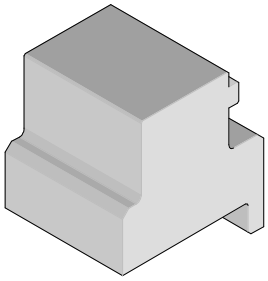
I-Trac™ Daughtercard Module and RAM Installation Application Tooling Specification Press-In Tool Order No. 62201-8606



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 press-in tools.

SCOPE

Products: I-Trac™ Daughtercard Signal Module Assembly, 75710 Series 10 Column Assemblies, and I-Trac™ RAM, 75910 Series 10 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.

75710 Series Numbers							
Guide Style	**Columns**	**Assembly Order Number**					
Open	10	75710-0010	75710-1010				
Guide Left	10	75710-2010	75710-2110	75710-2210	75710-2310	75710-2410	75710-2510
		75710-2610	75710-2710	75710-2810	75710-3010	75710-3110	75710-3210
		75710-3310	75710-3410	75710-3510	75710-3610	75710-3710	75710-3810
Guide Right	10	75710-4010	75710-4110	75710-4210	75710-4310	75710-4410	75710-4510
		75710-4610	75710-4710	75710-4810	75710-5010	75710-5110	75710-5210
		75710-5310	75710-5410	75710-5510	75710-5610	75710-5710	75710-5810

75910 Series Numbers							
Guide Style	**Columns**	**Assembly Order Number**					
Open	10	75910-0103	75910-0105	75910-0106	75910-1103	75910-1105	75910-1106
Left End Wall	10	75910-0113	75910-0115	75910-0116	75910-1113	75910-1115	75910-1116
Right End Wall	10	75910-0123	75910-0125	75910-0126	75910-1123	75910-1125	75910-1126
Dual End Wall	10	75910-0133	75910-0135	75910-0136	75910-1133	75910-1135	75910-1136
Guide Left	10	75910-2123	75910-2125	75910-2126	75910-2133	75910-2135	75910-2136
		75910-3123	75910-3125	75910-3126	75910-3133	75910-3135	75910-3136
		75910-6123	75910-6125	75910-6126	75910-6133	75910-6135	75910-6136
		75910-7123	75910-7125	75910-7126	75910-7133	75910-7135	75910-7136
Guide Right	10	75910-4123	75910-4125	75910-4126	75910-4133	75910-4135	75910-4136
		75910-5123	75910-5125	75910-5126	75910-5133	75910-5135	75910-5136
		75910-8123	75910-8125	75910-8126	75910-8133	75910-8135	75910-8136
		75910-9123	75910-9125	75910-9126	75910-9133	75910-9135	75910-9136

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.

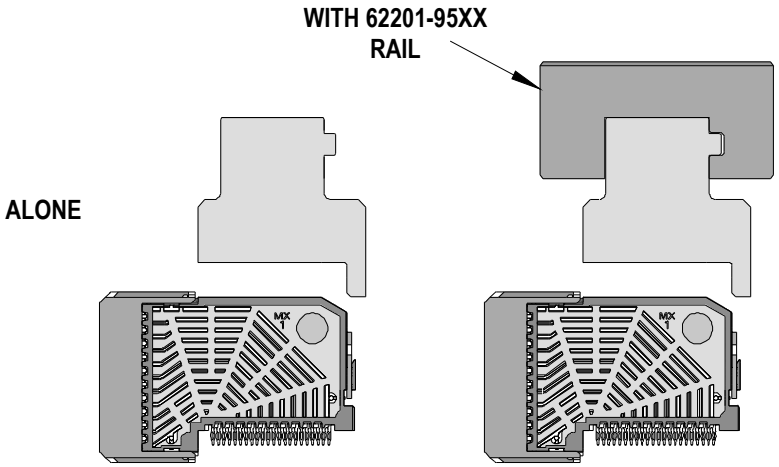


Figure 1

Tool Installation continued

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 36.9mm (1.45 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 Daughtercard and / or RAM module(s) into the PCB hole pattern.
2. Place the application tool on top of the module with the back guide surface of the tool against the back of the module. See Figure 2.

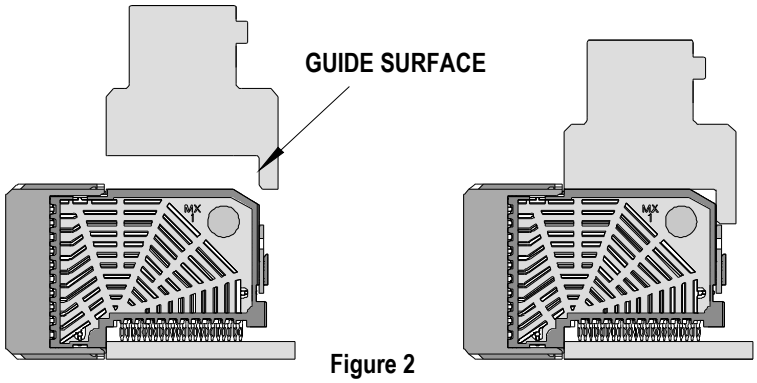


Figure 2

3. Using the application tool and an appropriate press, seat the module 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.

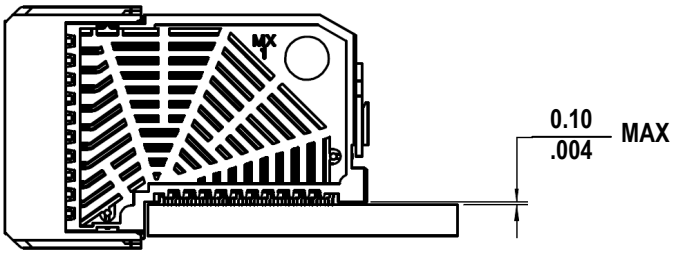


Figure 3
(Daughtercard shown; same dimensions for RAM)

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.

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