74979-9006	74979-9007
		74979-9008	74979-9009				

74980 Series Number							
Guide Style	Columns	Assembly Order Number					
Right	6	74980-1001	74980-1002	74980-1003	74980-1004	74980-1006	74980-1007
		74980-1008	74980-1009	74980-1011	74980-1012	74980-1013	74980-1014
		74980-1016	74980-1017	74980-1018	74980-1019	74980-1021	74980-1022
		74980-1023	74980-1024	74980-1026	74980-1027	74980-1028	74980-1029
		74980-1031	74980-1032	74980-1033	74980-1034	74980-1036	74980-1037
		74980-1038	74980-1039	74980-1041	74980-1042	74980-1043	74980-1044
		74980-1046	74980-1047	74980-1048	74980-1049	74980-1051	74980-1052
		74980-1053	74980-1054	74980-1056	74980-1057	74980-1058	74980-1059
		74980-1061	74980-1062	74980-1063	74980-1064	74980-1066	74980-1067
		74980-1068	74980-1069	74980-1071	74980-1072	74980-1073	74980-1074
		74980-1076	74980-1077	74980-1078	74980-1079	74980-1081	74980-1082
		74980-1083	74980-1084	74980-1086	74980-1087	74980-1088	74980-1089
		74980-9001	74980-9002	74980-9003	74980-9004	74980-9006	74980-9007
		74980-9008	74980-9009	74980-9011	74980-9012	74980-9013	74980-9014
		74980-9016	74980-9017	74980-9018	74980-9019	74980-9021	74980-9022
		74980-9023	74980-9024	74980-9026	74980-9027	74980-9028	74980-9029
		74980-9031	74980-9032	74980-9033	74980-9034	74980-9036	74980-9037
		74980-9038	74980-9039	74980-9041	74980-9042	74980-9043	74980-9044
		74980-9046	74980-9047	74980-9048	74980-9049	74980-9051	74980-9052
		74980-9053	74980-9054	74980-9056	74980-9057	74980-9058	74980-9059

74980 Series Number							
Guide Style	**Columns**	**Assembly Order Number**					
Right	6	74980-9061	74980-9062	74980-9063	74980-9064	74980-9066	74980-9067
		74980-9068	74980-9069	74980-9071	74980-9072	74980-9073	74980-9074
		74980-9076	74980-9077	74980-9078	74980-9079	74980-9081	74980-9082
		74980-9083	74980-9084	74980-9086	74980-9087	74980-9088	74980-9089

74981 Series Number							
Guide Style	**Columns**	**Assembly Order Number**					
Left	6	74981-1001	74981-1002	74981-1003	74981-1004	74981-1006	74981-1007
		74981-1008	74981-1009	74981-1011	74981-1012	74981-1013	74981-1014
		74981-1016	74981-1017	74981-1018	74981-1019	74981-1021	74981-1022
		74981-1023	74981-1024	74981-1026	74981-1027	74981-1028	74981-1029
		74981-1031	74981-1032	74981-1033	74981-1034	74981-1036	74981-1037
		74981-1038	74981-1039	74981-1041	74981-1042	74981-1043	74981-1044
		74981-1046	74981-1047	74981-1048	74981-1049	74981-1051	74981-1052
		74981-1053	74981-1054	74981-1056	74981-1057	74981-1058	74981-1059
		74981-1061	74981-1062	74981-1063	74981-1064	74981-1066	74981-1067
		74981-1068	74981-1069	74981-1071	74981-1072	74981-1073	74981-1074
		74981-1076	74981-1077	74981-1078	74981-1079	74981-1081	74981-1082
		74981-1083	74981-1084	74981-1086	74981-1087	74981-1088	74981-1089
		74981-9001	74981-9002	74981-9003	74981-9004	74981-9006	74981-9007
		74981-9008	74981-9009	74981-9011	74981-9012	74981-9013	74981-9014
		74981-9016	74981-9017	74981-9018	74981-9019	74981-9021	74981-9022
		74981-9023	74981-9024	74981-9026	74981-9027	74981-9028	74981-9029
		74981-9031	74981-9032	74981-9033	74981-9034	74981-9036	74981-9037
		74981-9038	74981-9039	74981-9041	74981-9042	74981-9043	74981-9044
		74981-9046	74981-9047	74981-9048	74981-9049	74981-9051	74981-9052
		74981-9053	74981-9054	74981-9056	74981-9057	74981-9058	74981-9059
		74981-9061	74981-9062	74981-9063	74981-9064	74981-9066	74981-9067
		74981-9068	74981-9069	74981-9071	74981-9072	74981-9073	74981-9074
		74981-9076	74981-9077	74981-9078	74981-9079	74981-9081	74981-9082
		74981-9083	74981-9084	74981-9086	74981-9087	74981-9088	74981-9089

74984 Series Number							
Guide Style	**Columns**	**Assembly Order Number**					
Custom	6	74984-0001	74984-0003	74984-0004	74984-0005	74984-0006	74984-0007
		74984-0008	74984-0010	74984-0012	74984-0013	74984-0014	74984-0018
		74684-0019	74984-0029	74984-9998			

*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.

