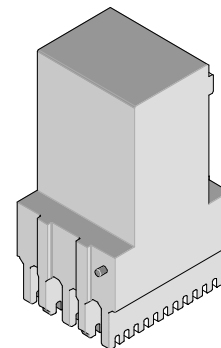




**I-Trac™ Backplane Module Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8617**



FEATURES

- Polarized tool prevents product damage.
- 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: I-Trac™ Backplane Signal Module Assembly, 75705 Series 8 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.

75705 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	8	75705-0802	75705-0803	75705-0804	75705-0805
Left End Wall		75705-0812	75705-0813	75705-0814	75705-0815
Dual End Wall		75705-0822	75705-0823	75705-0824	75705-0825
Right End Wall		75705-0832	75705-0833	75705-0834	75705-0835
Open		75705-1802	75705-1803	75705-1804	75705-1805
Left End Wall		75705-1812	75705-1813	75705-1814	75705-1815
Dual End Wall		75705-1822	75705-1823	75705-1824	75705-1825
Right End Wall		75705-1832	75705-1833	75705-1834	75705-1835
Guide Left	8	75705-2802	75705-2803	75705-2804	75705-2805
		75705-2812	75705-2813	75705-2814	75705-2815
		75705-2822	75705-2823	75705-2824	75705-2825
		75705-2832	75705-2833	75705-2834	75705-2835
		75705-2842	75705-2843	75705-2844	75705-2845
		75705-2852	75705-2853	75705-2854	75705-2855
		75705-2862	75705-2863	75705-2864	75705-2865
		75705-2872	75705-2873	75705-2874	75705-2875
		75705-2882	75705-2883	75705-2884	75705-2885
		75705-3802	75705-3803	75705-3804	75705-3805
		75705-3812	75705-3813	75705-3814	75705-3815
		75705-3822	75705-3823	75705-3824	75705-3825
		75705-3832	75705-3833	75705-3834	75705-3835
		75705-3842	75705-3843	75705-3844	75705-3845
		75705-3852	75705-3853	75705-3854	75705-3855
		75705-3862	75705-3863	75705-3864	75705-3865
75705-3872	75705-3873	75705-3874	75705-3875		
75705-3882	75705-3883	75705-3884	75705-3885		
Guide Right	8	75705-4802	75705-4803	75705-4804	75705-4805
		75705-4812	75705-4813	75705-4814	75705-4815
		75705-4822	75705-4823	75705-4824	75705-4825

75705 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Guide Right	8	75705-4832	75705-4833	75705-4834	75705-4835
		75705-4842	75705-4843	75705-4844	75705-4845
		75705-4852	75705-4853	75705-4854	75705-4855
		75705-4862	75705-4863	75705-4864	75705-4865
		75705-4872	75705-4873	75705-4874	75705-4875
		75705-4882	75705-4883	75705-4884	75705-4885
		75705-5802	75705-5803	75705-5804	75705-5805
		75705-5812	75705-5813	75705-5814	75705-5815
		75705-5822	75705-5823	75705-5824	75705-5825
		75705-5832	75705-5833	75705-5834	75705-5835
		75705-5842	75705-5843	75705-5844	75705-5845
		75705-5852	75705-5853	75705-5854	75705-5855
		75705-5862	75705-5863	75705-5864	75705-5865
		75705-5872	75705-5873	75705-5874	75705-5875
		75705-5882	75705-5883	75705-5884	75705-5885
		Guide Left With End Wall	8	75705-6802	75705-6803
75705-6812	75705-6813			75705-6814	75705-6815
75705-6822	75705-6823			75705-6824	75705-6825
75705-6832	75705-6833			75705-6834	75705-6835
75705-6842	75705-6843			75705-6844	75705-6845
75705-6852	75705-6853			75705-6854	75705-6855
75705-6862	75705-6863			75705-6864	75705-6865
75705-6872	75705-6873			75705-6874	75705-6875
75705-6882	75705-6883			75705-6884	75705-6885
75705-7802	75705-7803			75705-7804	75705-7805
75705-7812	75705-7813			75705-7814	75705-7815
75705-7822	75705-7823			75705-7824	75705-7825
75705-7832	75705-7833			75705-7834	75705-7835
75705-7842	75705-7843			75705-7844	75705-7845
75705-7852	75705-7853			75705-7854	75705-7855
75705-7862	75705-7863			75705-7864	75705-7865
75705-7872	75705-7873	75705-7874	75705-7875		
75705-7882	75705-7883	75705-7884	75705-7885		
Guide Right With End Wall	8	75705-8802	75705-8803	75705-8804	75705-8805
		75705-8812	75705-8813	75705-8814	75705-8815
		75705-8822	75705-8823	75705-8824	75705-8825
		75705-8832	75705-8833	75705-8834	75705-8835
		75705-8842	75705-8843	75705-8844	75705-8845
		75705-8852	75705-8853	75705-8854	75705-8855
		75705-8862	75705-8863	75705-8864	75705-8865
		75705-8872	75705-8873	75705-8874	75705-8875
		75705-8882	75705-8883	75705-8884	75705-8885
		75705-9802	75705-9803	75705-9804	75705-9805
		75705-9812	75705-9813	75705-9814	75705-9815
		75705-9822	75705-9823	75705-9824	75705-9825
		75705-9832	75705-9833	75705-9834	75705-9835
		75705-9842	75705-9843	75705-9844	75705-9845
		75705-9852	75705-9853	75705-9854	75705-9855
		75705-9862	75705-9863	75705-9864	75705-9865
75705-9872	75705-9873	75705-9874	75705-9875		
75705-9882	75705-9883	75705-9884	75705-9885		

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.

