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Tel: +86-755-8981 8866 Fax: +86-755-8427 6832

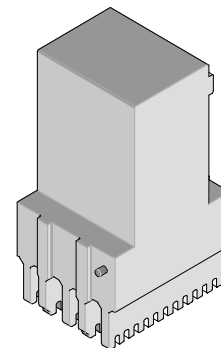
Email & Skype: info@chipsmall.com Web: www.chipsmall.com

Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China





**I-Trac™ Backplane Module Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8608**



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 holder with other Molex press-in tools.

SCOPE

Products: I-Trac™ Backplane Signal Module Assembly, 76015 Series 6 Column 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.

76015 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	6	76015-0602	76015-0603	76015-0604	76015-0605
Left End Wall		76015-0612	76015-0613	76015-0614	76015-0615
Dual End Wall		76015-0622	76015-0623	76015-0624	76015-0625
Right End Wall		76015-0632	76015-0633	76015-0634	76015-0635
Open		76015-1602	76015-1603	76015-1604	76015-1605
Left End Wall		76015-1612	76015-1613	76015-1614	76015-1615
Dual End Wall		76015-1622	76015-1623	76015-1624	76015-1625
Right End Wall		76015-1632	76015-1633	76015-1634	76015-1635
Guide Left	6	76015-2602	76015-2603	76015-2604	76015-2605
		76015-2612	76015-2613	76015-2614	76015-2615
		76015-2622	76015-2623	76015-2624	76015-2625
		76015-2632	76015-2633	76015-2634	76015-2635
		76015-2642	76015-2643	76015-2644	76015-2645
		76015-2652	76015-2653	76015-2654	76015-2655
		76015-2662	76015-2663	76015-2664	76015-2665
		76015-2672	76015-2673	76015-2674	76015-2675
		76015-2682	76015-2683	76015-2684	76015-2685
		76015-3602	76015-3603	76015-3604	76015-3605
		76015-3612	76015-3613	76015-3614	76015-3615
		76015-3622	76015-3623	76015-3624	76015-3625
		76015-3632	76015-3633	76015-3634	76015-3635
		76015-3642	76015-3643	76015-3644	76015-3645
		76015-3652	76015-3653	76015-3654	76015-3655
		76015-3662	76015-3663	76015-3664	76015-3665
76015-3672	76015-3673	76015-3674	76015-3675		
76015-3682	76015-3683	76015-3684	76015-3685		
Guide Right	6	76015-4602	76015-4603	76015-4604	76015-4605
		76015-4612	76015-4613	76015-4614	76015-4615
		76015-4622	76015-4623	76015-4624	76015-4625
		76015-4632	76015-4633	76015-4634	76015-4635

76015 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Guide Right	6	76015-4642	76015-4643	76015-4644	76015-4645
		76015-4652	76015-4653	76015-4654	76015-4655
		76015-4662	76015-4663	76015-4664	76015-4665
		76015-4672	76015-4673	76015-4674	76015-4675
		76015-4682	76015-4683	76015-4684	76015-4685
		76015-5602	76015-5603	76015-5604	76015-5605
		76015-5612	76015-5613	76015-5614	76015-5615
		76015-5622	76015-5623	76015-5624	76015-5625
		76015-5632	76015-5633	76015-5634	76015-5635
		76015-5642	76015-5643	76015-5644	76015-5645
		76015-5652	76015-5653	76015-5654	76015-5655
		76015-5662	76015-5663	76015-5664	76015-5665
		76015-5672	76015-5673	76015-5674	76015-5675
		76015-5682	76015-5683	76015-5684	76015-5685
		Guide Left With End Wall	6	76015-6602	76015-6603
76015-6612	76015-6613			76015-6614	76015-6615
76015-6622	76015-6623			76015-6624	76015-6625
76015-6632	76015-6633			76015-6634	76015-6635
76015-6642	76015-6643			76015-6644	76015-6645
76015-6652	76015-6653			76015-6654	76015-6655
76015-6662	76015-6663			76015-6664	76015-6665
76015-6672	76015-6673			76015-6674	76015-6675
76015-6682	76015-6683			76015-6684	76015-6685
76015-7602	76015-7603			76015-7604	76015-7605
76015-7612	76015-7613			76015-7614	76015-7615
76015-7622	76015-7623			76015-7624	76015-7625
76015-7632	76015-7633			76015-7634	76015-7635
76015-7642	76015-7643			76015-7644	76015-7645
76015-7652	76015-7653			76015-7654	76015-7655
76015-7662	76015-7663	76015-7664	76015-7665		
76015-7672	76015-7673	76015-7674	76015-7675		
76015-7682	76015-7683	76015-7684	76015-7685		
Guide Right With End Wall	6	76015-8602	76015-8603	76015-8604	76015-8605
		76015-8612	76015-8613	76015-8614	76015-8615
		76015-8622	76015-8623	76015-8624	76015-8625
		76015-8632	76015-8633	76015-8634	76015-8635
		76015-8642	76015-8643	76015-8644	76015-8645
		76015-8652	76015-8653	76015-8654	76015-8655
		76015-8662	76015-8663	76015-8664	76015-8665
		76015-8672	76015-8673	76015-8674	76015-8675
		76015-8682	76015-8683	76015-8684	76015-8685
		76015-9602	76015-9603	76015-9604	76015-9605
		76015-9612	76015-9613	76015-9614	76015-9615
		76015-9622	76015-9623	76015-9624	76015-9625
		76015-9632	76015-9633	76015-9634	76015-9635
		76015-9642	76015-9643	76015-9644	76015-9645
		76015-9652	76015-9653	76015-9654	76015-9655
76015-9662	76015-9663	76015-9664	76015-9665		
76015-9672	76015-9673	76015-9674	76015-9675		
76015-9682	76015-9683	76015-9684	76015-9685		

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 rail (ordered separately). See Figure 1.