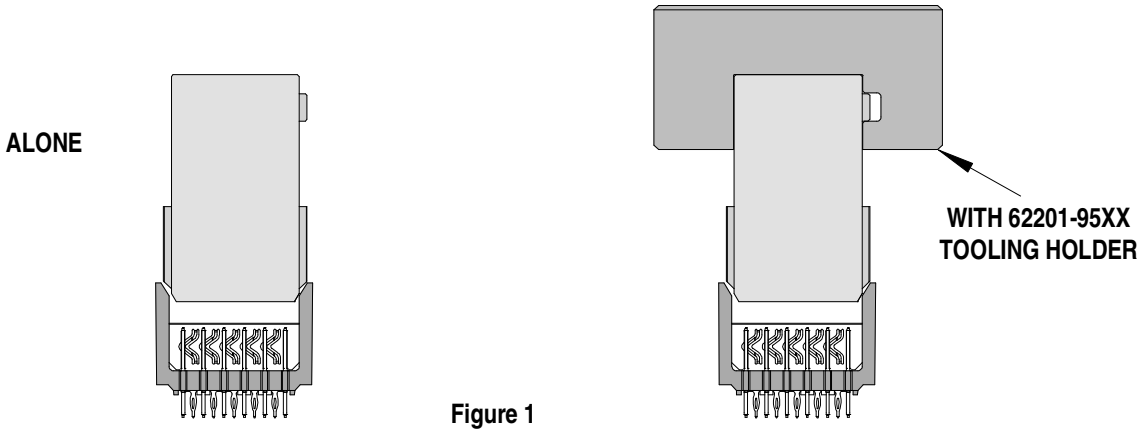


Figure 1

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 62202-0216 Press-In Tool is 19.9mm (.785 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.

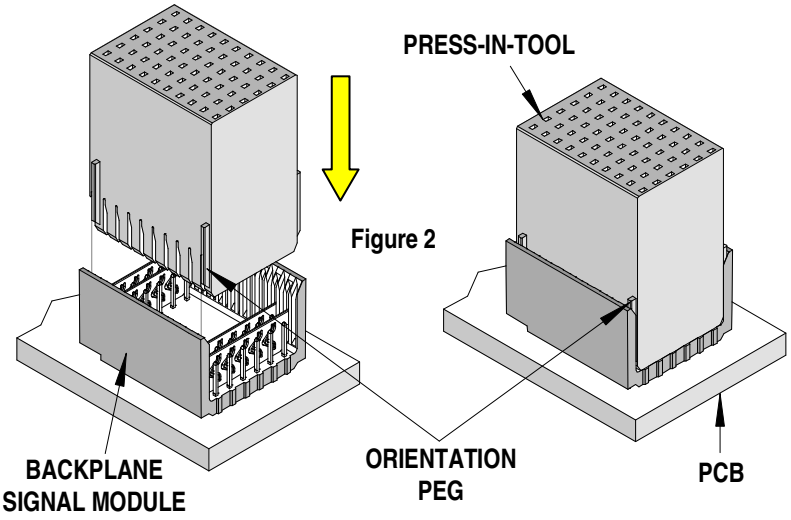


Figure 2

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.

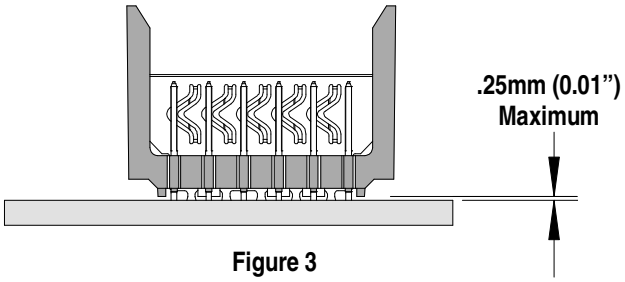


Figure 3

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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