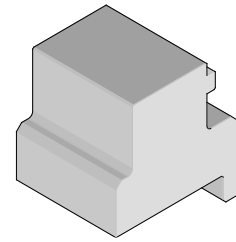


**Impact™  
Daughtercard  
Module Installation  
Press-In Tool**

**molex®**

**Application Tooling  
Specification Sheet**



**Order No. 62201-8735**

**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™ Daughtercard Signal Module Assembly and Daughtercard Orthogonal 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](http://www.molex.com).

Series No.	Guide Style	Columns	5 Pair Assembly Order Number					
76060	Open	12	76060-0012	76060-1012	76060-0022	76060-1022		
	Left	12	76060-2012	76060-2022	76060-2052	76060-2062	76060-2112	76060-2122
			76060-2152	76060-2162	76060-2212	76060-2222	76060-2252	76060-2262
			76060-2312	76060-2322	76060-2352	76060-2362	76060-2412	76060-2422
			76060-2452	76060-2462	76060-2512	76060-2522	76060-2552	76060-2562
			76060-2612	76060-2622	76060-2652	76060-2662	76060-2712	76060-2722
			76060-2752	76060-2762	76060-2812	76060-2822	76060-2852	76060-2862
			76060-3012	76060-3022	76060-3052	76060-3062	76060-3112	76060-3122
			76060-3152	76060-3162	76060-3212	76060-3222	76060-3252	76060-3262
			76060-3312	76060-3322	76060-3352	76060-3362	76060-3412	76060-3422
			76060-3452	76060-3462	76060-3512	76060-3522	76060-3552	76060-3562
			76060-3612	76060-3622	76060-3652	76060-3662	76060-3712	76060-3722
			76060-3752	76060-3762	76060-3812	76060-3822	76060-3852	76060-3862
			76060-9001					
	Right	12	76060-4012	76060-4022	76060-4052	76060-4062	76060-4112	76060-4122
			76060-4152	76060-4162	76060-4212	76060-4222	76060-4252	76060-4262
			76060-4312	76060-4322	76060-4352	76060-4362	76060-4412	76060-4422
			76060-4452	76060-4462	76060-4512	76060-4522	76060-4552	76060-4562
			76060-4612	76060-4622	76060-4652	76060-4662	76060-4712	76060-4722
			76060-4752	76060-4762	76060-4812	76060-4822	76060-4852	76060-4862
			76060-5012	76060-5022	76060-5052	76060-5062	76060-5112	76060-5122
			76060-5152	76060-5162	76060-5212	76060-5222	76060-5252	76060-5262
			76060-5312	76060-5322	76060-5352	76060-5362	76060-5412	76060-5422
			76060-5452	76060-5462	76060-5512	76060-5522	76060-5552	76060-5562
			76060-5612	76060-5622	76060-5652	76060-5662	76060-5712	76060-5722
			76060-5752	76060-5762	76060-5812	76060-5822	76060-5852	76060-5862
			76060-9002					

Series No.	Guide Style	Columns	5 Pair Assembly Order Number						
76990	Open	12	76990-0012	76990-0022	76990-1012	76990-1022			
	Left	12	76990-2012	76990-2022	76990-3012	76990-3022			
	Right	12	76990-4012	76990-4022	76990-5012	76990-5022			
170480	Open	12	170480-1012	170480-1022					
	Left	12	170480-3012	170480-3022	170480-3052	170480-3062	170480-3112	170480-3122	
			170480-3152	170480-3162	170480-3212	170480-3222	170480-3252	170480-3262	
			170480-3312	170480-3322	170480-3352	170480-3362	170480-3412	170480-3422	
			170480-3452	170480-3462	170480-3512	170480-3522	170480-3552	170480-3562	
			170480-3612	170480-3622	170480-3652	170480-3662	170480-3712	170480-3722	
			170480-3752	170480-3762	170480-3812	170480-3822	170480-3852	170480-3862	
	Right	12	170480-5012	170480-5022	170480-5052	170480-5062	170480-5112	170480-5122	
			170480-5152	170480-5162	170480-5212	170480-5222	170480-5252	170480-5262	
			170480-5312	170480-5322	170480-5352	170480-5362	170480-5412	170480-5422	
			170480-5452	170480-5462	170480-5512	170480-5522	170480-5552	170480-5562	
			170480-5612	170480-5622	170480-5652	170480-5662	170480-5712	170480-5722	
			170480-5752	170480-5762	170480-5812	170480-5822	170480-5852	170480-5862	
	172104	Unguided	12	172104-1012	172104-1022				
		Left	12	172104-3012	172104-3022	172104-3112	172104-3122	172104-3212	172104-3222
172104-3312				172104-3322	172104-3412	172104-3422	172104-3512	172104-3522	
172104-3612				172104-3622	172104-3712	172104-3722	172104-3812	172104-3822	
Right		12	172104-5012	172104-5022	172104-5112	172104-5122	172104-5212	172104-5222	
			172104-5312	172104-5322	172104-5412	172104-5422	172104-5512	172104-5522	
			172104-5612	172104-5622	172104-5712	172104-5722	172104-5812	172104-5822	

### 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)

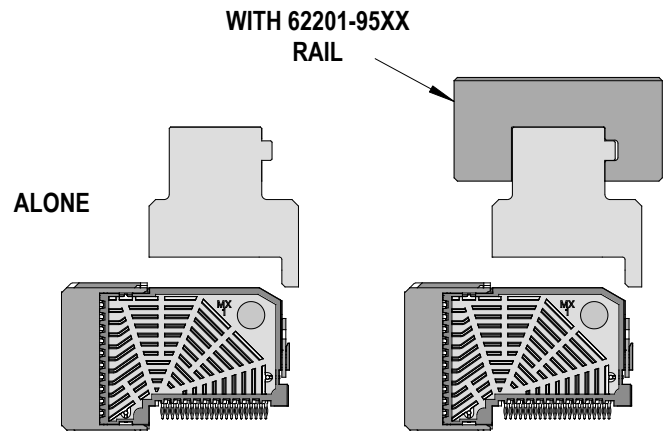


Figure 1

Reference: This Press-In Tool is 22.7mm (0.89 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:

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.

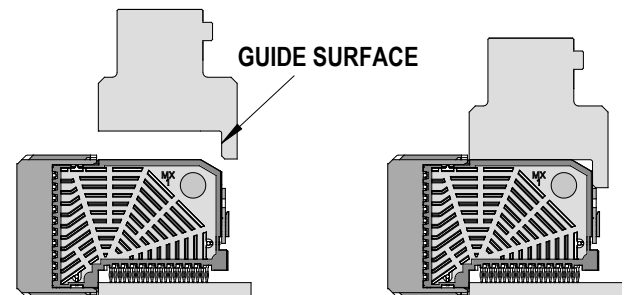


Figure 2

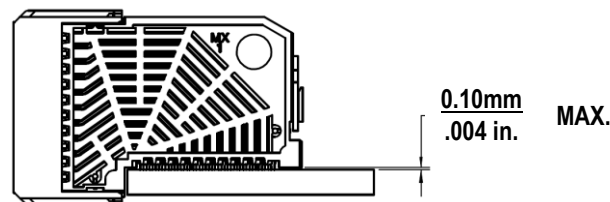


Figure 3

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