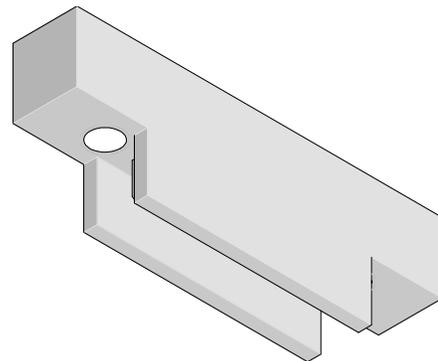




**SCA-2
Press-Fit Receptacle (40 Circuit)
Upper Alignment Tool
Order No. 62100-2502**



FEATURES

- This tool is intended to insert the SCA-2 Press-Fit Receptacle.
- For lower alignment tooling (PCB support), see Molex part number 62100-2501.

SCOPE

Products: 1.27mm (.050") Pitch SCA-2 Receptacle, Press-Fit Assembly, 73826 Series (40 Circuits)
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.	Assembly Order Number		
73826	73826-0002	73826-0004	73826-5004

Tool Setup

1. Mounting holes (M5 threaded) are provided in the tool for attachment to a (customer-provided) tooling plate. For mounting dimensions, see Figure 1.
2. The Upper Alignment Tool must be mounted such that it is central to the receptacle.
3. The tooling plate must be of sufficient thickness to support the maximum insertion force for this connector, approximately 600 lbs (270 kg).

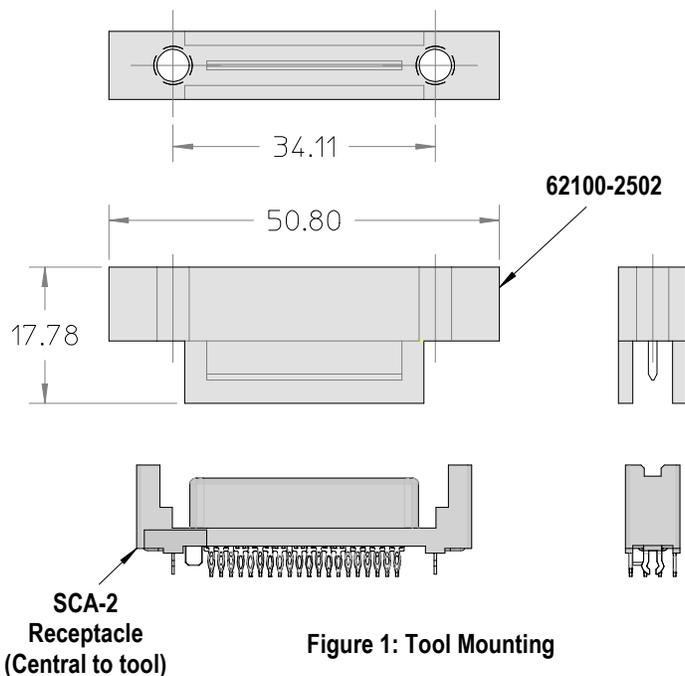


Figure 1: Tool Mounting

Tool Operation

1. Position the PCB above the Lower Alignment Tool (62100-2501); ensuring the tool does not block any of the holes in the PCB.
2. Place the SCA-2 Receptacle in the PCB hole pattern by hand. Make sure all pins have entered the holes.
3. Using the Upper Alignment Tool and a suitable press, insert the receptacle in the PCB until there is less than 0.005" (0.13mm) clearance between the bottom of the receptacle housing and the surface of the PCB. See Figure 2.

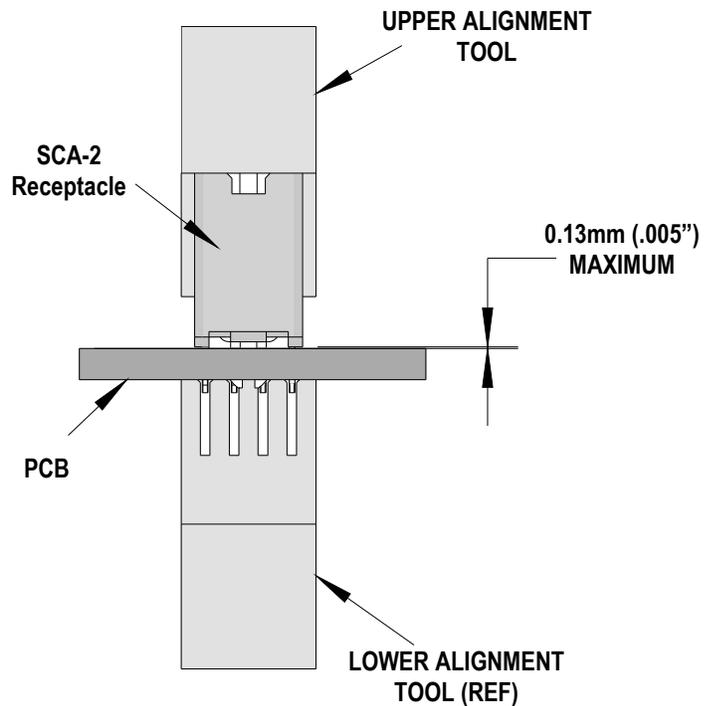


Figure 2: INSERTION DETAILS

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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