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Press-In Tool for Impact™ Signal Module Assembly

Impact™ Vertical Mezzanine Signal Module Installation Press-In Tool	 Application Tooling Specification Sheet	 Order No. 62201-8860
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FEATURES

- 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 Mezzanine Signal Module Assembly, 5-Pair by 12 Column Assemblies. See Product List below for specific part numbers.

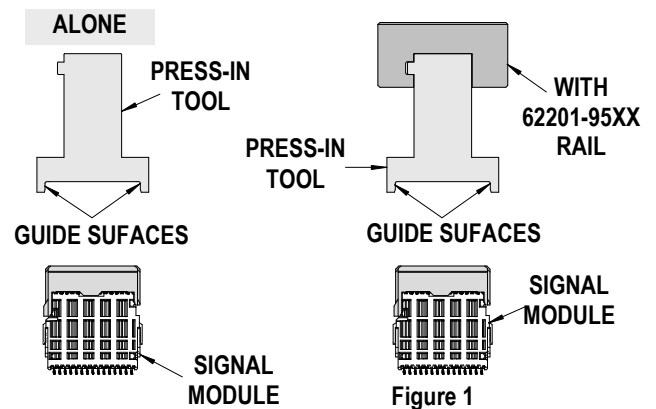
Product List

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	Guide Style	Columns	5 Pair Assembly Order Number					
76530	Open	12	76530-0022	76530-0032	76530-0042	76530-1022	76530-1032	76530-1042
	Left	12	76530-2032	76530-2042	76530-2132	76530-2142	76530-2232	76530-2242
			76530-2332	76530-2342	76530-2432	76530-2442	76530-2532	76530-2542
			76530-2632	76530-2642	76530-2732	76530-2742	76530-2832	76530-2842
			76530-3032	76530-3042	76530-3132	76530-3142	76530-3232	76530-3242
			76530-3332	76530-3342	76530-3432	76530-3442	76530-3532	76530-3542
			76530-3632	76530-3642	76530-3732	76530-3742	76530-3832	76530-3842
	Right	12	76530-4032	76530-4042	76530-4132	76530-4142	76530-4232	76530-4242
			76530-4332	76530-4342	76530-4432	76530-4442	76530-4532	76530-4542
			76530-4632	76530-4642	76530-4732	76530-4742	76530-4832	76530-4842
			76530-5032	76530-5042	76530-5132	76530-5142	76530-5232	76530-5242
			76530-5332	76530-5342	76530-5432	76530-5442	76530-5532	76530-5542
			76530-5632	76530-5642	76530-5732	76530-5742	76530-5832	76530-5842

Tool Setup

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



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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 22.8mm (.898 in.) wide x 27.30mm (1.07 in.) long.

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

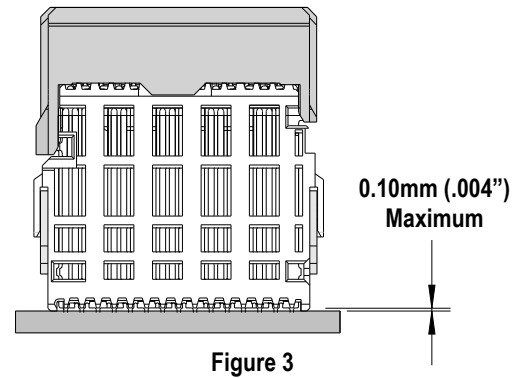
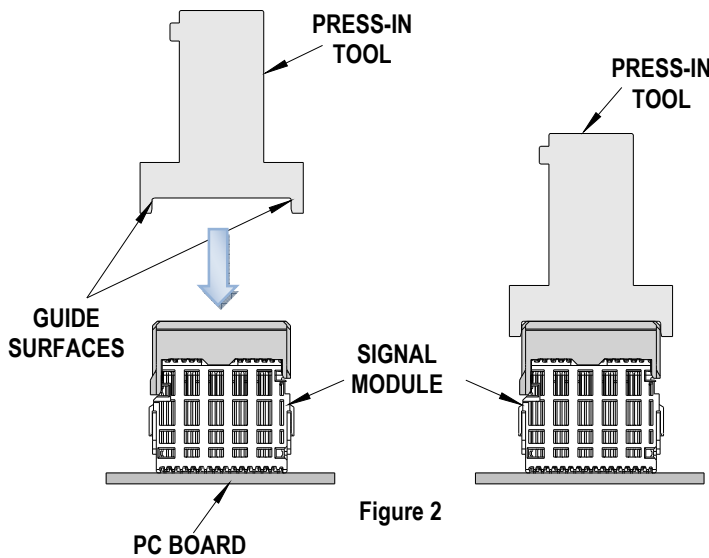
Many types of presses can be used to install Impact™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

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.

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Tool Operation

1. Carefully insert, by hand, the vertical Signal 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 Signal module. See Figure 2.



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