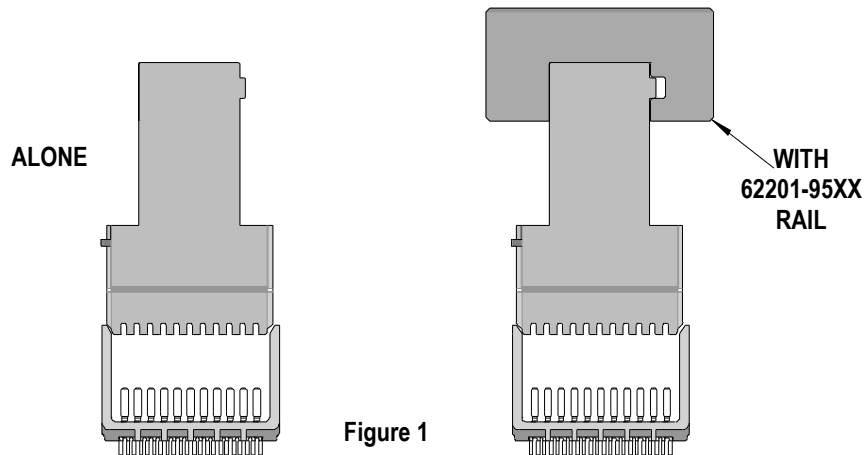


Figure 1

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 29.6mm (1.17 in.) long.

Printed Circuit Board (PCB) Support

The I-Trac™ connectors require up to 1.81kg (4 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.

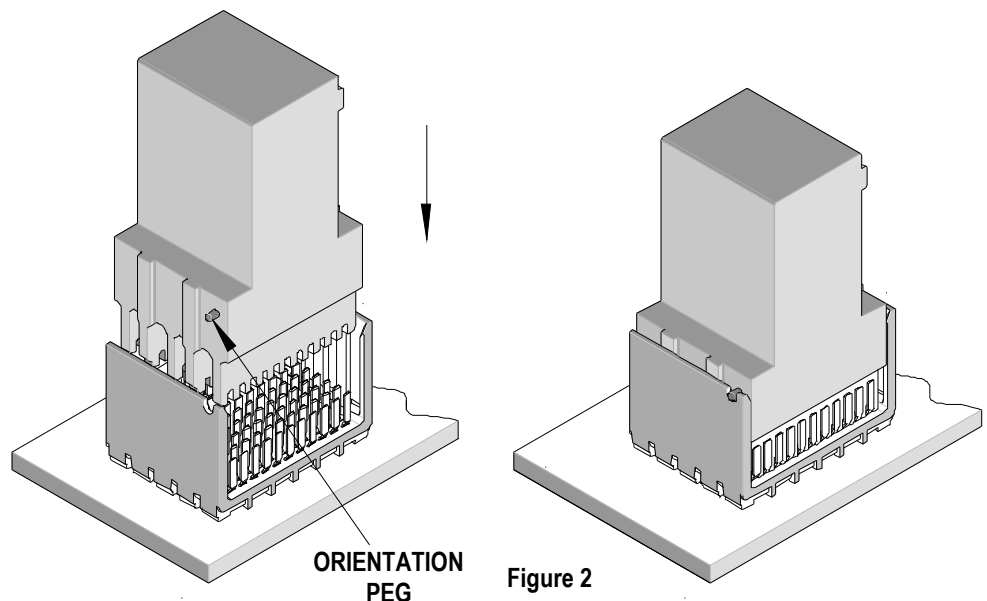
Press Equipment Recommendations

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

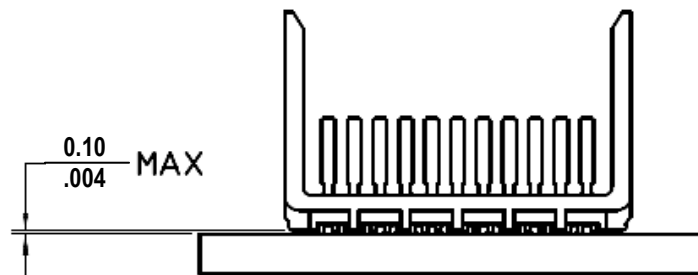
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press 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 backplane signal module(s) into the PCB hole pattern. Make sure the connector(s) are oriented properly by confirming the location of the #1 circuit notch with respect to the PCB layout.
2. Insert the application tool into the header assembly with the orientation peg on the tool entering the #1 circuit notch at the top of the connector housing. See Figure 2.



3. Using the application tool and an appropriate press, seat the header assembly 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.



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.

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