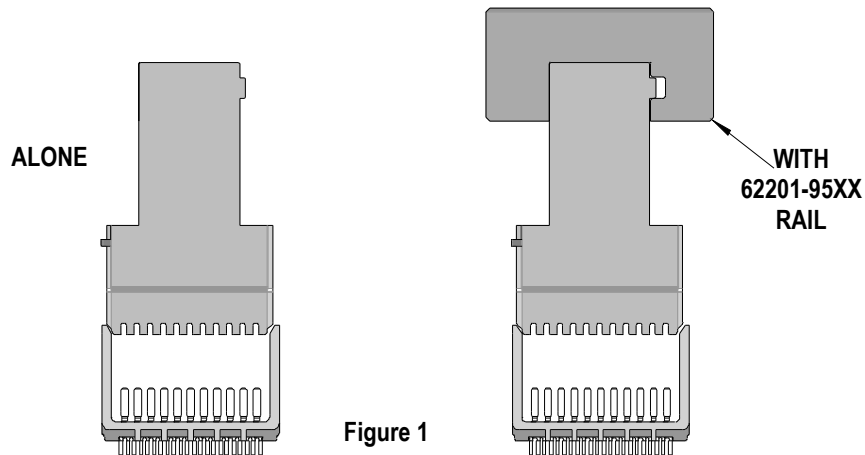


Figure 1

Tool Installation

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

Rail 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 22.2mm (0.87 in.) long.

Printed Circuit Board (PCB) Support

The I-Trac™ connectors require up to 1.81kg (4 lb) 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 I-Trac™ 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 by confirming the location of the #1 circuit notch with respect to the PCB layout.
2. Insert the application tool into the header assembly with the orientation peg on the tool entering the #1 circuit notch at the top of the connector housing. See Figure 2.

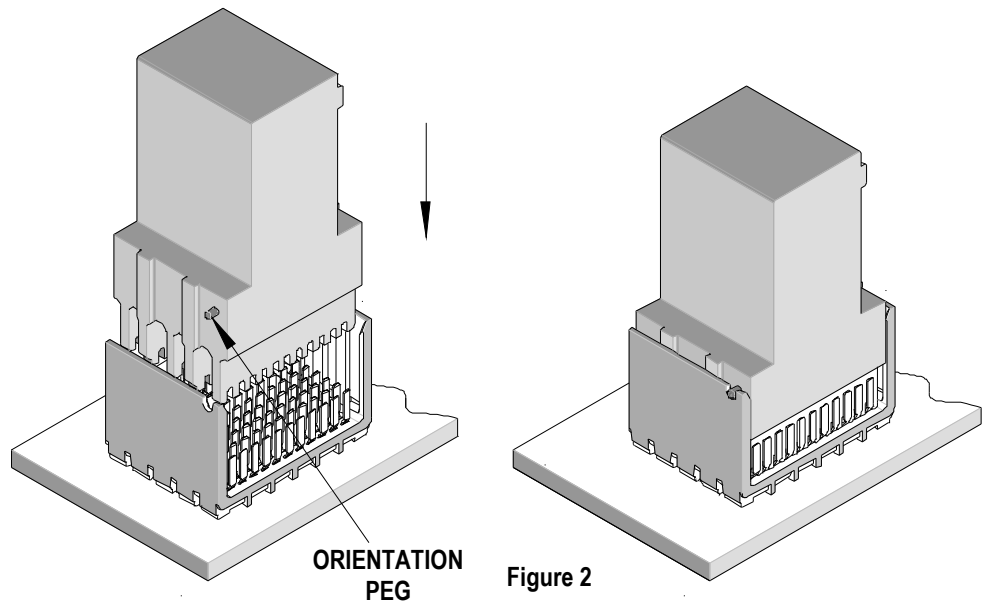


Figure 2

3. Using the application tool and an appropriate press, seat the header assembly until there is less than 0.10mm (.004 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.

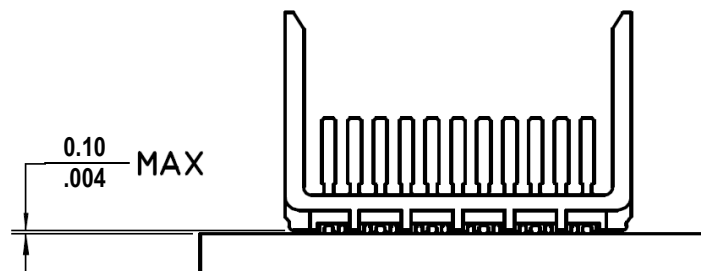


Figure 3

There should be no broken stand-offs along the perimeter of the part (an indication of over-pressing).

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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>