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Press-In Tool for Impact™ Power Module Assembly

<b>Impact™ Vertical Power Module Installation Press-In Tool</b>	  <b>Application Tooling Specification Sheet</b>	  <b>Order No. 62201-8875</b>
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**FEATURES**

- Vertical Power Module must be installed separately
- Use as a stand-alone tool or mounted in an optional holder with other Molex press-in tools.
- Guide surface provided for positive alignment to connector assembly
- Tool provides uniform distribution of press force across entire pin array

**SCOPE**

Products: Impact™ Vertical Power Module Assembly, 5-Pair Assemblies. See Product List below for specific part numbers.

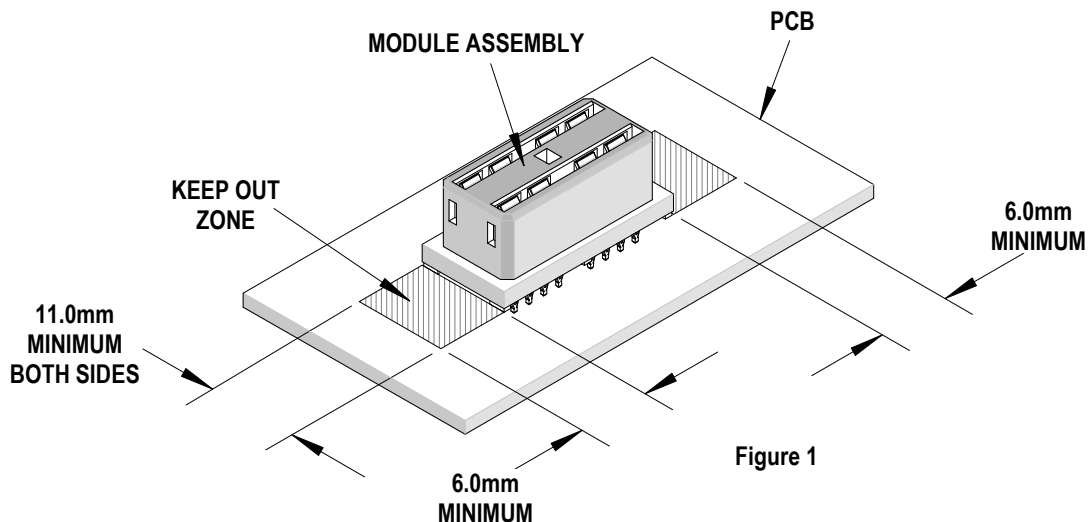
**Product List**

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](http://www.molex.com).

Vertical Power Module Series Number	Pair	Assembly Order Number	
78216	5	78216-1001	78216-5001
78662	5	78662-1001	78662-5001

**Tool Setup**

1. There is a “Keep-Out Zone” that needs to be clear of the other components when using some of the tool arrangements. See Figure 1. For more information see Molex drawing number SD-78216-002.



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### Printed Circuit Board (PCB) Support

The Impact™ connectors require up to 6.0kg (13.2 lbs) of force per pin to press into the PCB. To prevent flexing or damage to the PCB, a support plate is strongly recommended directly beneath the connector terminal hole pattern.

Due to the custom nature of every application, a board support is required for proper tool application. This can be supplied by the customer or by Molex. For more information contact Molex Application Tooling.

When creating a PCB support plate, allow clearance for connector terminal pins that pass through the PCB.

### Press Equipment Recommendations

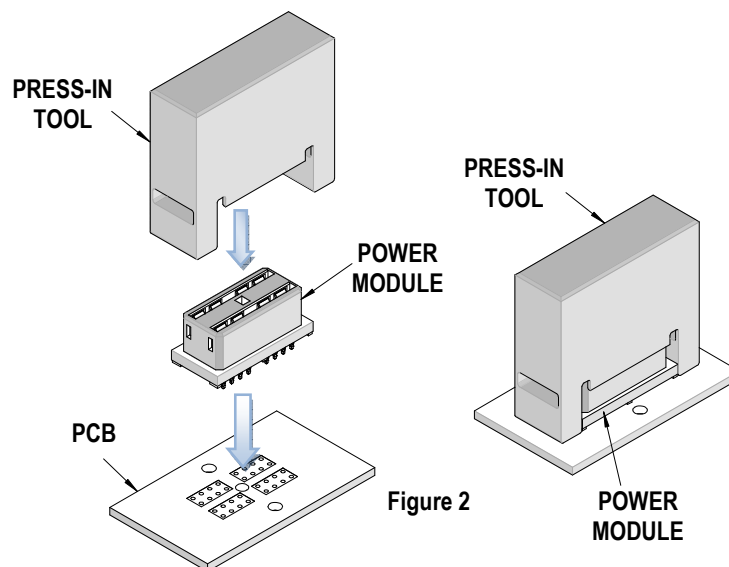
Many types of presses can be used to install Impact™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

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.

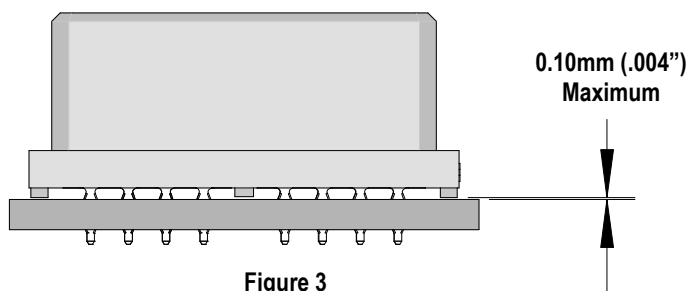
### Tool Operation

Reference: This Press-In Tool is 11.0mm (0.43 in.) wide x 33.90 (1.33 in.) long.

1. Carefully insert, by hand, the vertical power module(s) into the PCB hole pattern. Make sure the connector(s) are oriented properly to the PCB layout.
2. Line-up the Press-In tool so that the guide surfaces on the tool are in line with the sides of the vertical power module. See Figure 2.



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**Figure 3**

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

**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.

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