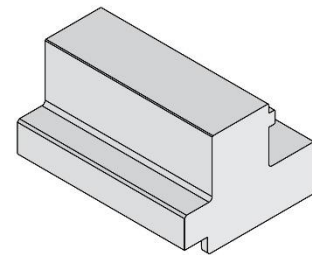


Order Number
62201-9004



Application Tooling Specification

FEATURES

- Lip provided for positive alignment to connector assembly
- 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 insertion tools
- Use this tool with guided Impel assemblies
- Use tool 62201-8923 for unguided Impel assemblies

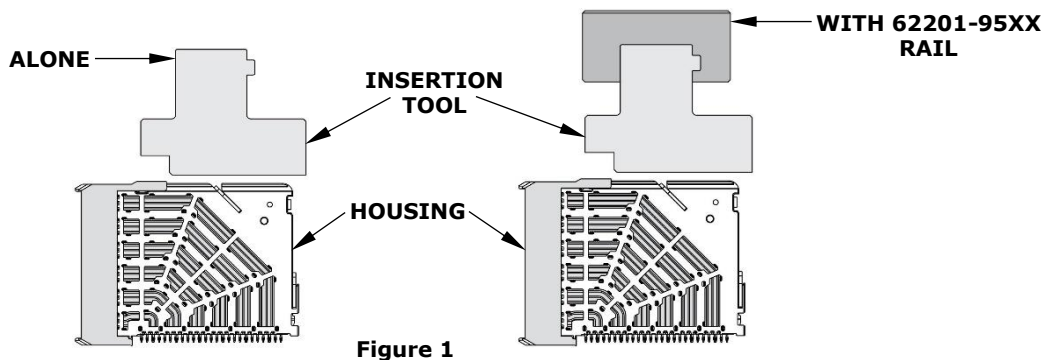
SCOPE

Products: Impel 1.9mm Pitch Daughtercard Module Assembly (6-Pair by 16-Column Guided Assemblies).

Series No.	Guide Style	Columns	Assembly Order Number					
171400	Left	16	171400-3026	171400-3126	171400-3226	171400-3326	171400-3426	171400-3526
			171400-3626	171400-3726	171400-3826			
	Right	16	171400-5026	171400-5126	171400-5226	171400-5326	171400-5426	171400-5526
			171400-5626	171400-5726	171400-5826			

TOOL SETUP

Depending on the number of connectors to be installed or the press used, this tool can be used alone or with a group of insertion tools, mounted in a 62201-95XX rail (ordered separately). See Figure 1.



TOOL INSTALLATION

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

Rail Part Number	Rail Overall Length
62201-9501	24mm (0.94")
62201-9502	72mm (2.83")
62201-9503	156mm (6.14")
62201-9504	216mm (8.50")
62201-9509	254mm (10.0")
62201-9511	305mm (12.0")

Reference: This insertion tool is 41.6mm (1.64") long.

PRINTED CIRCUIT BOARD (PCB) SUPPORT

The Impel connectors require up to 3.6kg (8 lb.) of force per pin to insert into the PCB. To prevent excessive PCB flexure 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. Customers must furnish their own support plates.

When creating the PCB support plate, remember to allow clearance for the connector pins as they pass through the PCB thickness.

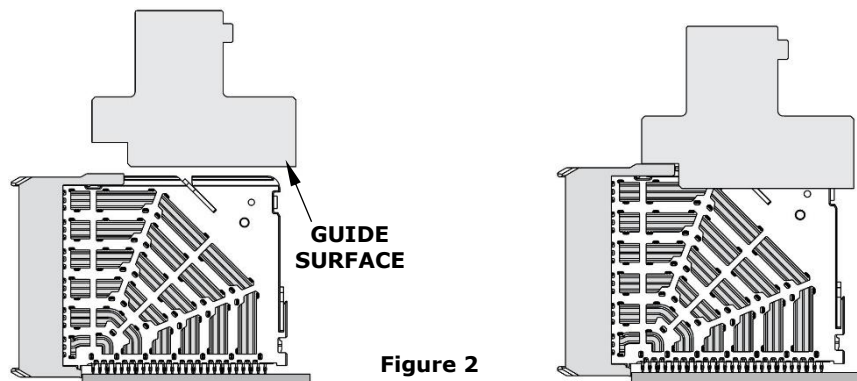
PRESS EQUIPMENT RECOMMENDATIONS

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

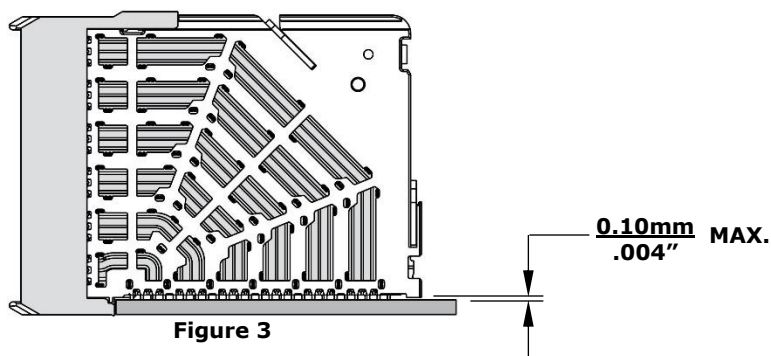
1. Presses should have the capability to detect force variations as low as 4.5kg (10 lb.) during the insertion cycle; excessive force measurements should stop the insertion cycle.
2. The rate of pressing can be regulated as low as 0.13mm (.005") per second.
3. Press stroke control should be within 0.25mm (.010").
4. The total press stroke must be at least 19mm (.750").
5. For statistical purposes, presses should automatically collect force and distance data.

OPERATION

1. By hand, carefully insert the Daughtercard module into the PCB hole pattern.
2. Place the application tool on top of the Daughtercard module so that the back guide surface of the inside of the tool rests against the back of the Daughtercard module. See Figure 2.



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



There should be no broken standoffs along the perimeter of the part (an indication of overpressing).

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.

Application Tooling Support

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