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Impact™ Daughtercard Press-In Tool

Impact™ Daughtercard Module Installation Press-In Tool		
	Application Tooling Specification Sheet	Order No. 62201-8778

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: Impact™ 100Ω Daughtercard Right Angle Signal Module Assembly and Impact™ RAM Signal Module Assembly, (2-Pair by 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.

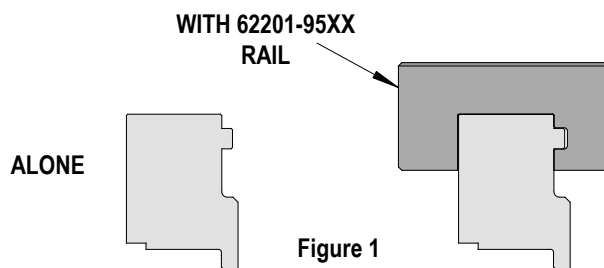
Series No.	Guide Style	Columns	Assembly Order Number					
76450 100Ω	Open	10	76450-0104	76450-0105	76450-0107	76450-0108	76450-1104	76450-1105
			76450-1107	76450-1108				
	Left	10	76450-0114	76450-0115	76450-0117	76450-0118	76450-1114	76450-1115
			76450-1117	76450-1118				
	Dual	10	76450-0124	76450-0125	76450-0127	76450-0128	76450-1124	76450-1125
			76450-1127	76450-1128				
	Right	10	76450-0134	76450-0135	76450-0137	76450-0138	76450-1134	76450-1135
			76450-1137	76450-1138				
	Left Guided	10	76450-2104	76450-2105	76450-2107	76450-2108	76450-3104	76450-3105
			76450-3107	76450-3108	76450-6104	76450-6105	76450-6107	76450-6108
			76450-7104	76450-7105	76450-7107	76450-7108		
	Right Guided	10	76450-4104	76450-4105	76450-4107	76450-4108	76450-5104	76450-5105
			76450-5107	76450-5108	76450-8104	76450-8105	76450-8107	76450-8108
			76450-9104	76450-9105	76450-9107	76450-9108		
76460 100Ω	Open	10	76460-0010	76460-0020	76460-1010	76460-1020		
	Left	10	76460-2010	76460-2020	76460-3010	76460-3020		
	Right	10	76460-4010	76460-4020	76460-5010	76460-5020		
170470	Open	10	170470-1104	170470-1105	170470-1107	170470-1108		
	Dual	10	170470-1124	170470-1125	170470-1127	170470-1128		
	Left	10	170470-1114	170470-1115	170470-1117	170470-1118		
	Right	10	170470-1134	170470-1135	170470-1137	170470-1138		
	Left Guided	10	170470-3104	170470-3105	170470-3107	170470-3108		
			170470-7104	170470-7105	170470-7107	170470-7108		
	Right Guided	10	170470-5104	170470-5105	170470-5107	170470-5108		
170470-9104			170470-9105	170470-9107	170470-9108			

Impact™ Daughtercard Press-In Tool

Series No.	Guide Style	Columns	Assembly Order Number					
170026 Ram	Custom	10	170026-0001	170026-2100	170026-2101	170026-3100	170026-3101	170026-6100
			170026-6101	170026-7100	170026-7101	170026-9001	170026-9002	170026-9963
			170026-9964	170026-9971	170026-9972	170026-9974	170026-9978	170026-9979
			170026-9981	170026-9982	170026-9983	170026-9984	170026-9998	170026-9999
172101 Ram	Open	10	172101-1010	172101-1020				
	Left	10	172101-3010	172101-3020				
	Right	10	172101-5010	172101-5020				
	Custom	10	172101-0005	172101-0006				

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.



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 18.9mm (0.744 in.) long.

Printed Circuit Board (PCB) Support

The Impact™ connectors require up to 3.6kg (8 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 Impact™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

Impact™ Daughtercard Press-In Tool

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 module(s) into the PCB hole pattern.
2. Place the application tool on top of the Daughtercard module with the back guide surface of the tool 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 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.

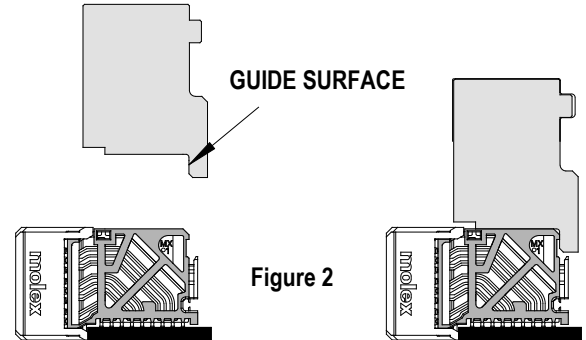


Figure 2

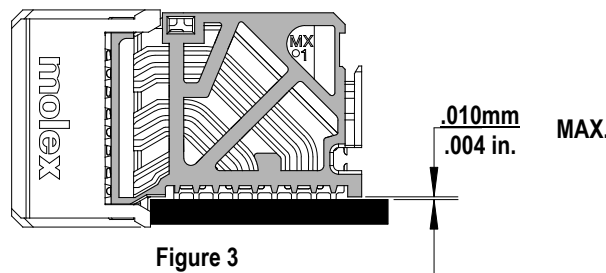


Figure 3

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.

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