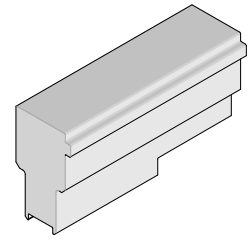


EdgeLine™
ESP
Press-In Tool



Application Tooling Specification Sheet



Order No. 62203-0301

FEATURES

- Lip provided for positive alignment to connector assembly.
- Tool provides uniform distribution of press force across entire connector.
- May be used as a stand-alone tool or mounted in an optional holder with other Molex press-in tools.
- Use tool 62100-6850 for removing 171852-1030

SCOPE

Products: EdgeLine™ ESP 50 AMPs Assemblies, 0.8mm Pitch for 0.093"PCB. See Product List below for specific application tools.

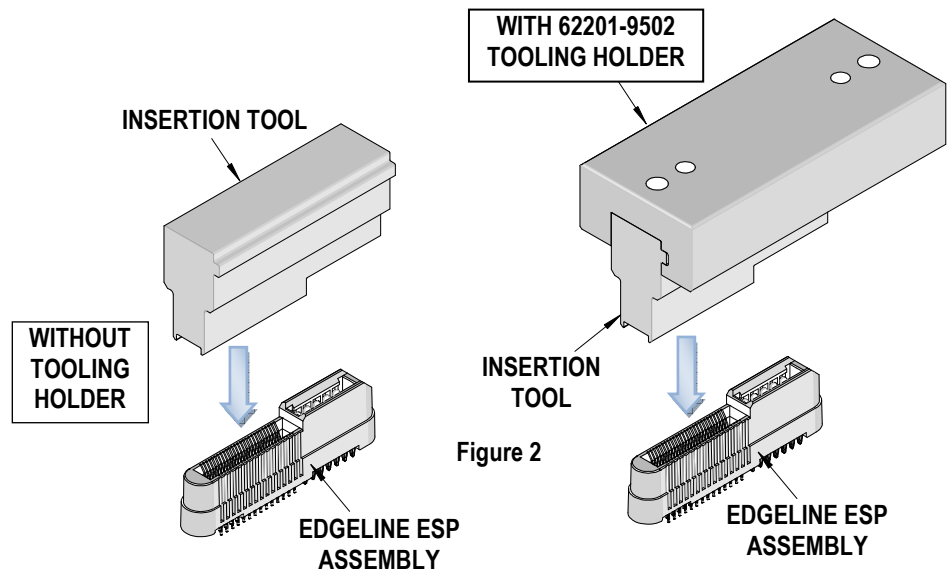
Product List

The following is a partial list of the product order numbers and their specifications that this tool is designed to run. Updates to this list are available on www.molex.com.

Description	Assembly Order Number			
EdgeLine™ ESP 50A	171852-1030	171852-7030	171852-7046	171852-7054

Tool Setup

The insertion tool can be mounted in a 62201-9502 tool holder rail (ordered separately). See Figure 2.



Recommended Tooling Holder	Tooling Holder Overall Length
62201-9502	72mm (2.83 in)

Reference: This tool Press-In Tool is 50mm (1.97 in.) long.

Printed Circuit Board (PCB) Support

The EdgeLine™ connector requires significant insertion 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 and guide connector pegs as they pass through the PCB thickness.

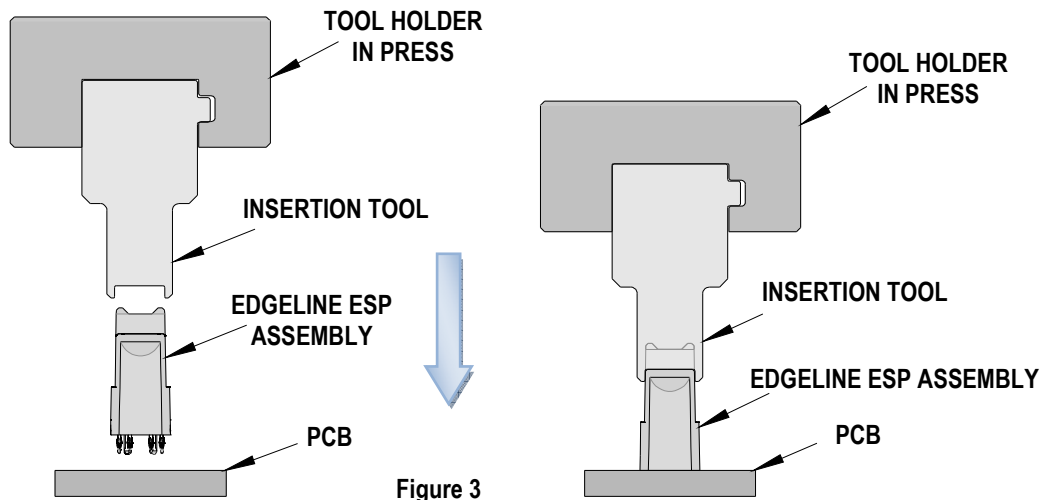
Press Equipment Recommendations

Many types of presses can be used to install 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 (0.005in) per second.
3. Press stroke control to within 0.25mm (0.010in).
4. Total press stroke must be at least 19mm (0.75in).
5. For statistical purposes, automatic collection of force and distance data.

Tool Operation

1. Carefully insert, by hand, the connector into the PCB hole pattern.
2. Place the insertion tool on top of power connector. The two side guide surfaces of the tool should be in line with the side walls of the connector. See Figure 3.
3. Using the insertion tool and an appropriate press, seat the power connector until the bottom of the plastic housing and the surface of the PCB is flush as shown below.



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>